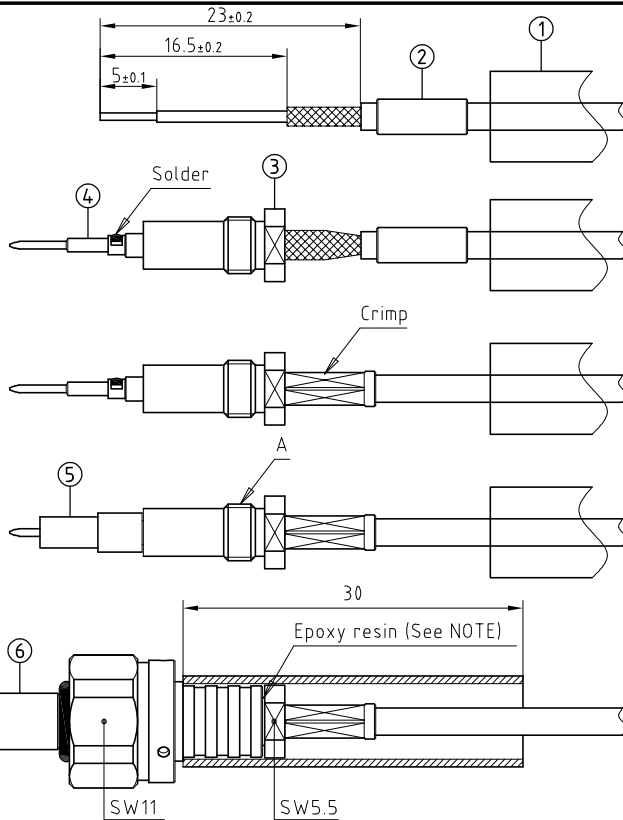


Outer shell	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Coupling nut	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Retaining ring	: Stainless steel (AISI301)	-
Insulator	: PEEK	-
Insulating sleeve	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Crimping collet	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
Crimp ferrule	: Copper (UNS C18700)	Nickel plated (FS-QQ-N-290A)
O-rings	: Viton (FPM)	-
Heat shrink tubing	: Polyolefin	Black

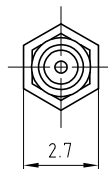


- Strip the cable according to the given dimensions. Slide into the cable the shrink tubing ① and the crimp ferrule ②.
- Widen the screen, slide the crimping collet ③ fully onto the cable until the insulator touches the dielectric and one can see the conductor in the contact ④ hole and solder.
- Slide the crimp ferrule fully onto the screen until it touches the crimping collet. Crimp with crimping tool.
- Slide the insulator ⑤ on the contact. Apply a small drop of thread lock (Loctite 270 or equivalent) on the screw ring thread A.
- Screw the outer shell ⑥ on the premounted cable and tighten with the appropriate tool to the maximum torque value of 0,25Nm. Slide the heat shrink tubing. With a heat gun fully shrink tubing until it retract.

NOTE : In order to guaranty performances under high pressure conditions, the space around the thread of the crimping collet nut must be filled with an epoxy resin before tightening.

Coupling nut torque 0.5Nm

Crimping dimension



Crimping tool with dies	: DPE.99.123.1K
Flat spanner	: DCP.99.055.TC
Flat spanners set	: DCP.0T.110.TN

Crimp ferrule	: FFS.00.160.DN
For cables	: RG.178B/U (50Ω)
	: RG.196A/U (50Ω)

**Straight plug for cable crimping .**

**(Cable group 1)**

**Series 03 , coaxial (50Ω)**

ETUDE N° E3139-E1734

Echelle	Dessiné	23.03.2021	OVU /OBAR
	Contrôle	23.03.2021	OBAR/ CDE
	Modif.	00	23.03.2021/ OVU



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