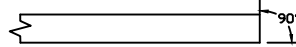


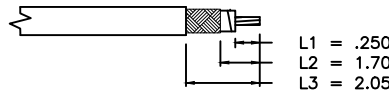
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**INSTALLATION INSTRUCTIONS**

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



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



- SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH Y1757 DIE. 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 FOIL BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.

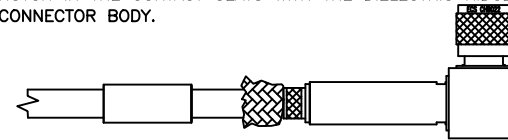


- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK OUTER SHIELD.

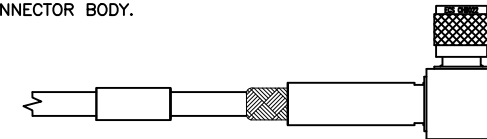


REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
18282	-	N/C	NEW RELEASE.	9/18/03	D KNOLL
19292	D4 C3 A4	A	CHANGED CONNECTOR DIMENSIONS CHANGED STRIP DIMENSIONS REMOVED CONTACT GASKET FROM MATERIALS	2/16/04	D KNOLL
79392	NTS	B	UPDATED MATERIAL SPEC UPDATED MATERIAL SPEC UPDATED FINISH SPEC UPDATED INSULATION RESISTANCE SPEC		

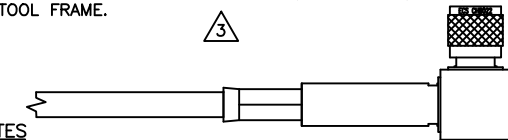
- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



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

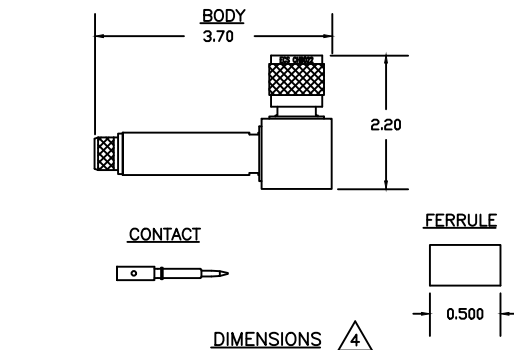


- SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING THE M22520/5-21 DIE (A HEX) IN A M22520/5-01 TOOL FRAME.



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



**SPECIFICATIONS**

**ELECTRICAL**

IMPEDANCE: 50 OHMS NOMINAL  
 FREQUENCY RANGE: 0-4 GHz  
 VSWR: 1.35:1 MAXIMUM  
 INSERTION LOSS: .1 dB MAXIMUM DC TO 2 GHz  
 WORKING VOLTAGE: 2500 VRMS @ -55°C AND 55,000 FT  
 DIELECTRIC WITHSTANDING: 5000 VRMS @ SEA LEVEL  
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM  
 @ 500 VOLTS DC

**MECHANICAL**

CONNECTOR INTERFACE DIMENSION PER MIL-STD-348B  
 FIGURE 317-1 WITH EXCEPTION OF CENTER CONTACT  
 AND DIELECTRIC. INTERFACE IS COMPATIBLE WITH HN JACK.  
 TERMINATION STYLE: CONTACT-SOLDER OR CRIMP  
 FERRULE-CRIMP

CABLE RETENTION: 50 LBS

**ENVIRONMENTAL**

TEMPERATURE RATING: -65° TO +165° C  
 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  
 CABLE CONTACT: BRASS PER ASTM B16  
 OUTER CONTACT AND CENTER CONTACT: BRASS PER ASTM B16  
 FEMALE CONTACT (REAR): BERYLLIUM COPPER PER ASTM B196.  
 DIELECTRIC: TEFLON PER ASTM D1710  
 GASKET: SILICONE RUBBER PER A-A-59588

**FINISHES**

BODY, FERRULE: BRIGHT NICKEL PER SAE-AMS-QQ-N-290  
 CENTER CONTACT: GOLD PER MIL-DTL-45204  
 CABLE CONTACT: GOLD PER MIL-DTL-45204

ALL LENGTHS IN INCHES		ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: T. SEROOGY II	09/18/03	HN RIGHT ANGLE PLUG WITH EXTENDED PIN CONTACT FOR ECS CABLE 310801	
CHECKED BY: DAVID E. KNOLL	09/18/03	SIZE: B	CAGE CODE: 66197
DESIGNED BY:		LEVEL:	ECS PART NO. CHB022
PROJECT ENG:		SCALE:	EFFECTIVITY:
ENG. MGR: DAVID E. KNOLL	09/18/03		SHEET: 1 OF 1