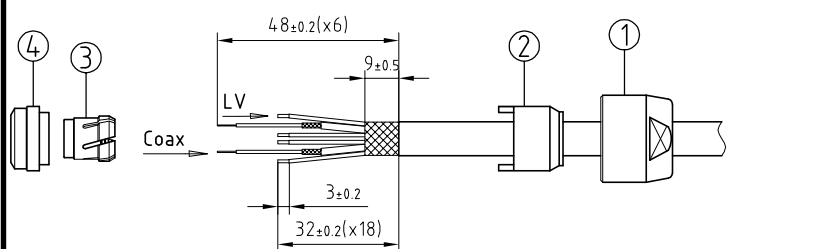


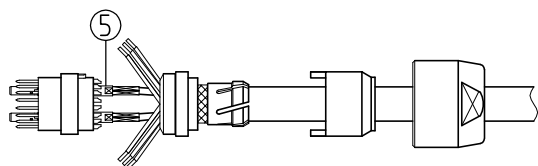
Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Earthing crown	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulator	: PEEK	
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Other metallic parts	: Brass (UNS C38500)	Nickel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

Coaxial contact subassembly :

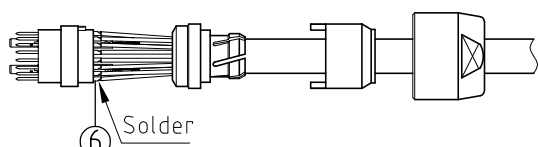
Male sleeve	: Brass (UNS C38500)	Gold plated (ISO 4523)
Insulator	: PEEK	-
Female contact	: Cu-Be (UNS C17300)	Gold plated (ISO 4523)
Crimping collet	: Brass (UNS C38500)	Gold plated (ISO 4523)
Other insulating part	: PEEK	-
Crimp ferrule	: Cu (UNS C18700)	Gold plated (ISO 4523)



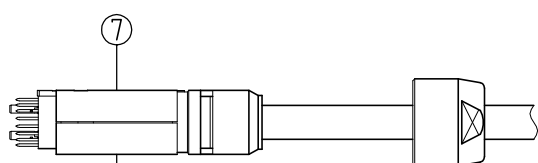
1. Strip the cable according to the given dimensions. Slide it into the collet nut (1), the reducing cone (2), the collet (3) and the reducer (4).



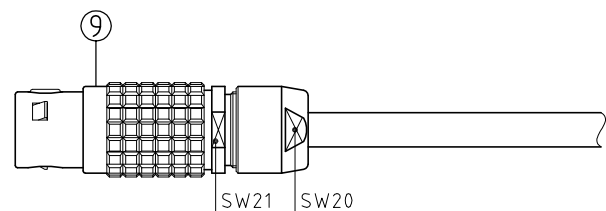
2. In case of a screened cable, fold screen back over the extremity of the collet and cut, if necessary, the excess screen. Mount the male coaxial contacts (5) according to the separate instructions given beside.



3. Fit conductor into contact (6), and solder. Verify that insulator and insulation remain clean.

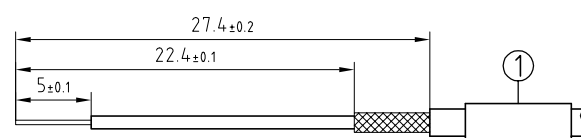


4. Locate the upper half (7) of the split insert carrier over the shoulder and key on the insulator then align and press together the other half (8) to form a complete cylinder. Align the key of the insert carrier with the keyway in the reducer. Push the collet and reducing cone with the keys located into the slots of the reducer.

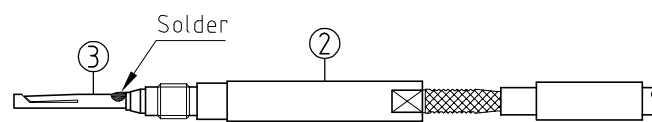


5. Next slide the plug shell (9) over the insulator assembly making sure that the key on the insert carrier goes into the appropriate keyway (under the color point) inside the shell. Ensure that the internal components do not rotate in the shell and finally screw the collet nut with the appropriate tool and tighten to the maximum torque value of 7 Nm.

Coaxial contact : FFS.2B.250.DLLE21



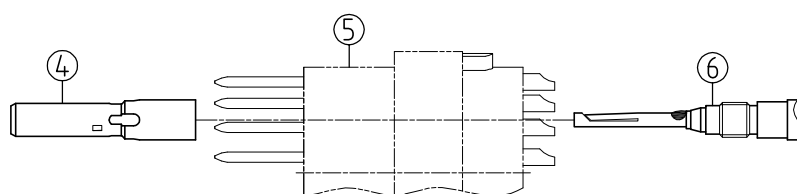
1. Slide the cable into the crimp ferrule (1). Strip according to the given dimensions.



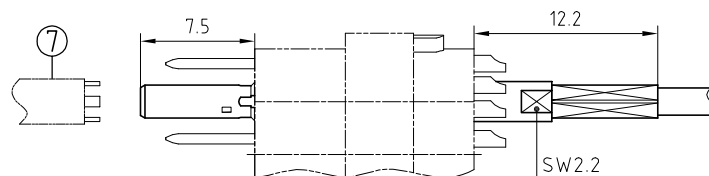
2. Winden the screen, slide the crimping collet (2) fully onto the cable until the insulator touches the dielectric and one can see the conductor in the contact (3) hole. Solder the contact.



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

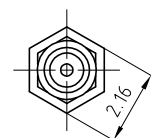


4. Slide the coax male contact (4) into the male insulator (5) front and the pre-mounted cable assembly (6) into the insulator back.



5. Screw the coax male contact with the male spanner (7) on the collet (verify that the four small pins fit well into the slots of the male contact) by holding it with the flat spanner SW2.2 of the installation tool. Tighten to the maximum torque value of 0,1 Nm.

Crimping dimensions



Flat spanners set	: DCP.91.045.TN
Crimping tool with dies	: DPE.99.002.5K
Crimp ferrule	: FFS.2B.161.DA
Installation tool	: DCC.91.050.2LA

**Straight plug, with key (G), with cable collet.
Series 4B, 6coax50Ω(typeE) + 18LV(φ0,7)**

ETUDE N° E4141

Echelle	Dessiné	13.04.2010	OVU / JPBA
	Contrôle	13.04.2010	JPBA / CDE
	Modif.	00	13.04.2010 / OVU