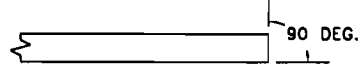


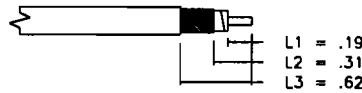
This print and associated documents and the contained information are the confidential property of ELECTRONIC CABLE SPECIALISTS. Disclosure of, and/or reproduction of, all or part thereof or manufacture of any part from information contained on this print not specifically permitted by ELECTRONIC CABLE SPECIALISTS in writing is forbidden.

INSTALLATION INSTRUCTIONS

- BEGIN BY CUTTING THE CABLE OFF SQUARE.



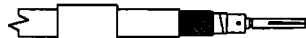
- WHEN USING AUTOMATIC STRIPPING EQUIPMENT, STRIP CABLE AS SHOWN STARTING WITH L1 AND ENDING WITH L3. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. IF AUTOMATIC STRIPPING EQUIPMENT IS NOT AVAILABLE, STRIP L1 AND L3 ONLY AND TRIM EXCESS BRAID AT STEP 10.



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



- SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER. ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



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



- SLICE THE ALUMINUM/POLYESTER FOIL LENGTHWISE ABOUT EVERY 1/8". GENTLY ROTATE PIN TO SEPARATE THE FLAT BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.

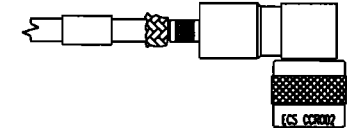


- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER BRAIDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: TAKE CARE NOT TO UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.

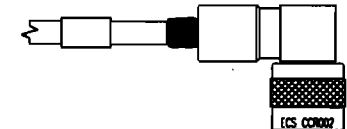


REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
26602	-	N/C	NEW RELEASE.	10/2/06	DEK
40648	C3 B4	A	NOTE 4 DEL "OR CRIMP WITH Y1757 DIE" TERM STYLE SPEC, DELETED "CRIMP"	7/16/10	DSR

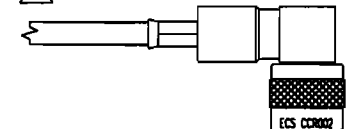
- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CONTACT UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR.



- FOLD ALL BRAIDS UP OVER THE NECK OF THE CONNECTOR BODY.

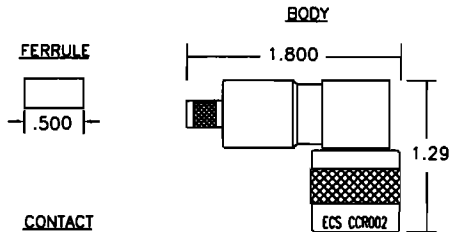


- SLIDE THE FERRULE OVER THE BRAIDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING A M22520/5-31 DIE IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



NOTES

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



DIMENSIONS 3

SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-11 GHz
 VSWR: 1.30:1 MAXIMUM
 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 ONLY
 OUTER CONTACT-FERRULE CRIMP
 CABLE RETENTION: 50 LBS

ENVIRONMENTAL

TEMPERATURE RATING: -65 TO +165 DEG. C
 VIBRATION: MIL-STD-202, METHOD 204, COND. B
 SHOCK: MIL-STD-202, METHOD 213, COND. 1
 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: BERYLLIUM COPPER PER QQ-C-530
 CENTER 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: BRIGHT NICKEL PER QQ-N-290
 CENTER CONTACT: GOLD PER MIL-G-45204

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300			
APPROVALS		DATE		TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: C CHAPMAN		9/28/06		C RIGHT ANGLE PLUG FOR ECS CABLE 310701	
CHECKED BY: D KNOLL		10/2/06		PART NO. CCR002	
DESIGNED BY:		SIZE	CAGE CODE	LEVEL	PART NO.
PROJECT ENG:		B	66197		
ENG. MGR: D KNOLL		10/2/06		SCALE:	FILE NO. F:\ECS\SPEC\COM\INST\CCR002
				SHEET: 1 OF 1	