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DWG NO.	CSS522-1	SH	1	REV.	N/C
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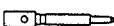
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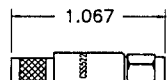
## FERRULE



## CONTACT



## BODY



## DIELECTRIC STIFFENER



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## SPECIFICATIONS

## ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL  
 FREQUENCY RANGE: 0-18 GHz  
 VSWR: 1.05 + .05 FGHz, MAXIMUM

INSERTION LOSS:  $.03\sqrt{\text{FGHz}}$  dB MAX  
 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 310-1  
 TERMINATION STYLE: CABLE CONTACT-SOLDER OR CRIMP  
 FERRULE CRIMP  
 CABLE RETENTION: 20 LBS

## ENVIRONMENTAL

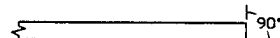
TEMPERATURE RATING: -65° TO +165° C  
 VIBRATION: MIL-STD-202, METHOD 204, COND. D  
 SHOCK: MIL-STD-202, METHOD 213, COND. I  
 THERMAL SHOCK: MIL-STD-202, METHOD 107, COND. B  
 CORROSION: MIL-STD-202, METHOD 101, COND. B  
 MOISTURE RESISTANCE: MIL-STD-202, METHOD 106

## MATERIALS

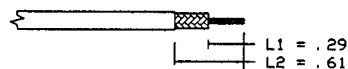
BODY: STAINLESS STEEL PER QQ-S-763  
 FERRULE: ANNEALED BRASS PER ASTM B16  
 CENTER CONTACT: BRASS PER ASTM B16  
 DIELECTRIC: TEFLON PER ASTM D1710  
 GASKET: SILICON RUBBER PER ZZ-R-765  
 FINISHES  
 FERRULE: BRIGHT NICKEL PER QQ-N-290  
 CENTER CONTACT: GOLD PER MIL-G-45204

## 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.



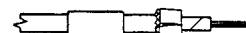
3. SLIDE THE FERRULE AND ADHESIVE HEAT SHRINK OVER THE END OF THE CABLE.



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



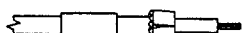
5. SLIT FOIL LONGITUDINALLY AND FOLD BACK OVER THE OTHER SHIELD.



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.

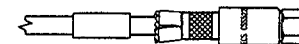


8. ENSURE THAT THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. TERMINATE CONTACT PER OPTION a OR b BELOW.  
 a) SOLDER CONTACT ONTO CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER. CLEAN FLUX RESIDUE USING APPROPRIATE CLEANER.  
 b) CRIMP CONTACT ONTO CENTER CONDUCTOR USING A M22520/5-09 DIE (B HEX).

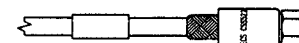


REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
13939		N/C	NEW RELEASE	6/28/01	R. 14/2/01

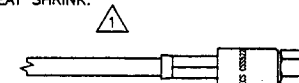
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE RIDGE INSIDE THE CONNECTOR DIELECTRIC. CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



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

1. ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.  
 2. ENSURE HEATSHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.  
 3. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300			
APPROVALS	DATE	TITLE <b>CUSTOMER SPECIFICATION</b>			
DRAWN BY: V. LEX	06/19/01	SMA STRAIGHT PLUG FOR ECS CABLE 432101 AND 532101			
CHECKED BY: C. Chapman	7/5/01	SIZE	CAGE CODE	LEVEL	PART NO.
DESIGNED BY:		B	66197	C	CSS522
PROJECT ENG:		SCALE:	F:\STORAGE\E\SPEC\CONNA\INST\CSS522		
DWG. NO.:		SHEET 1 OF 1			

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