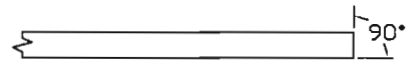



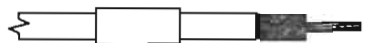
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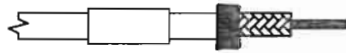
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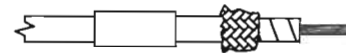
REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
2347		N/C	RELEASED BY ECN# 2347	1/20/95	JBH
2806		A	SEE ECN# 2806	4/12/95	JBH
4440		B	SEE ECN# 4440	8/13/96	JBH
6189		C	SEE ECN# 6189	9/10/98	MCT
12886		D	SEE ECN	12/7/00	DEK
13467		E	SEE ECN	7/30/01	C CHAPMAN
49716	C,D	4	ADDED DIMENSIONS	7/1/13	CAC

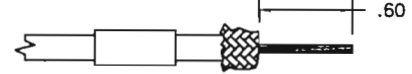
INSTALLATION INSTRUCTIONS

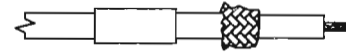
- BEGIN BY CUTTING THE CABLE OFF SQUARE. 
- STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED. 


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

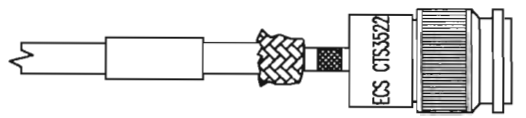
- USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE. 

- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE. 

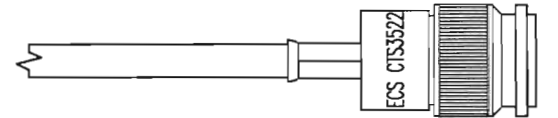
- REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK APPROXIMATELY .60 INCHES FROM THE END OF THE CONDUCTOR. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR. THERMAL STRIPPERS ARE RECOMMENDED. 

- INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR, ENSURING THAT IT IS BUTTED AGAINST THE CABLE DIELECTRIC. 

- SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-11 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUE USING AN APPROPRIATE FLUX CLEANER. 

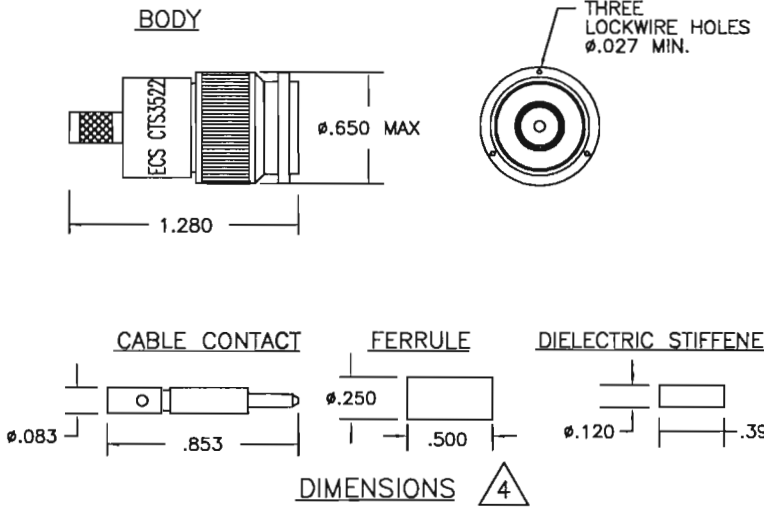
- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE RIDGE INSIDE THE CONNECTOR DIELECTRIC. **CAUTION:** PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE. 

- FOLD BOTH BRAIDS OVER THE NECK OF THE CONNECTOR BODY. 

- 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 M22520/5-57 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. 

NOTES

- ALL DIMENSIONS ARE IN INCHES.
- ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W10007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
- DELETED.
- DELETED.



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-348A FIGURE 313-1
 TERMINATION STYLE: CABLE CONTACT-SOLDER OR CRIMP FERRULE-CRIMP
 CABLE RETENTION: 20 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 QQ-B-626
 FERRULE: ANNEALED, BRASS PER QQ-B-626
 CABLE CONTACT: BRASS PER QQ-B-626
 OUTER CONTACT: BERYLLIUM COPPER PER QQ-C-530
 DIELECTRIC: TEFLON PER L-P-403
 GASKET: SILICONE RUBBER PER ZZ-R-765
FINISHES
 BODY, FERRULE AND OUTER CONTACT: BRIGHT NICKEL PER QQ-N-290
 CENTER CONTACT: GOLD PER MIL-G-45204

ALL LENGTHS IN INCHES		ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: JB HACKETT	1/11/95	TNC STRAIGHT PLUG FOR ECS CABLE 352001	
CHECKED BY: T MEYERS	1/20/95	SIZE: B	CAGE CODE: 66197
DESIGNED BY:		LEVEL:	PART NO. CTS3522
PROJECT ENG: H STOIBER	1/20/95	SCALE:	EFFECTIVITY:
ENG. MGR: JB HACKETT	1/20/95	SHEET: 1 OF 1	