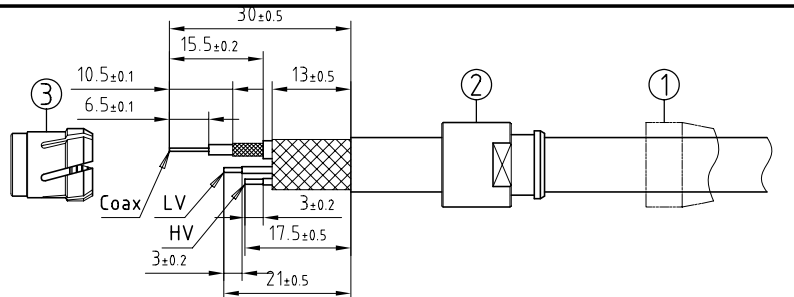
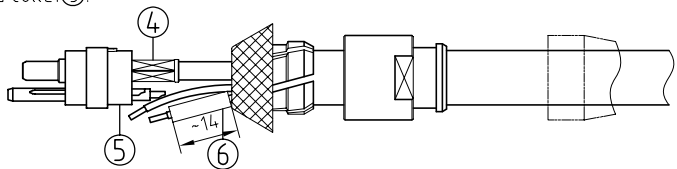


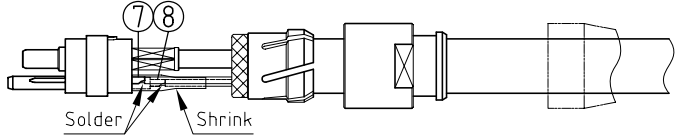
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulators	: PEEK	-
Male contact (LV)	: Brass (UNS C38500)	Gold plated (ISO 4523)
Female contact (HV)	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Heat shrink tubing	: Polyolefin	-
Label	: Polyester	Yellow
Bend relief	: Polyurethan	Various colors
<b>Coaxial contact subassembly :</b>		
Male sleeve	: Brass (UNS C38500)	Gold plated (ISO 4523)
Insulator	: PTFE	-
Male contact	: Brass (UNS C34500)	Gold plated (ISO 4523)
Crimping collet	: Brass (UNS C38500)	Gold plated (ISO 4523)
Other insulating part	: PTFE	-
Crimp ferrule	: Brass (UNS C34500)	Nickel plated (FS-QQ-N-290A)
Clip	: Cu-Be (UNS C17200)	-



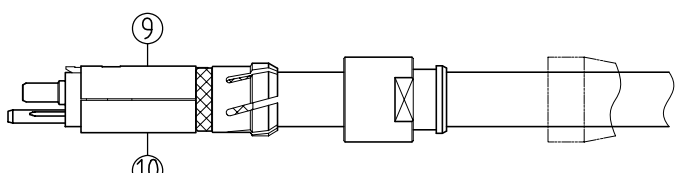
1. Strip the cable according to the given dimensions. Slide it into the strain relief ① collet nut ② and collet ③.



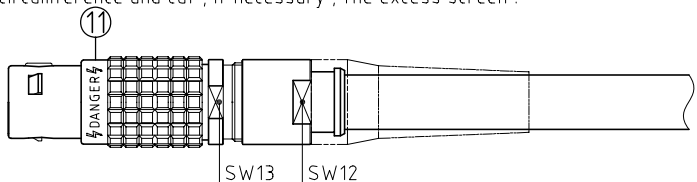
2. Mount the male coaxial contact ④ according to the separate instructions given beside, slide to the insulator ⑤ and they should remain in position when given a gentle pull to each conductor. In case of a screened cable, fold screen back over the extremity of the collet. Slide a piece of heat shrink tubing ⑥ (not supplied) of the correct length over the dielectric of (HV) cable.



3. Fit conductor into contact (LV) ⑦ and contact (HV) ⑧, and solder. Verify that insulator and insulation remain clean. Slide the heat shrink tubing over the contact insulating sleeve. With a heat gun fully shrink the tubing until full melting of the inner adhesive coating.

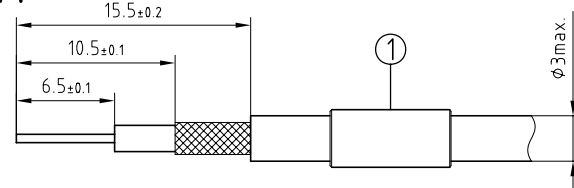


4. In case of a screened cable, check that the screen which is folded back the collet is clear of the keyway. Locate the upper half ⑨ of the split insert carrier over the shoulder and key on the insulator then align and press together the other half ⑩ to form a complete cylinder. Align the key of the insert carrier with the keyway in the collet and move them together whilst checking that the screen is being clamped around the whole circumference and cut, if necessary, the excess screen.

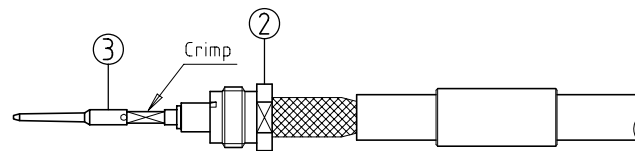


5. Next slide the plug shell ⑪ over the insulator assembly making sure that the key on the insert carrier goes into the appropriate keyway (under the color point) inside the shell. Ensure that the internal components do not rotate in the shell and finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 2.5Nm. Slide the bend relief onto the collet nut.

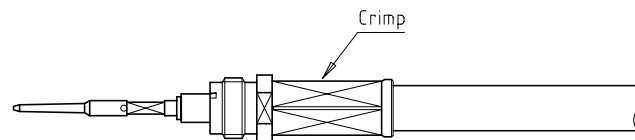
### Coaxial contact .



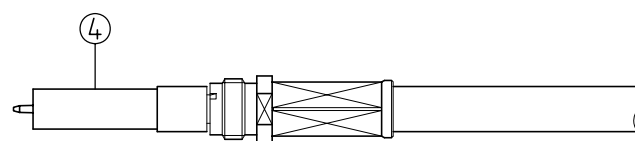
1. Slide the cable into the crimp ferrule ①. Strip according to the given dimensions.



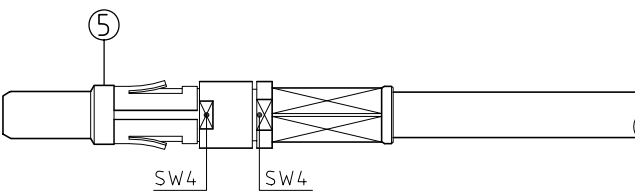
2. Winden the screen, slide the crimping collet ② fully onto the cable until the insulator touches the dielectric and one can see the conductor in the contact ③ hole. Crimp the contact with crimping tool.



3. Slide the crimp ferrule fully onto the screen until it touches the crimping collet. Crimp with crimping tool.

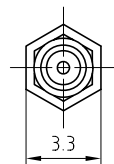


4. Slide the insulator ④ on the contact.



5. Screw the male sleeve ⑤ fitted with the clip onto the crimp backnut and tighten with the appropriate tool to the maximum torque value of 0,1Nm.

### Crimping dimension



Flat spanners set : DCP.91.023.TN  
Crimping tool with dies : DPE.99.103.8K  
Extractor : DCC.91.384.5LA

**Straight plug , with key (G) , with cable collet and nut for bend relief .  
Series 2B , 1coax50Ω(typeC) +1HV + 2LV(φ0,7)**

ETUDE N° E2844

Echelle	Dessiné	14.03.07	OVU / RMO
	Contrôle	27.03.07	RMO / CDE
	Modif.	01	27.03.07 / OVU