

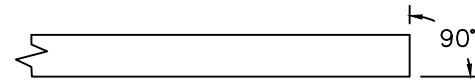
This print and associated documents and the contained information are the confidential property of ELECTRONIC CABLE SPECIALISTS. Disclosure of, and/or reproduction of, all or part thereof or manufacture of any part from information contained on this print not specifically permitted by ELECTRONIC CABLE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

**** EXPORT CONTROLLED DOCUMENT - EAR ****
The information in this document is subject to the export controls in accordance with the export administration regulations. Diversion contrary to U.S. Law is prohibited.

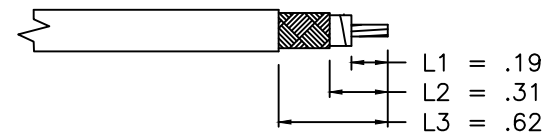
REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
58519		N/C	NEW RELEASE	4/11/16	CAC
59235		A	UPDATED ELECTRICAL NOTES	6/7/16	CAC
81434		B	UPDATED NOTE 4 CRIMP DIE CALLOUT		

INSTALLATION INSTRUCTIONS

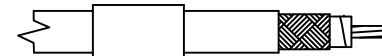
1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



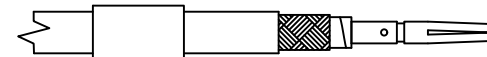
2. WHEN USING AUTOMATIC STRIPPING EQUIPMENT, STRIP CABLE AS SHOWN STARTING WITH L1 AND ENDING WITH L3. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. IF AUTOMATIC STRIPPING EQUIPMENT IS NOT AVAILABLE, STRIP L1 AND L3 ONLY AND TRIM EXCESS BRAID AT STEP 10.



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



4. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-06 DIE (A HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



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



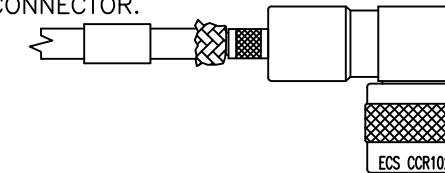
6. SLICE THE ALUMINUM/POLYESTER FOIL LENGTHWISE ABOUT EVERY 1/8". GENTLY ROTATE PIN TO SEPARATE THE FLAT FOIL BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.



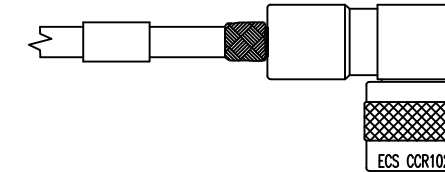
7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER BRAIDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: TAKE CARE NOT TO UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.



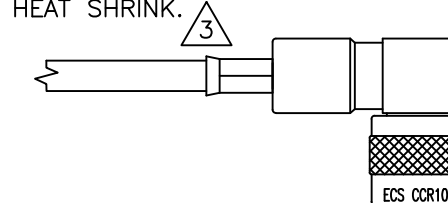
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CONTACT UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR.



9. FOLD ALL THREE BRAIDS UP OVER THE NECK OF THE CONNECTOR BODY.

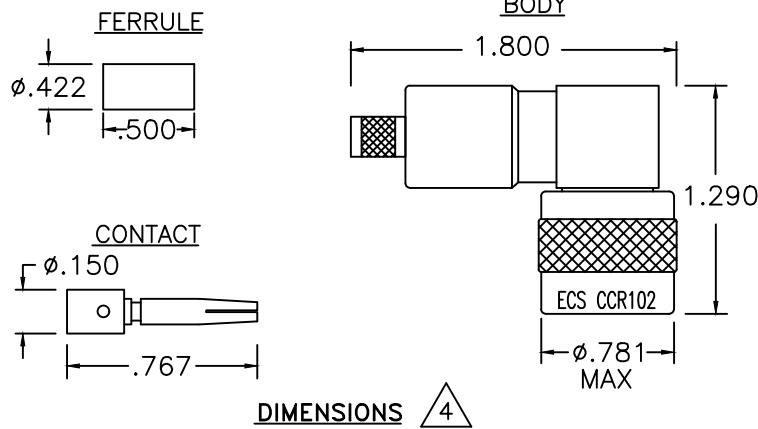


10. SLIDE THE FERRULE OVER THE BRAIDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING A M22520/5-51 DIE IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



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 CIT FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.



SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0-11 GHz
VSWR: 1.30:1 MAXIMUM DC TO 2GHz
INSERTION LOSS: 0.13dB MAXIMUM DC TO 2GHz
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-348B, FIGURE 302-1
TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP
OUTER CONTACT-FERRULE CRIMP

CABLE RETENTION: 50 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: BERYLLIUM COPPER PER ASTM B196
DIELECTRIC: TEFLON PER ASTM D1710
GASKET: SILICONE RUBBER PER A-A-59588
FINISHES
BODY, FERRULE AND OUTER CONTACT: BRIGHT NICKEL PER SAE-AMS-QQ-N-290
CONTACTS: GOLD PER MIL-DTL-45204

ALL LENGTHS IN INCHES		Amphenol Cable & Interconnect Technologies			
APPROVALS	DATE				
DRAWN BY: CRAIG KULAS	3/30/16	TITLE: CUSTOMER SPECIFICATION			
CHECKED BY: C CHAPMAN	4/11/16	C RIGHT ANGLE PLUG FOR CABLE 311001			
DESIGNED BY: C CHAPMAN	3/30/16	SIZE	CAGE CODE	LEVEL	PART NO.
PROJECT ENG: C CHAPMAN	4/11/16	B	66197		CCR102
ENG. MGR:		SCALE:	EFFECTIVITY:	SHEET: 1 OF 1	