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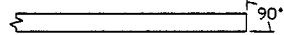
DWG NO.	CNS522-1	SH	REV.
		1	N/C

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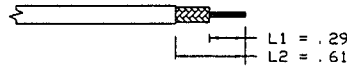
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INSTALLATION INSTRUCTIONS

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.



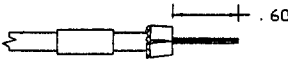
4. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



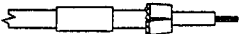
5. SLIT FOIL LONGITUDINALLY AND FOLD BACK OVER THE OTHER SHIELD.



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.



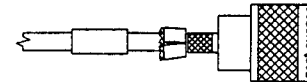
8. ENSURE THAT THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. TERMINATE CONTACT PER OPTION a OR b BELOW.

- a) SOLDER CONTACT ONTO CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER. CLEAN FLUX RESIDUE USING APPROPRIATE CLEANER.
- b) CRIMP CONTACT ONTO CENTER CONDUCTOR USING A M22520/5-09 DIE (B HEX). IN A M22520/5-01 TOOL FRAME.

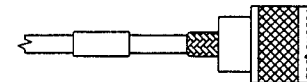


REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
13939		N/C	NEW RELEASE	7/6/01	Handwritten signature

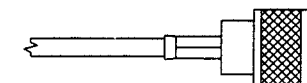
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE RIDGE INSIDE THE CONNECTOR DIELECTRIC. CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



10. FOLD BOTH SHIELDS BACK OVER THE NECK OF THE CONNECTOR BODY.



11. 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 M22520/5-09 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



NOTES

- ⚠️ ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- ⚠️ ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION WI007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- ⚠️ CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: V. LEX	06/19/01	N STRAIGHT PLUG FOR ECS CABLE 432101 AND 532101	
CHECKED BY: C. Chapman	7/5/01	SIZE	CAGE CODE
DESIGNED BY:		B	66197
PROJECT ENG:		LEVEL	PART NO.
		C	CNS522
DRG. MGR: Handwritten signature	7/6/01	SCALE:	EFFECTIVITY:
			SHEET: 1 OF 1

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