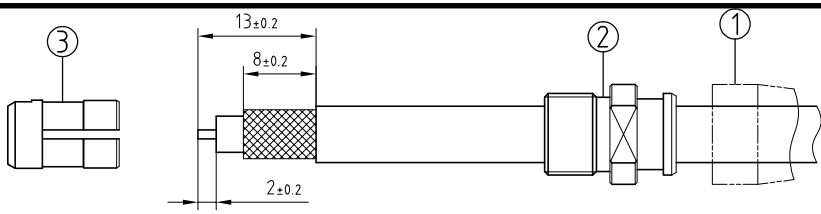
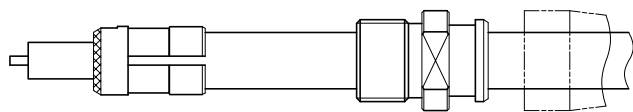


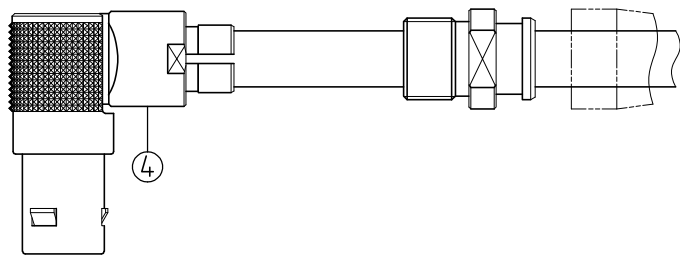
Outer shell , inner shell	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Latch sleeve	: Special brass	Nickel plated (SAE AMS QQ N 290)
Collet nut	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Cap	: Brass (UNS C38500)	Chrome plated (SAE AMS 2460)
Insulator	: PTFE	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Insulating sleeve	: POM	-
Other metallic part	: Brass (UNS C38500)	Nickel plated (SAE AMS QQ N 290)
Bend relief	: Polyurethane	Various colors



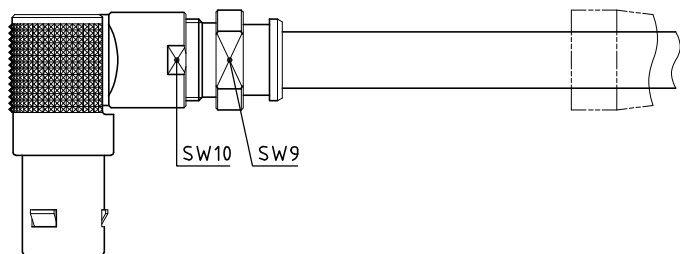
1. Strip the cable according to the given dimensions . Slide it into the bend relief①, the collet nut② and the collet③.



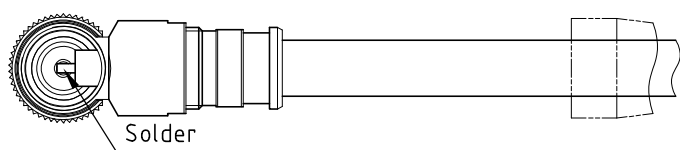
2. Fold the external screen back over the extremity of the collet and cut , if necessary , the braid excess .



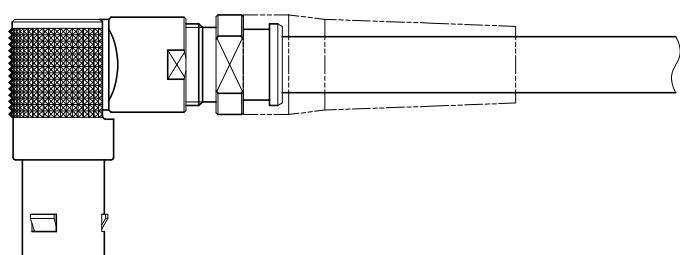
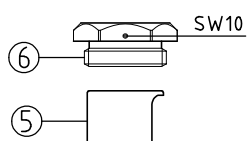
3. Introduce the cable stripped into the plug subassembly④ and push the collet by ensuring that the screen is being clamped around the whole circumference .



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



5. Fit conductor into the central contact and solder as shown . Verify that insulator and insulation remain clean . Solder the twisted end to the tag of the



6. Fit the insulating sleeve⑤ and screw the cap⑥ to to the maximum torque value of 0.8Nm . Slide the bend relief onto the collet nut .

Assembly spanner : DCN.91.149.0TK  
Flat spanners set : DCP.91.001.TN

## Elbow plug (90°) with collet and nut for bend relief . Series 1S , coaxial (75Ω)

ETUDE N° E7210-E1093

Echelle	Dessiné	31.03.2021	OVU / OBAR
	Contrôle	31.03.2021	OBAR/ CDE
	Modif.	00	31.03.2021/ OVU



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**FLC.1S.275.CTAC\_\_Z**