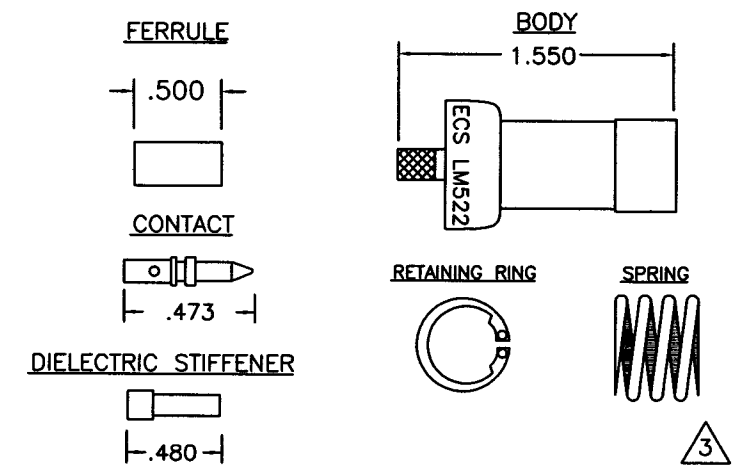


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SPECIFICATIONS

ELECTRICAL
 IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-6 GHz
 VSWR: 1.70:1 MAXIMUM
 INSERTION LOSS: 0.3 dB @ 6 GHz
 DIELECTRIC WITHSTANDING: 2500 VRMS @ SEA LEVEL
 WORKING VOLTAGE: 1000 VRMS @ SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

MECHANICAL
 MECHANICAL INTERFACE PER ARINC SPEC 600 FIGURE 19-54.2
 TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP
 OUTER CONTACT-FERRULE CRIMP
 CABLE RETENTION: 20 LBS

ENVIRONMENTAL
 TEMPERATURE RATING: -65° TO +200°
 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
 CABLE CONTACT: BRASS PER ASTM B16
 CENTER CONTACT: BERYLLIUM COPPER PER ASTM B196
 DIELECTRIC: TEFLON PER ASTM D1710

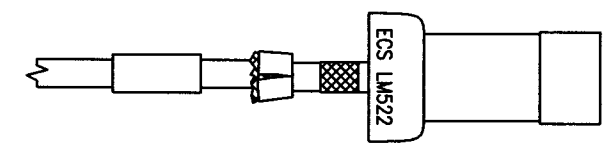
FINISHES
 FERRULE: BRIGHT NICKEL PER QQ-N-290
 BODY, CENTER CONTACT: GOLD PER MIL-G-45204

INSTALLATION INSTRUCTIONS

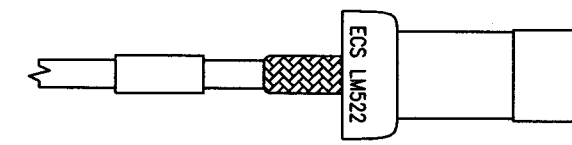
- BEGIN BY CUTTING THE CABLE OFF SQUARE. 90°
- STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED. L1 = .25
L2 = .70
- SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE. 1
- USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.
- SLIT FOIL LONGITUDINALLY AND FOLD BACK OVER THE OTHER SHIELD.
- 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. LEAVE APPROXIMATELY .09 INCHES OF DIELECTRIC ON THE CABLE FOR THE CUP IN THE STIFFENER. .09 | .60
- INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR AND THE CABLE DIELECTRIC MAKING SURE THAT CABLE DIELECTRIC IS FULLY SEATED INSIDE CUPPED END OF DIELECTRIC STIFFENER.
- ENSURE THAT THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. TERMINATE CONTACT USING METHOD A OR B.
 - SOLDER CONTACT ONTO CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER. CLEAN FLUX RESIDUE USING APPROPRIATE CLEANER.
 - CRIMP CONTACT ONTO CENTER CONDUCTOR USING A M22520/5-09 DIE (B HEX). IN A M22520/5-01 TOOL FRAME.

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
13939	-	N/C	NEW RELEASE	7/6/01	D. KNOLL
17356	-	A	CHANGED STIFFENER AND STRIPPING DIM'S	4/16/03	D. Knoll

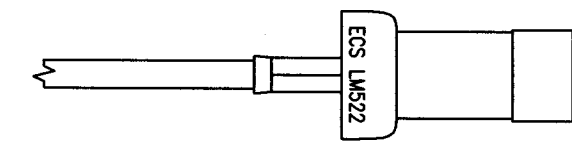
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CONTACT UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR. **CAUTION:** PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



10. FOLD BOTH SHIELDS BACK 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 A M22520/5-09 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



