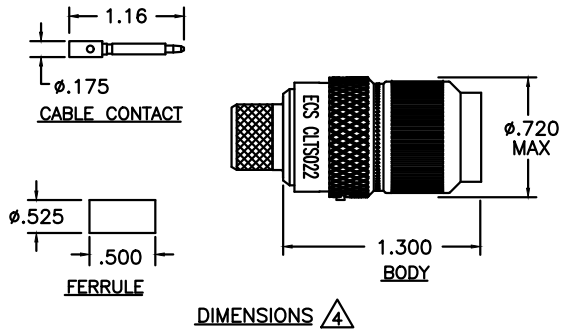
REVISIONS						
ECN	SHEET	ZONE	REV.	BRIEF DESCRIPTION (SEE ECN FOR COMPLETE CHANGE DETAILS)	DATE	APPROVED
77800			NC	NEW RELEASE	Rashaad Lay	



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

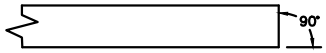
BODY: BRASS PER ASTM B16
FERRULE: ANNEALED BRASS PER ASTM B16 OR COPPER PER ASTM B124
CENTER CONTACT: BRASS PER ASTM B16
COUPLING & BACK NUT: 303 SST PER ASTM A582
OUTER CONTACT: BERYLLIUM COPPER PER ASTM B196
DIELECTRIC: TEFLON PER ASTM D1710
GASKET: SILICONE RUBBER PER A–A–59588

FINISHES

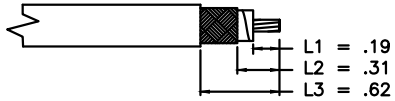
BODY, FERRULE AND OUTER CONTACT: BRIGHT NICKEL PER SAE–AMS–QQ–N–290
CONTACTS: GOLD PER MIL–DTL–45204
COUPLING & BACK NUT: PASSIVATE PER SAE–AMS–2700

INSTALLATION INSTRUCTIONS

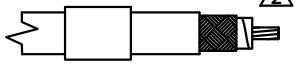
1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



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.



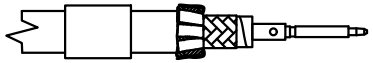
3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE. 2



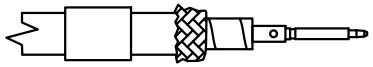
4. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL–STD–2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH Y1757 DIE. ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.

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

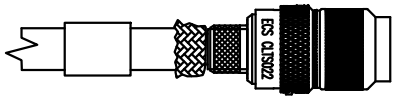
6. SLICE THE ALUMINUM/POLYESTER FOIL LENGTHWISE ABOUT EVERY 1/8". GENTLY ROTATE PIN TO SEPARATE THE FLAT FOIL BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.



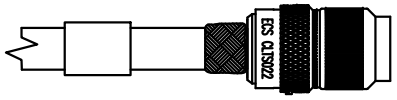
7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.



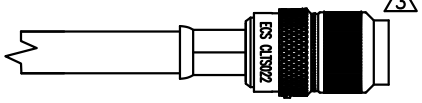
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



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 M22520/5–21 DIE IN A M22520/5–01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. 3



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 WI007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
4. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

ALL LENGTHS IN INCHES

APPROVALS	DATE
DRAWN BY: S SHAFFER	08/31/21
CHECKED BY: Stephan Sklenak	Digitally signed by Stephan Sklenak Date: 2021.09.02 12:10:12 -05'00'
DESIGNED BY: S SKIBINSKI	08/31/21
PROJECT ENG: Rashaad Lay	Digitally signed by Rashaad Lay Date: 2021.09.03 02:36:21 -05'00'
ENG. MGR: Rashaad Lay	Digitally signed by Rashaad Lay Date: 2021.09.03 02:36:46 -05'00'

CARLISLE

Carlisle Interconnect Technologies
Franklin, WI 53132
414-421-5300

TITLE: CUSTOMER SPECIFICATION
LOCKING TNC STRAIGHT PLUG
FOR ECS CABLE 310801

SIZE	CAGE CODE	LEVEL	PART NO.
B	66197		CLTS022

SCALE: | EFFECTIVITY: | SHEET: 1 OF 1