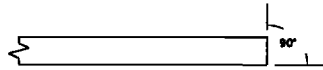


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INSTALLATION INSTRUCTIONS

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 ONLY L1 AND L3 AND TRIM EXCESS BRAID AT STEP 10.



3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBINGLE. ² 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 M22520/5-59 DIE (B 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.

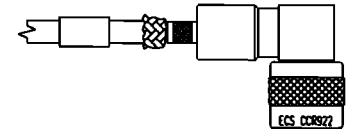


7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.

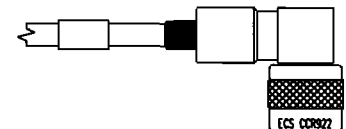


REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
40680	B2	C	ADDED FLAG NOTE 5	7/6/96	CAC

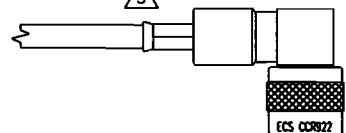
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



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



10. SLIDE THE FERRULE OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING AN M22520/5-59 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. ³

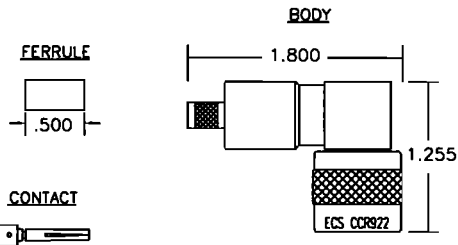


NOTES

1. ALL DIMENSIONS ARE IN INCHES.

- ² ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
³ ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION WI0007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
⁴ CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
⁵ WHEN TERMINATING TO 421601 CABLE CENTER CONTACT SHALL BE SOLDERED. DO NOT CRIMP.

APPROVALS		DATE	ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300			
DRAWN BY: KW HOFFMAN		8/3/95	TITLE: CUSTOMER SPECIFICATION			
CHECKED BY: M TAUBENHEIM		8/18/95	C RIGHT ANGLE PLUG FOR ECS CABLE 311601, 311501, 421601			
DESIGNED BY:			SIZE B	CAGE CODE 66197	LEVEL	PART NO. CCR922
PROJECT ENG:			SCALE:	FILE NO F:\ECSPEC\COMM\MST\CCR922	SHEET: 1 OF 1	
ENG. MGR: JB HACKETT		8/18/95				



DIMENSIONS ⁴

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 OR CRIMP
 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. 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