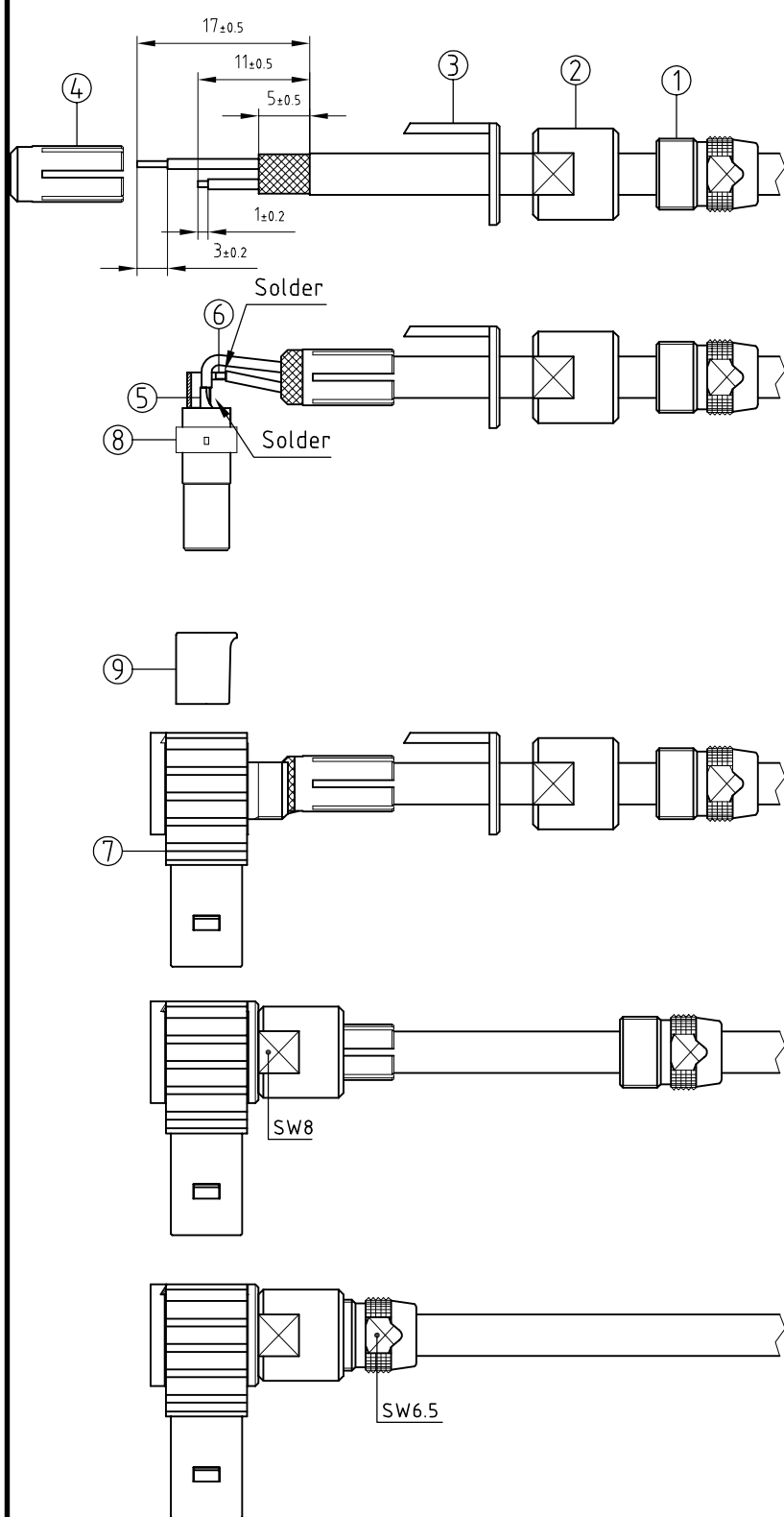


Outer shell , inner shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Female sleeve	: Bronze (UNS C54400)	Gold plated (ISO 4523)
Insulators	: PEEK	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 4523)
Insulating sleeve	: PA6.6	-
Threaded ring , square piece	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



1. Strip the cable according to the given dimensions . Slide it into the collet nut①, the threaded ring②, the square piece③and collet④.

2. In case of a screened cable , fold screen back over the extremity of the collet . Fit long conductor into the contact⑤and solder . Verify that insulator and insulation remain clean . Solder the other conductor to the female sleeve⑥ as shown . Make sure that there is over thickness of solder .

3. Slide the subassembly into the plug outer shell⑦, ensure that the keys inside the shell goes into the appropriate keyway on the insert carrier⑧ and introduce the insulating sleeve⑨into the shell . Slide the collet by ensuring that its keyway goes on the key of the inner shell and cut , if necessary , the excess screen .

4. Slide the square piece on the thread until it butts and screw the threaded ring with the appropriate tool and tighten to the maximum torque value of 1Nm .

5. Screw the collet nut with appropriate tool and tighten to the maximum torque value of 0,5Nm .

Assembly spanner : DCL.91.127.0TK

**Elbow plug (90°) with cable collet .  
(assembly with 2 conductors cable)  
Series 0S , Triaxial (50Ω)**

ETUDE N°



**LEMO**

CH-1024 Ecublens

Echelle	Dessiné	08.04.04	OVU / RMO
	Contrôle	08.11.04	RMO / CDE
	Modif.	01	08.11.04 / OVU

**FLA.0S.650.CLAC** \_ \_