NOTES

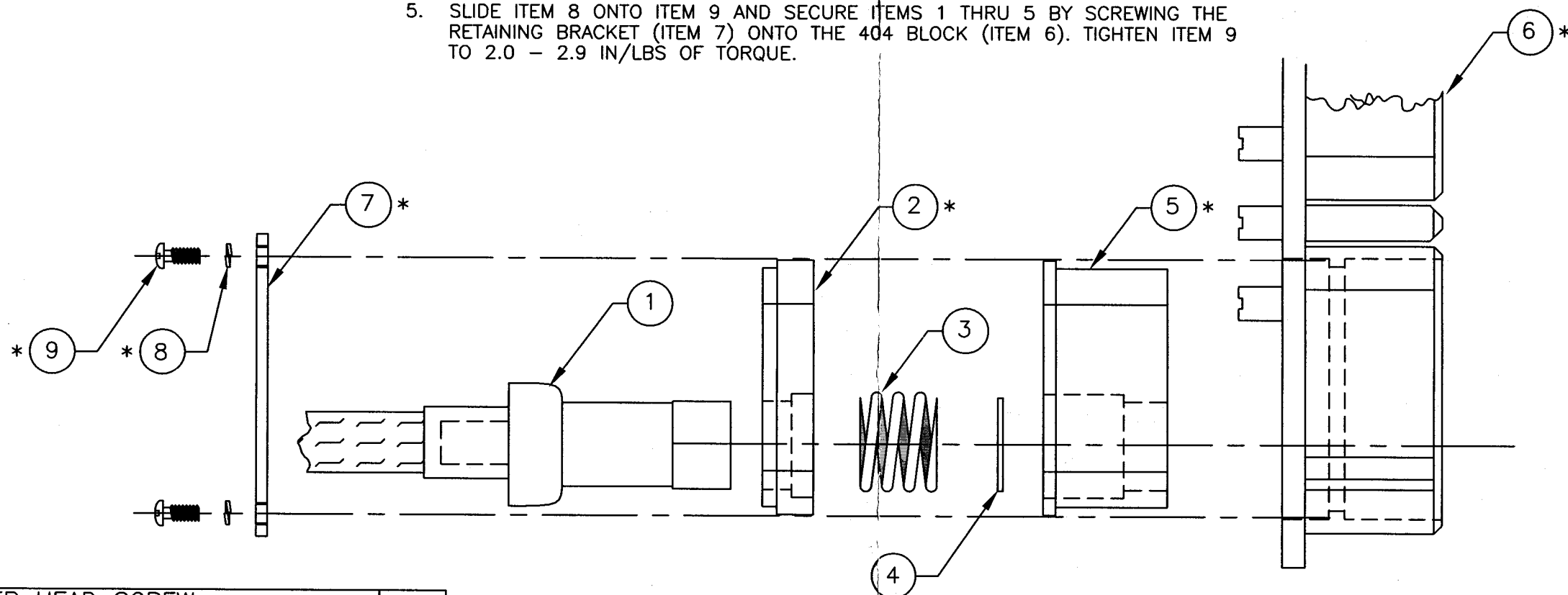
- 1 ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- 2 ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- 3 CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

ALL LENGTHS IN INCHES		ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: P PHALPHOUVONG	06/11/01	SIZE 1, ARINC 404 RF CONNECTOR FOR ECS CABLE 432101 AND 532101	
CHECKED BY: C CHAPMAN	7/6/01	SIZE	CAGE CODE
DESIGNED BY:		B	66197
PROJECT ENG:		LEVEL	PART NO.
ENG. MGR: DAVID E. KNOLL	7/6/01		LM522
SCALE:		FILE NO. F:\E\SPEC\CONN\INST\LM522-1-1	SHEET: 1 OF 2

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INSTALLATION INSTRUCTIONS—RETAINING HARDWARE

1. REMOVE THE FOUR SCREWS (ITEM 9) FROM THE 404 BLOCK (ITEM 6) SO THAT ONE OF THE RETAINING BRACKETS (ITEM 7) CAN BE REMOVED. REMOVE ITEM 2 AND ITEM 5 FROM THE CAVITY OF ITEM 6.
2. SLIDE RETAINING BRACKET (ITEM 7) OVER CONNECTOR AND ONTO CABLE.
3. SLIDE ITEMS 2 THRU 4 OVER THE END OF ITEM 1 IN THE ORDER SHOWN UNTIL ITEM 4 SNAPS INTO THE GROOVE OF ITEM 1. REPEAT STEPS 1 AND 2 FOR THE REMAINING CONNECTORS ENSURING THAT EACH CONNECTOR GOES INTO THE CORRECT JACK.
4. INSERT ITEM 1 AND ITS ACCOMPANYING HARDWARE INTO ITEM 5 WHILE OBSERVING PROPER POLARITY OF JACK LOCATIONS. INSERT ITEMS 1 THRU 5 INTO ITEM 6.
5. SLIDE ITEM 8 ONTO ITEM 9 AND SECURE ITEMS 1 THRU 5 BY SCREWING THE RETAINING BRACKET (ITEM 7) ONTO THE 404 BLOCK (ITEM 6). TIGHTEN ITEM 9 TO 2.0 - 2.9 IN/LBS OF TORQUE.



ITEM NUMBER	DESCRIPTION	QTY EACH
9	FILLISTER HEAD SCREW	*
8	LOCK WASHER	*
7	RETAINING BRACKET	*
6	ARINC 404 SHELL (CUT AWAY VIEW)	*
5	FRONT BLOCK	*
4	RETAINING RING	1
3	SPRING	1
2	REAR BLOCK	*
1	LM TYPE CONNECTOR (ATTACHED TO CABLE)	1

NOTES:

1. ASSEMBLE CONNECTOR BODY TO THE CABLE PER SHEET 1 THIS DRAWING.
- * NOT SUPPLIED WITH LM-SERIES CONNECTOR, QUANTITIES WILL VARY PER ARINC 404 CAVITY.

		ELECTRONIC CABLE SPECIALISTS	
		FRANKLIN, WI 53132 PHONE: (414) 421-5300	
SIZE	CAGE CODE	LEVEL	PART NO.
B	66197		LM522
SCALE:		FILE NO. F:\E\SPEC\CONN\INST\LM3522-2	SHEET: 2 OF 2