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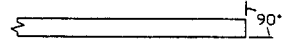
DWG NO. CCS3522-1 SH 1 REV. A

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INSTALLATION INSTRUCTIONS

1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



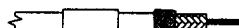
2. STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.



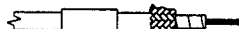
3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.



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



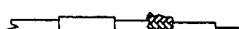
5. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OUTER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.



6. REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK TO THE BEGINNING OF THE FOLDED BACK SHIELD, APPROXIMATELY .60 INCHES FROM THE END OF THE CENTER CONDUCTOR. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR. THERMAL STRIPPERS ARE RECOMMENDED.



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

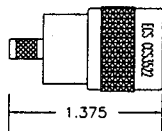


8. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-57 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
6188		N/C	NEW RELEASE.	9/16/98	MCT
13277		A	SEE ECN	7/23/01	C Chapman

FERRULE

BODY

DIELECTRIC STIFFENER

CONTACT

DIMENSIONS
SPECIFICATIONS
ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-11 GHz
 VSWR: 1.2:1 MAX DC TO 2 GHz
 INSERTION LOSS: .1 dB MAX DC TO 2 GHz
 WORKING VOLTAGE: 1000 VRMS @ SEA LEVEL
 DIELECTRIC WITHSTANDING: 3000 VRMS @ SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

MECHANICAL

CONNECTOR INTERFACE DIMENSION PER MIL-STD-348A FIGURE 302-1

TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP

OUTER CONTACT-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

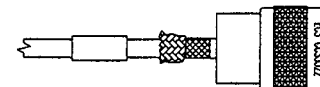
MATERIALS

BODY: BRASS PER QQ-B-626
 FERRULE: ANNEALED BRASS PER QQ-B-626
 CENTER CONTACT: BRASS PER QQ-B-626
 OUTER CONTACT: BERYLLIUM COPPER PER QQ-C-530
 DIELECTRIC: TEFLON PER L-P-403
 GASKET: SILICON RUBBER PER ZZ-R-765

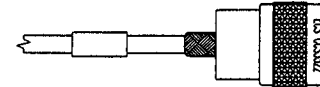
FINISHES

BODY, FERRULE: BRIGHT NICKEL PER QQ-N-290
 CENTER CONTACT: GOLD PER MIL-G-45204

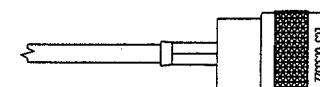
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR. CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



9. FOLD BOTH SHIELDS 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 THE M22520/5-57 DIE (A HEX) 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 W10007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
 4. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
 5. DELETED.
 6. DELETED.

APPROVALS		DATE	ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300		
DRAWN BY: C CHAPMAN		09/15/98	TITLE: CUSTOMER SPECIFICATION		
CHECKED BY: C CHAPMAN		09/15/98	C STRAIGHT PLUG FOR ECS CABLE 352001		
DESIGNED BY:			SIZE	CAGE CODE	LEVEL PART NO.
PROJECT ENG: M TAUBENHEIN		9/16/98	B	66197	CCS3522
ENG. MGR: P JOBE		6/4/99	SCALE:	FILE NO F:\E\SPEC\CONN\INST\CCS3522	SHEET: 1 OF 1

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