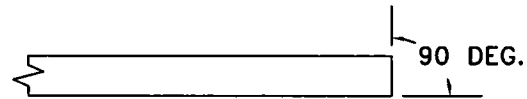


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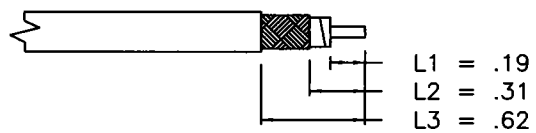
INSTALLATION INSTRUCTIONS

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
26602	-	N/C	NEW RELEASE.	10/2/06	<i>[Signature]</i>

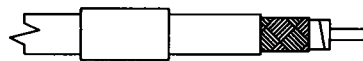
1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



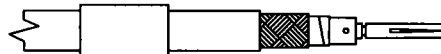
2. WHEN USING AUTOMATIC STRIPPING EQUIPMENT, STRIP CABLE AS SHOWN STARTING WITH L1 AND ENDING WITH L3. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. IF AUTOMATIC STRIPPING EQUIPMENT IS NOT AVAILABLE, STRIP L1 AND L3 ONLY AND TRIM EXCESS BRAID AT STEP 10.



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



4. 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.



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



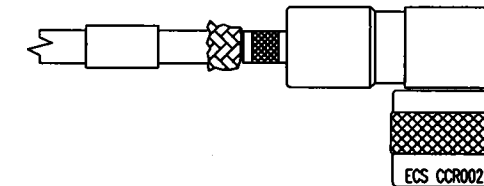
6. SLICE THE ALUMINUM/POLYESTER FOIL LENGTHWISE ABOUT EVERY 1/8". GENTLY ROTATE PIN TO SEPARATE THE FLAT FOIL BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.



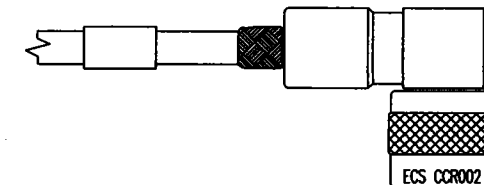
7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER BRAIDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: TAKE CARE NOT TO UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.



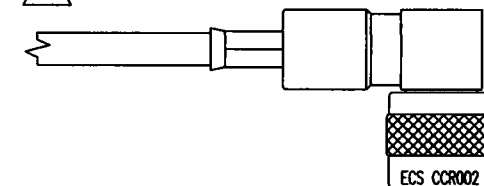
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CONTACT UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR.



9. FOLD ALL BRAIDS UP OVER THE NECK OF THE CONNECTOR BODY.



10. SLIDE THE FERRULE OVER THE BRAIDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING A M22520/5-31 DIE 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 W10007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- 3. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

D

D

C

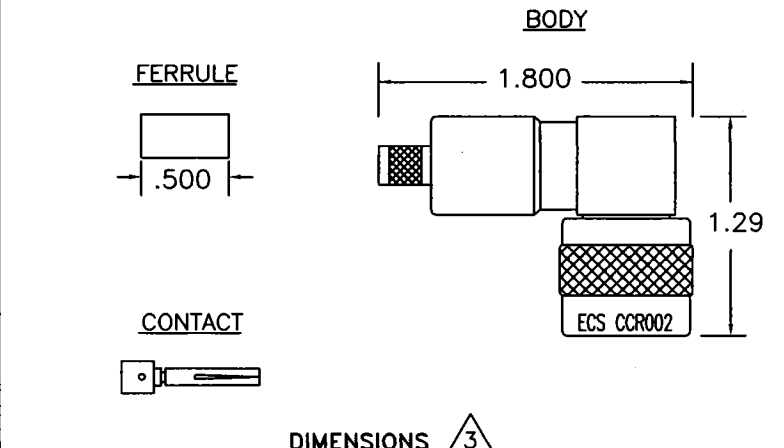
C

B

B

A

A



SPECIFICATIONS

ELECTRICAL
IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0-11 GHz
VSWR: 1.30:1 MAXIMUM
INSERTION LOSS: .1 dB MAX @ DC TO 2 GHz
WORKING VOLTAGE: 1000 VRMS @ SEA LEVEL
DIELECTRIC WITHSTANDING: 3000 VRMS @ SEA LEVEL
INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

MECHANICAL
CONNECTOR INTERFACE DIMENSION PER MIL-STD-348A FIGURE 302-1
TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP
OUTER CONTACT-FERRULE CRIMP
CABLE RETENTION: 50 LBS

ENVIRONMENTAL
TEMPERATURE RATING: -65 TO +165 DEG. 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 QQ-B-626
FERRULE: ANNEALED BRASS PER QQ-B-626
CABLE CONTACT: BERYLLIUM COPPER PER QQ-C-530
CENTER CONTACT: BRASS PER QQ-B-626
OUTER CONTACT: BERYLLIUM COPPER PER QQ-C-530
DIELECTRIC: TEFLON PER L-P-403
GASKET: SILICONE RUBBER PER ZZ-R-765

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

ALL LENGTHS IN INCHES		ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: C CHAPMAN	9/28/06	C RIGHT ANGLE PLUG FOR ECS CABLE 310701	
CHECKED BY: <i>[Signature]</i>	10/2/06	SIZE: B	CAGE CODE: 66197
DESIGNED BY:		LEVEL:	PART NO.: CCR002
PROJECT ENG:		SCALE:	FILE NO: F:\E\SPEC\CONN\INST\CCR002
ENG. MGR: <i>[Signature]</i>	10/2/06	SHEET: 1 OF 1	