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DWG NO. CHR3522-1 SH 1 REV. N/C

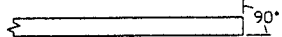
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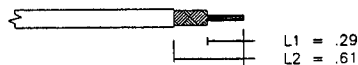
INSTALLATION INSTRUCTIONS

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
13278		N/C	NEW RELEASE	8/10/01	<i>c. Chappera</i>

1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



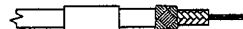
2. STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.



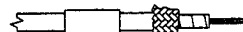
3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.



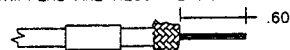
4. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



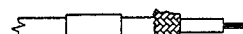
5. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.



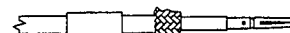
6. REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK TO THE BEGINNING OF THE FOLDED BACK SHIELD, APPROXIMATELY .58 INCHES FROM THE END OF THE CENTER CONDUCTOR. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR. THERMAL STRIPPERS ARE RECOMMENDED.



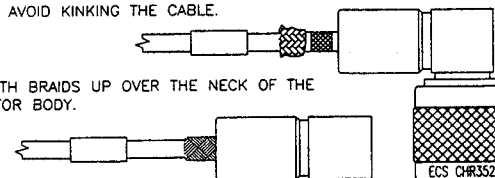
7. INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR, ENSURING THAT IT IS BUTTED AGAINST THE CABLE DIELECTRIC.



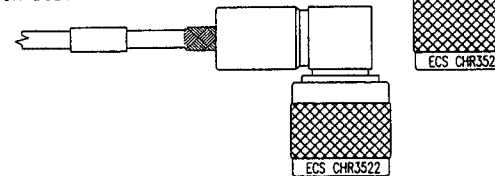
8. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-57 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



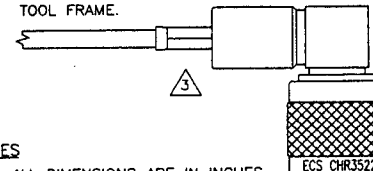
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR. CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



9. FOLD BOTH 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 THE M22520/5-57 DIE (A HEX) IN A M22520/5-01 TOOL FRAME.



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 W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

FERRULE



CONTACT

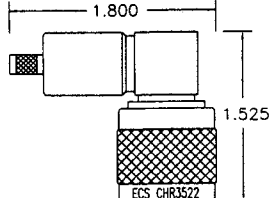


DIELECTRIC STIFFENER



DIMENSIONS

BODY



SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-4 GHz
 VSWR: 1.35:1 MAXIMUM
 INSERTION LOSS: .1 dB MAXIMUM DC TO 2 GHz
 WORKING VOLTAGE: 500 VRMS @ SEA LEVEL
 DIELECTRIC WITHSTANDING: 1500 VRMS @ SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

MECHANICAL

CONNECTOR INTERFACE DIMENSION PER MIL-STD-348A FIGURE 317-1.

TERMINATION STYLE: INNER CONTACT-SOLDER
 OUTER CONTACT-FERRULE CRIMP

CABLE RETENTION: 40 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

CABLE CONTACT: BERYLLIUM COPPER PER ASTM B196

OUTER CONTACT: BRASS PER ASTM B16

DIELECTRIC: TEFLON PER ASTM D1710

GASKET: SILICONE RUBBER PER ZZ-R-765

FINISHES

BODY, FERRULE: BRIGHT NICKEL PER QQ-N-290

CENTER CONTACT: GOLD PER MIL-G-45204

APPROVALS		DATE	ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300		
DRAWN BY: <i>E. Fossett</i>		8/10/01	TITLE: CUSTOMER SPECIFICATION		
CHECKED BY: <i>B. Chappera</i>		8/10/01	HN RIGHT ANGLE FOR ECS CABLE 352001		
DESIGNED BY:			SIZE: B	CAGE CODE: 66197	ECS PART NO. CHR3522
PROJECT ENG:			LEVEL:		
ECS MGR: <i>Paul S. Powell</i>		9/2/01	SCALE:	EFFECTIVITY:	SHEET: 1 OF 1

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