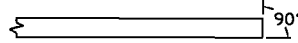


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INSTALLATION INSTRUCTIONS

- 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.



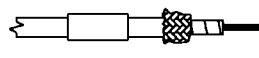
- SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.



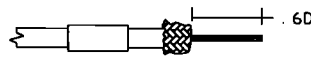
- USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



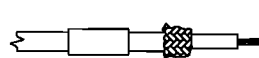
- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OUTER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.



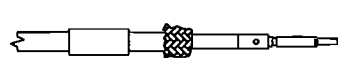
- REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK, TO THE BEGINNING OF THE FOLDED BACK SHIELD, APPROXIMATELY .60 INCHES FROM THE END OF THE CENTER CONDUCTOR. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR. THERMAL STRIPPERS ARE RECOMMENDED.



- INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR, ENSURING THAT IT IS BUTTED AGAINST THE CABLE DIELECTRIC.



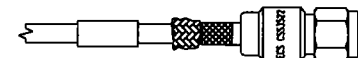
- SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-11 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



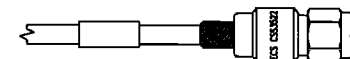
REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
6188	-	N/C	NEW RELEASE	9/16/98	MCT
12899	-	A	SEE ECN	9/14/01	C CHAPMAN
22534	C4	B	CHANGED CONNECTOR AND CONTACT DESIGN CHANGED TERMINATION INSTRUCTIONS	5/10/05	DEK
41321	-	C	REVISE PICTORIAL OF CONN, DIM WAS 1.067	9/28/10	DS/L

- 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.

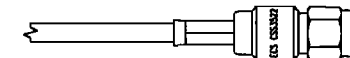
CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT, TO AVOID KINKING THE CABLE.



- FOLD BOTH 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 AN M22520/5-11 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. **2**



NOTES

- 1** ENSURE HEATSHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- 2** ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- 3** CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

APPROVALS		DATE	ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
DRAWN BY: M TAUBENHEIM		09/16/98	TITLE CUSTOMER SPECIFICATION SMA STRAIGHT PLUG FOR ECS CABLE 352001	
CHECKED BY: C CHAPMAN		09/16/98		
DESIGNED BY:			SIZE	CAGE CODE
PROJECT ENG: M TAUBENHEIM		09/16/98	B	66197
ENG. MGR. PETER JOBE		06/04/99	LEVEL	PART NO.
			C	CSS3522
SCALE:		FILE NO. F:\E\SPEC\CONN\INST\CSS3522	SHEET 1 OF 1	

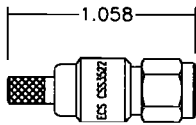
FERRULE



CONTACT



BODY



DIELECTRIC STIFFENER



DIMENSIONS **3**

SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-18 GHz
 VSWR: 1.05 + .05 FGHz. MAXIMUM
 INSERTION LOSS: .03√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: CABLE CONTACT-SOLDER OR CRIMP FERRULE CRIMP
 CABLE RETENTION: 20 LBS

ENVIRONMENTAL

TEMPERATURE RATING: -65° TO +165° C
 VIBRATION: MIL-STD-202, METHOD 204, COND. D
 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 QQ-S-763
 FERRULE: ANNEALED BRASS PER ASTM B16 OR COPPER PER ASTM B124
 CENTER CONTACT: BRASS PER QQ-B-626
 DIELECTRIC: TEFLON PER L-P-403
 GASKET: SILICON RUBBER PER ZZ-R-765

FINISHES

FERRULE: BRIGHT NICKEL PER QQ-N-290
 CABLE CONTACT: GOLD PER MIL-G-45204