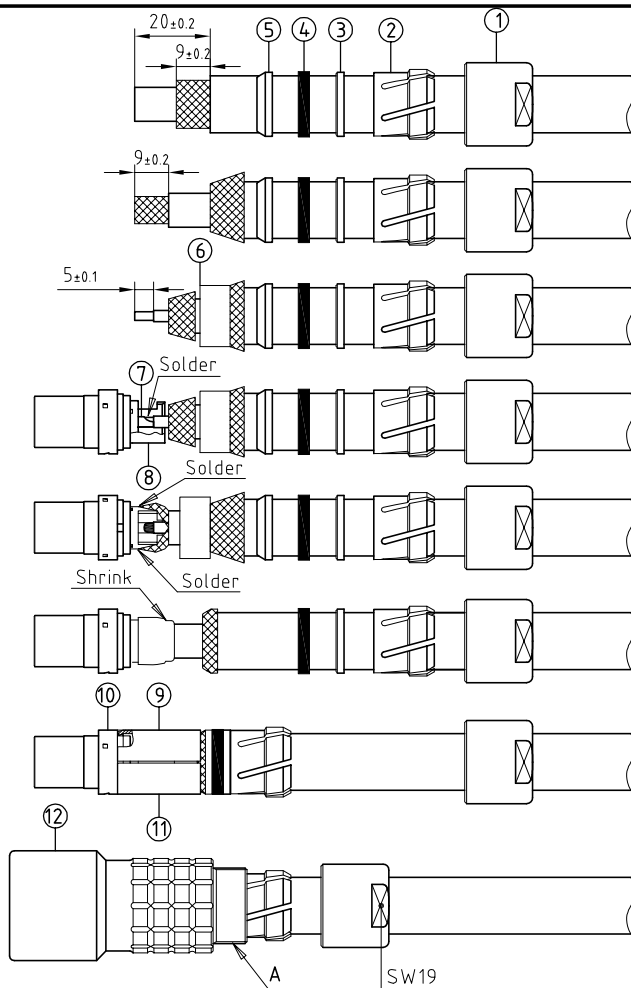


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Earthing crown	: Brass (UNS C38500)	Gold plated (ISO 27874)
Female sleeve	: Bronze (UNS C54400)	Gold plated (ISO 27874)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulators	: PTFE	-
Female contact	: Bronze (UNS C54400)	Gold plated (ISO 27874)
Gland	: Silicone (SI)	-
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)
O-ring	: Silicone (MVQ)	-



1. Strip the cable according to the given dimensions . (The end of the cable jacket must be cut properly) . Slide it into the collet nut①, the collet② the ring③, the gland④and the earthing cone⑤.
2. Fold back the external screen and strip the cable according to the given dimension .
3. Slide a piece of heat shrink tubing (not supplied)⑥of the correct length over cable . Fold back the intern braid and strip the cable according to the given dimension .
4. Slide the conductor into the contact⑦until the dielectric of the cable strike against the contact and solder .
5. Twist the internal screen in two parts and solder on each side of the female sleeve⑧. Make sure that there is no over thickness of solder .
6. Slide the heat shrink tubing over the female sleeve . With a heat gun fully shrink the tubing . Fold back the external screen over the extremity of the earthing cone .
7. Locate the upper half⑨of the split insert carrier over the shoulder and key on the insert metal ring⑩then align and press together the other half⑪to form a complete cylinder . Push the earthing cone against the insert carriers whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen . Push the gland , the ring and the collet against the earthing cone .
8. Next slide the socket shell⑫over the insulator assembly by holding the collet . Apply a small drop of thread lock (Loctite 270 or equivalent) on the socket shell thread A and screw the collet nut with the appropriate tool and tighten to the maximum torque value of 5Nm .

Free socket , with cable collet and nut .
Series 4E , triaxial (75Ω)

ETUDE N° E1830-E7017-E1092-E4106

Echelle	Dessiné	03.10.1989	MD / RMO
	Contrôle	07.03.2017	NHA / ATVI
	Modif.	02	07.03.2017/ OVU



LEMO

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