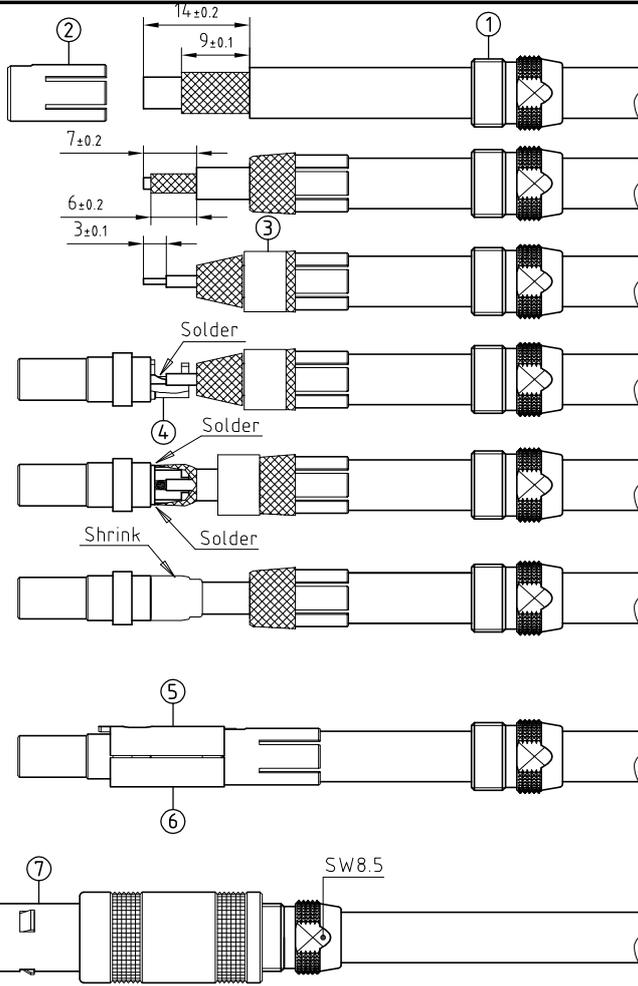


Outer shell	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Latch sleeve	: Special brass	Nickel plated (FS-QQ-N-290A)
Female sleeve	: Brass (UNS C38500)	Gold plated (ISO 27874)
Collet nut	: Brass (UNS C38500)	Chrome plated (FS-QQ-C-320B)
Insulators	: PTFE	-
Male contact	: Brass (UNS C38500)	Gold plated (ISO 27874)
Other metallic parts	: Brass (UNS C38500)	Nickel plated (FS-QQ-N-290A)



- Strip the cable according to the given dimensions . Slide it into the collet nut<sup>①</sup> and the collet<sup>②</sup>.
- Fold back the external screen over the extremity of the collet and strip the cable according to the given dimension .
- Slide a piece of heat shrink tubing (not supplied)<sup>③</sup> of the correct length over cable . Fold back the intern braid and strip the cable according to the given dimension .
- Slide the conductor into the contact until the dielectric of the cable strike against the contact and solder .
- Twist the internal screen in two parts and solder on each side of the female sleeve<sup>④</sup>. Make sure that there is no over thickness of solder .
- Slide the heat shrink tubing over the female sleeve . With a heat gun fully shrink the tubing .
- Check that the screen which is folded back over the collet is clear of the keyway . Locate the upper half<sup>⑤</sup> of the split insert carrier over shoulder the insulator assembly and press together the other half<sup>⑥</sup> to form a complete cylinder . Align the key of the insert carrier with the keyway in the collet and move them together whilst checking that the screen is being clamped around the whole circumference and cut , if necessary , the excess screen .
- Next slide the plug shell<sup>⑦</sup> over the insulator assembly making sure that the key on the insert carrier goes into the keyway 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 1,5Nm .

Assembly spanner : DCN.91.149.0TK

**Straight plug , with cable collet .**  
**Series 1S , triaxial (50Ω)**

Echelle	Dessiné	24.01.2006	OVU / RMO
	Contrôle	11.12.2014	JPBA / ATVI
Modif.	01	11.12.2014 / OVU	

ETUDE N°



**FFA.1S.650.CTAC\_\_**