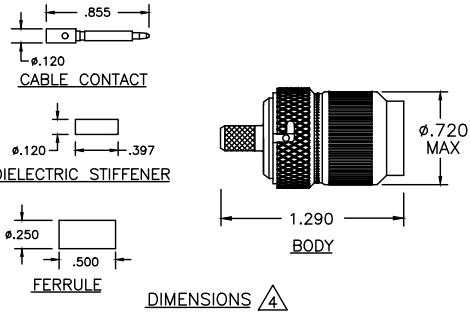


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**SPECIFICATIONS**  
ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL  
 FREQUENCY RANGE: 0-11 GHz  
 VSWR: 1.2:1 MAXIMUM DC TO 2GHz  
 INSERTION LOSS: .1dB 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 313-1  
 TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP  
 OUTER CONTACT-FERRULE CRIMP  
 CABLE RETENTION: 20 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  
 COUPLING & BACK NUT: 303 SST PER ASTM A582  
 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  
 COUPLING & BACK NUT: PASSIVATE PER SAE-AMS-2700

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**INSTALLATION INSTRUCTIONS**

- BEGIN BY CUTTING THE CABLE OFF SQUARE.
- STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L3. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.
- SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.  $\Delta$
- USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.
- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.
- REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK APPROXIMATELY .60 INCHES FROM THE END OF THE CONDUCTOR. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR. THERMAL STRIPPERS ARE RECOMMENDED.
- INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR, ENSURING THAT IT IS BUTTED AGAINST THE CABLE DIELECTRIC.
- SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-57 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUE USING AN APPROPRIATE FLUX CLEANER.

| REVISIONS |      |      |                      |         |          |
|-----------|------|------|----------------------|---------|----------|
| ECN       | ZONE | REV. | DESCRIPTION          | DATE    | APPROVED |
| 57691     |      | N/C  | NEW RELEASE          | 1/14/16 | CAC      |
| 76556     | B1   | A    | DELETED ECS CLTS3522 |         |          |
|           | C1   |      | DELETED ECS CLTS3522 | 7/10/20 | R Lay    |

- 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.

- FOLD BOTH BRAIDS 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 A M22520/5-57 DIE (A HEX) TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.  $\Delta$

**NOTES**

- ALL DIMENSIONS ARE IN INCHES.
- $\Delta$  ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- $\Delta$  ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- $\Delta$  CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

|                            |         |  |              |               |          |
|----------------------------|---------|--|--------------|---------------|----------|
| ALL LENGTHS IN INCHES      |         | <b>CARLISLE</b> Carlisle Interconnect Technologies<br>Franklin, WI 53132<br>414-421-5300 |              |               |          |
| APPROVALS                  | DATE    | TITLE: CUSTOMER SPECIFICATION  |              |               |          |
| DRAWN BY:<br>CRAIG KULAS   | 12/3/15 | LOCKING TNC STRAIGHT PLUG FOR 352001 CABLE   |              |               |          |
| CHECKED BY:<br>R. LAY      | 1/14/16 | SIZE   | CAGE CODE    | LEVEL         | PART NO. |
| DESIGNED BY:<br>R. LAY     | 12/3/15 | B  | 66197        |               | CLTS3522 |
| PROJECT ENG:<br>C. CHAPMAN | 1/14/16 | SCALE:   | EFFECTIVITY: | SHEET: 1 OF 1 |          |
| ENG. MGR:<br>D. KNOLL      | 1/14/16 |  |              |               |          |