

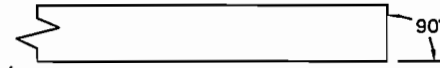
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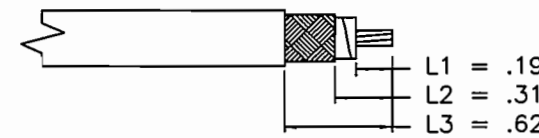
REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
57775		N/C	NEW RELEASE	1/19/16	ENC

**INSTALLATION INSTRUCTIONS**

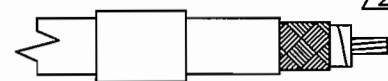
1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



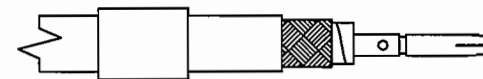
2. WHEN USING AUTOMATIC STRIPPING EQUIPMENT, STRIP CABLE AS SHOWN STARTING WITH L1 AND ENDING WITH L3. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. IF AUTOMATIC STRIPPING EQUIPMENT IS NOT AVAILABLE, STRIP ONLY L1 AND L3 AND TRIM EXCESS BRAID AT STEP 10.



3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.



4. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-57 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



5. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



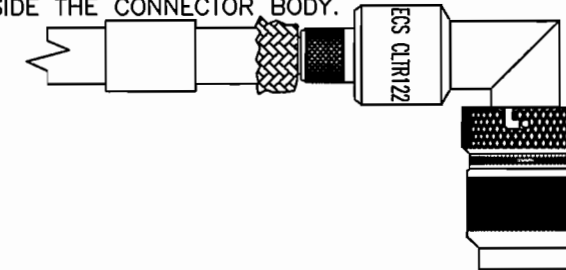
6. SLICE THE ALUMINUM/POLYESTER FOIL LENGTHWISE ABOUT EVERY 1/8". GENTLY ROTATE PIN TO SEPARATE THE FLAT FOIL BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.



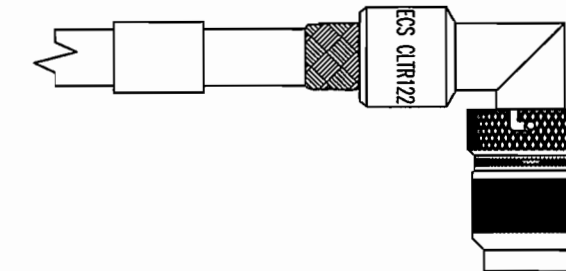
7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.



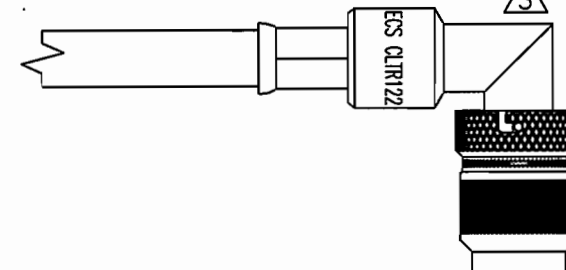
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



9. FOLD ALL THREE BRAIDS UP OVER THE NECK OF THE CONNECTOR BODY.

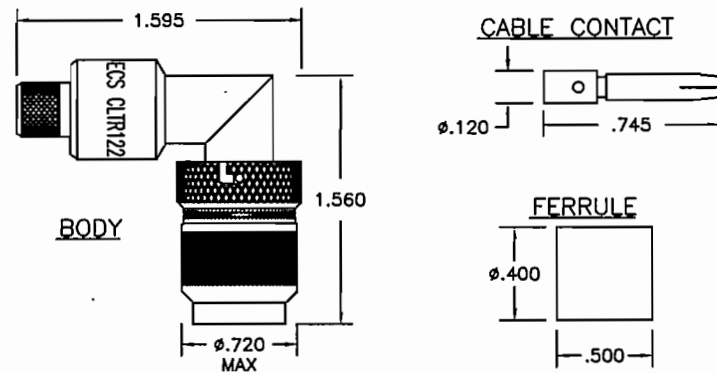


10. SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING A M22520/5-47 DIE IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



**NOTES**

- 1. ALL DIMENSIONS ARE IN INCHES.
- 2. ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- 3. ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- 4. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.



DIMENSIONS 4

**SPECIFICATIONS**

**ELECTRICAL**

IMPEDANCE: 50 OHMS NOMINAL  
FREQUENCY RANGE: 0-11 GHz  
VSWR: 1.2:1 MAXIMUM DC TO 2GHz  
INSERTION LOSS: .1dB MAXIMUM DC TO 2GHz  
WORKING VOLTAGE: 500 VRMS @ SEA LEVEL  
DIELECTRIC WITHSTANDING: 1500 VRMS @ SEA LEVEL  
INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

**MECHANICAL**

CONNECTOR INTERFACE DIMENSIONS PER MIL-STD-348B, FIGURE 313-1  
TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP  
OUTER CONTACT-FERRULE CRIMP  
CABLE RETENTION: 50 LBS

**ENVIRONMENTAL**

TEMPERATURE RATING: -65° TO +165° C  
VIBRATION: MIL-STD-202, METHOD 204, COND. B  
SHOCK: MIL-STD-202, METHOD 213, COND. I  
THERMAL SHOCK: MIL-STD-202, METHOD 107, COND. B  
CORROSION: MIL-STD-202, METHOD 101, COND. B  
MOISTURE RESISTANCE: MIL-STD-202, METHOD 106

**MATERIALS**

BODY: BRASS PER ASTM B16  
FERRULE: ANNEALED BRASS PER ASTM B16 OR COPPER PER ASTM B124  
CENTER CONTACT: BRASS PER ASTM B16  
COUPLING & BACK NUT: 303 SST PER ASTM A582  
CABLE, OUTER CONTACT: BERYLLIUM COPPER PER ASTM B196  
DIELECTRIC: TEFLON PER ASTM D1710  
GASKET: SILICONE RUBBER PER A-A-59588

**FINISHES**

BODY, FERRULE AND OUTER CONTACT: BRIGHT NICKEL PER SAE-AMS-QQ-N-290  
CONTACTS: GOLD PER MIL-DTL-45204  
COUPLING & BACK NUT: PASSIVATE PER SAE-AMS-2700

ALL LENGTHS IN INCHES		<b>CARLISLE</b> Carlisle Interconnect Technologies Franklin, WI 53132 414-421-5300	
APPROVALS	DATE	TITLE: <b>CUSTOMER SPECIFICATION</b>	
DRAWN BY: CRAIG KULAS	11/30/15	LOCKING TNC RIGHT ANGLE PLUG FOR 311201 & 421201 CABLES	
CHECKED BY: R. Lay	1/19/16	SIZE	CAGE CODE
DESIGNED BY: R LAY	11/30/15	B	66197
PROJECT ENG: C Chapman	1/19/16	LEVEL	PART NO.
ENG. MGR: D. G. Arnold	1/19/16		CLTR122
SCALE:		EFFECTIVITY:	SHEET: 1 OF 1