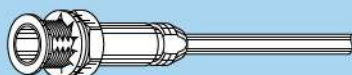
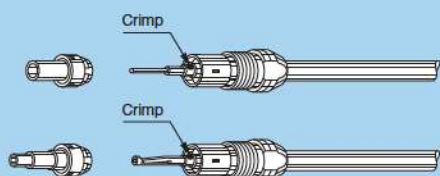
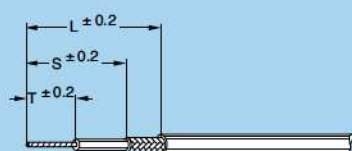
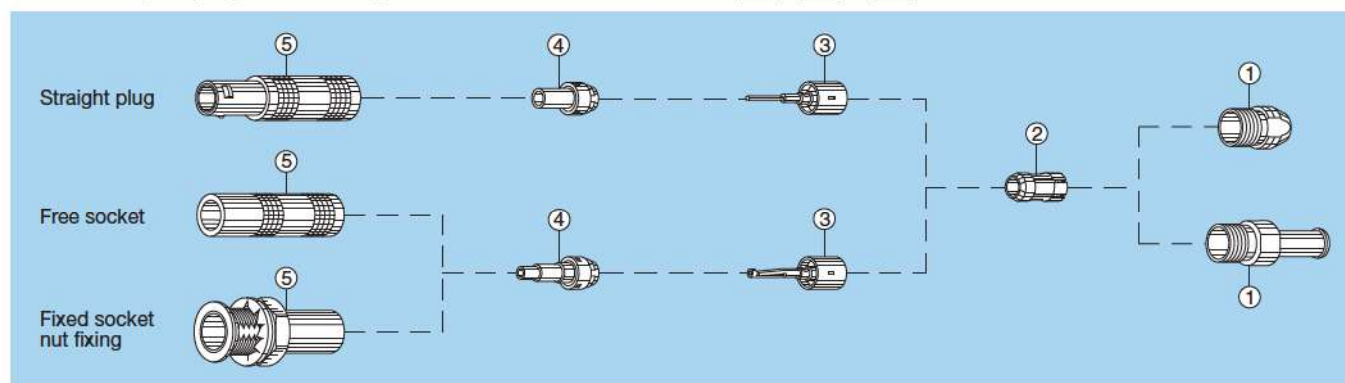


## Cable assembly

### Terminating of plugs and straight sockets with cable collet M1 M2 M3



#### 1. Cable preparation

First place the bend relief (if to be used) on the cable. Strip the cable according to dimensions below.

Cable group	M1			M2			M3		
	T	S	L	T	S	L	T	S	L
1-2-3-4-8	4	4.5	9	–	–	–	5	5	8
6-7	–	–	–	7.5	8.5	13	–	–	–

#### 2. Cable termination

2.1 Place the collet nut ① and the collet ② on the cable. Fold back the shield braid onto the conical part of the collet, and trim to the outer edge of the collet

2.2 Slide the subassembly ③ to trap the shield braiding and solder the central conductor into the contact.

2.3 Slide the insulator ④ onto the subassembly ③ until it rests against the earthing sleeve of the subassembly ③.

2.4 Slide the assembly into the connector outer shell ⑤. Screw the collet nut ① into the connector outer shell ⑤ using the appropriate tool and tighten to a torque of 0.25 Nm (see "Tooling" on page 35, 36 and 37). Push the bend relief (if used) onto the collet nut.

**Note:** these terminating instructions apply to the following models:

M1 = FFA, FFE, FFF, PCA, PSA  
M2 = FFY  
M3 = FFC