

|                      |                       |                              |
|----------------------|-----------------------|------------------------------|
| Outer shell          | : Brass (UNS C38500)  | Chrome plated (FS-QQ-C-320B) |
| Earthing crown       | : Bronze (UNS C54400) | Nickel plated (FS-QQ-N-290A) |
| Collet nut           | : Brass (UNS C38500)  | Chrome plated (FS-QQ-C-320B) |
| Insulator            | : PEEK                | -                            |
| Female contact       | : Bronze (UNS C54400) | Gold plated (ISO 4523)       |
| Other metallic parts | : Brass (UNS C38500)  | Nickel plated (FS-QQ-N-290A) |

**Coaxial contact subassembly :**

|                       |                       |                              |
|-----------------------|-----------------------|------------------------------|
| Female sleeve         | : Bronze (UNS C54400) | Gold plated (ISO 4523)       |
| Insulator             | : PTFE                | -                            |
| Female contact        | : Cu-Be (UNS C17300)  | 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)  | -                            |

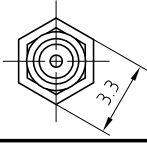
Technical drawing showing the assembly steps for the coaxial contact subassembly. The drawing includes dimensions for the cable stripping and the assembly components. The steps are as follows:

- Strip the cable according to the given dimensions. Slide it into the collet nut (1) and collet (2).
- In case of a screened cable, fold screen back over the extremity of the collet. Mount the female coaxial contacts (3) according to the separate instructions given beside, slide to the insulator (4) and they should remain in position when given a gentle pull to each conductor.
- Fit conductor into contact (5), and solder. Verify that insulator and insulation remain clean.
- In case of a screened cable, check that the screen which is folded back over the collet is clear of the keyway. Locate the upper half (6) of the split insert carrier over the shoulder and key on the insulator then align and press together the other half (7) 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.
- Next slide the socket shell (8) 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 4 Nm.

**Coaxial contact : PSS.2B.250.ZTME31**

Technical drawing showing the assembly steps for the coaxial contact. The drawing includes dimensions for the cable stripping and the assembly components. The steps are as follows:

- Slide the cable into the crimp ferrule (1). Strip according to the given dimensions.
- Wind 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.
- Slide the crimp ferrule fully onto the screen until it touches the crimping collet. Crimp with crimping tool.
- Slide the insulator (4) on the contact.
- Screw the female 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 |  | Crimping tool with dies | : DPE.99.103.8K  |
|                    |   | Crimp ferrule           | : FFS.00.161.MN  |
|                    |   | Extractor               | : DCC.91.384.5LA |
|                    |   | Flat spanner            | : DCP.99.040.TC  |
|                    |   | ( For Coax )            |                  |
|                    |   | Flat spanners set       | : DCP.91.023.TN  |
|                    |   | ( For Shell )           |                  |

**Straight socket , with key (G) , with cable collet .**  
**(Cable group 3)**  
**Series 3B , 2coax50Ω(typeC) + 6LV(φ0,9)**

ETUDE N° E1849



CH-1024 Ecublens

|         |          |            |                  |
|---------|----------|------------|------------------|
| Echelle | Dessiné  | 22.11.2013 | OVU /JPBA        |
|         | Contrôle | 22.11.2013 | JPBA/ATVI        |
|         |          |            |                  |
|         | Modif.   | 00         | 22.11.2013 / OVU |

**PHG.3B.846.CLLD\_\_ \_3**