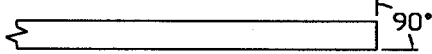



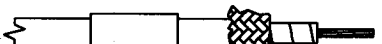





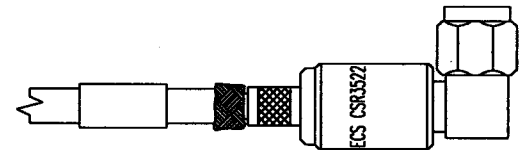
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INSTALLATION INSTRUCTIONS

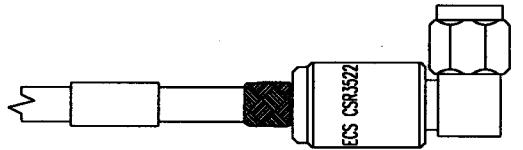
- BEGIN BY CUTTING THE CABLE OFF SQUARE.
 
- STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.
 
- SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.
 
- 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 OUTER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.
 
- REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK, TO THE BEGINNING OF THE FOLDED BACK SHIELD, APPROXIMATELY .60 INCHES FROM THE END OF THE CENTER 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 M22520/5-11 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.
 

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
2941		N/C	NEW RELEASE	5/20/99	MCT
14171		A	SEE ECN	9/19/01	CAC
30364		B	CHANGED CONN DESIGN AND STRIP DIM'S	9/20/07	QJK

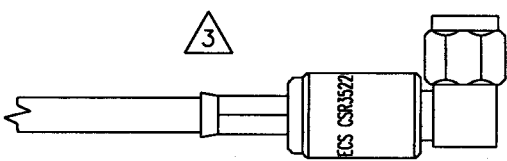
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



10. FOLD BOTH BRAIDS UP OVER THE NECK OF THE CONNECTOR BODY.

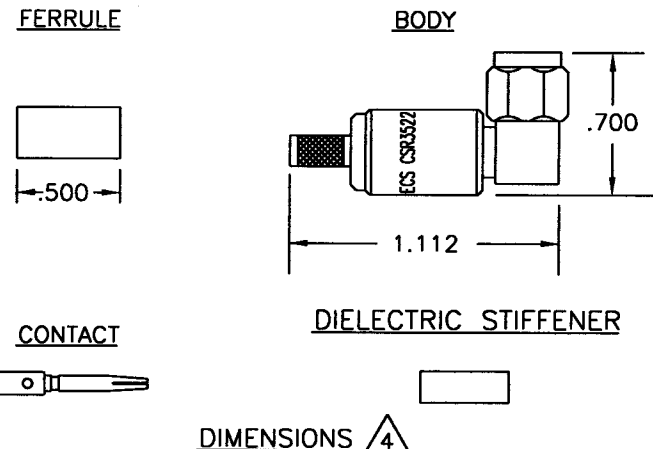


11. SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING THE M22520/5-11 DIE (A HEX) IN A M22520/5-01 TOOL FRAME.



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: 0-18 GHz
 VSWR: 1.05 + .07(FGHz) MAX
 INSERTION LOSS: .07 √FGHz dB MAX
 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-348A, FIGURE 310-1 (SMA)
 TERMINATION STYLE: CENTER INNER CONTACT-SOLDER OR CRIMP FERRULE-CRIMP

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: STAINLESS STEEL PER SAE-AMS-QQ-S-763
 FERRULE: ANNEALED, BRASS PER ASTM B16 OR COPPER PER ASTM B124
 CENTER CONTACT: BRASS PER ASTM B16
 CABLE CONTACT: BERYLLIUM COPPER PER ASTM B196
 INNER BODY DIELECTRIC: TEFLON PER ASTM D1710
 GASKET: SILICONE RUBBER PER ZZ-R-765

FINISHES
 BODY: PASSIVATED
 FERRULE: BRIGHT NICKEL PER QQ-N-290
 CABLE AND CENTER CONTACTS: GOLD PER MIL-G-45204

ALL LENGTHS IN INCHES		 ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300			
APPROVALS	DATE	TITLE			
DRAWN BY C CHAPMAN	05/14/99	CUSTOMER SPECIFICATION SMA 90° PLUG FOR ECS 352001			
CHECKED BY C CHAPMAN	05/20/99				
DESIGNED BY:		SIZE	CAGE CODE	LEVEL	ECS PART NO.
PROJECT ENG: M TAUBENHEIM	05/20/99	B	66197		CSR3522
ENG. MGR: P JOBE	05/20/99	EFFECTIVITY:			SHEET 1 of 1