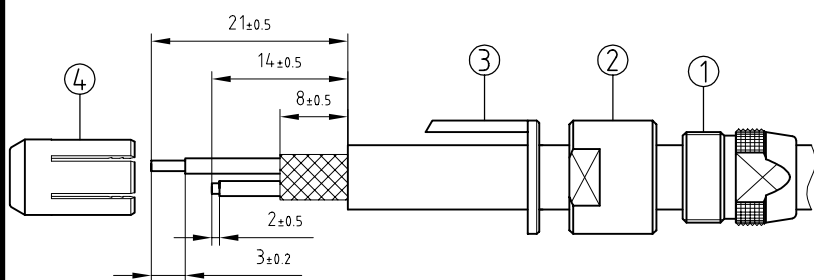
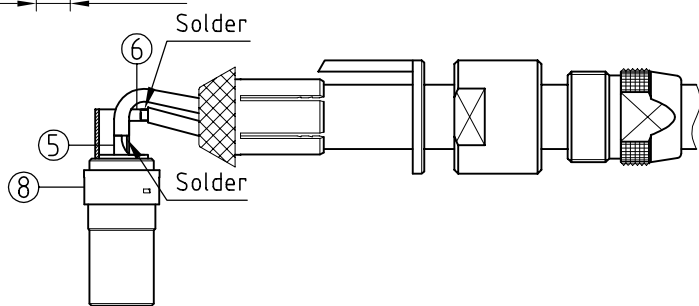


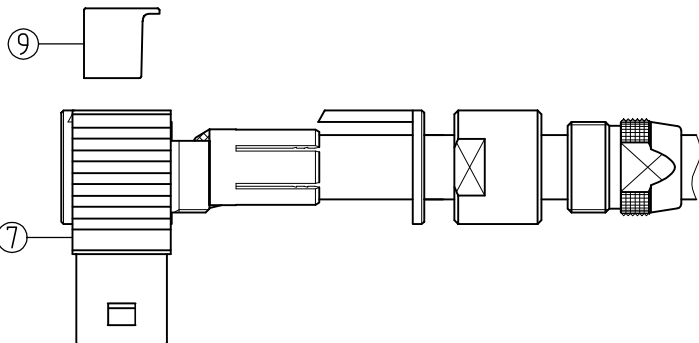
Outer shell , inner shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Female sleeve	: Brass (UNS C38500)	Gold plated (ISO 4523)
Insulators	: PTFE	-
Male contact	: Brass (UNS C38500)	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)



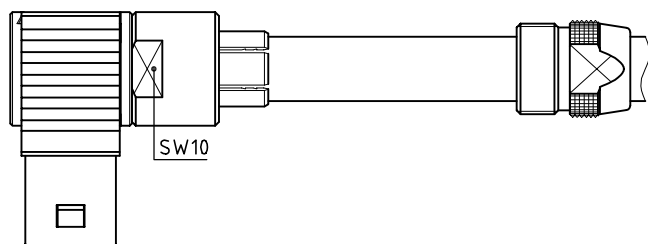
1. Strip the cable according to the given dimensions . Slide it into the collet nut①, the threaded ring②, the square piece③and collet④.



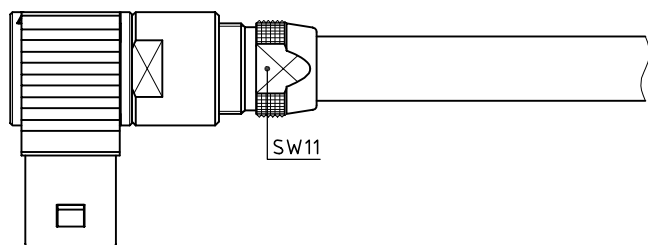
2. In case of a screened cable , fold screen back over the extremity of the collet . Fit long conductor into the contact⑤and solder . Verify that insulator and insulation remain clean . Solder the other conductor to the female sleeve⑥ as shown . Make sure that there is over thickness of solder .



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 2Nm .



5. Screw the collet nut with appropriate tool and tighten to the maximum torque value of 1,5Nm .

**Elbow plug (90°) with cable collet .  
(assembly with 2 conductors cable)  
Series 1S , Triaxial (50 Ω)**

ETUDE N° E1015

Echelle	Dessiné	22.04.05	OVU / RMO
	Contrôle	22.04.05	RMO / CDE
	Modif.	00	22.04.05 / OVU