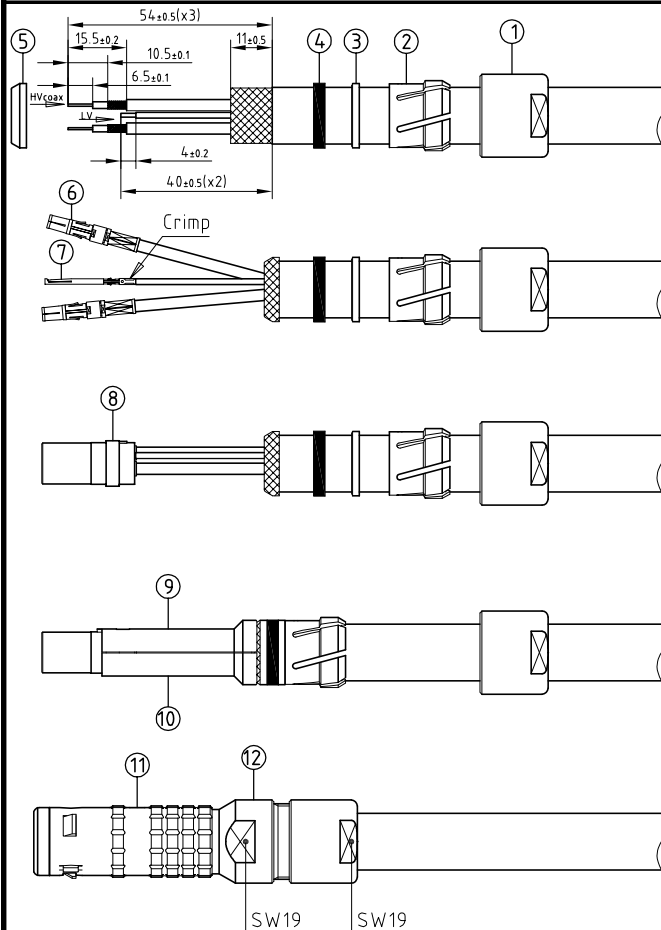


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Chrome plated (FS-QQ-C-320B)
Inner shell	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Oversize collet sleeve	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	-
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 27874)
Clip	: Cu-Be (UNS C17200)	-
Gland	: Silicone (SI)	-
Clip	: Bronze (UNS C54400)	Nickel plated (FS-QQ-N-290A)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
O-Ring	: Silicone (MVQ)	-
Female HV coaxial contact	: (PSS.2B.401.ZLME34)	(See customer drawing)



1. Strip the cable according to the given dimensions . (The end of the cable jacket must be cut properly) . Slide it into the collet nut①, the collet②, the ring③, the gland④ and the earthing cone⑤.
2. Mount the female coaxial contacts⑥ according to the separate instructions . In case of a screened cable , fold screen back over the extremity of the earthing cone . Fix the positioner on the crimping tool and set selector to the number corresponding to the conductor AWG as indicated on the positioner label . Fit conductor into the contacts⑦ and make sure it is visible through its inspection hole in the crimp barrel . Open crimping tool then push contact fully into positioner and complete one crimping cycle . Remove from crimping tool and check that conductor is secure in contact and shows in inspection hole .
3. Slide contact-conductor combinations according to the insulator⑧ marking avoiding twisting of the conductors . Fit the contacts gently into the insulator and verify that no conductors are crossed before pushing them in completely . Check that all contacts hold in the insulator by verifying their alignment at the front of the insulator and they should remain in position when each conductor is given a gentle pull .
4. Locate the slotted upper half⑨ 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 . Push the earthing cone against the insert carriers whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen . Push the gland , the ring and collet against the earthing cone . Push the cable forward and verify that cable jacket is located under the gland .
5. Next slide the plug shell ⑪ fitted with the oversize collet ⑫ over the insulator assembly making sure that the key on the insert carrier goes into the 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 5Nm .

Crimping tool	: DPC.91.701.V
Extractor	: DCF.91.093.5LT
Female contact	: EGG.3B.660.ZZM
Female positioner	: DCE.91.093.BVM
Female retention testing tool:	DCK.91.091.4LRM

Assembly plier : DPF.91.023.TA

Straight plug , with keys (L) , with cable collet , oversize and nut .

Series 3K , 3HVcoax + 2LV(φ0.9)

ETUDE N° E1696-E1461-E2032-E3248

Echelle	Dessiné	15.05.2017	OVU / JPBA
	Contrôle	15.05.2017	JPBA / ATVI
	Modif.	00	15.05.2017 / OVU



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