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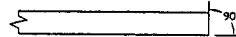
 DWG NO. **BTS722-1** SH **1** REV. **A**

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INSTALLATION INSTRUCTIONS

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 ONLY L1 AND L3 AND TRIM EXCESS BRAID AT STEP 10.



3. SLIDE THE FERRULE AND ADHESIVE 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 M22520/5-57 DIE (B HEX). 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.



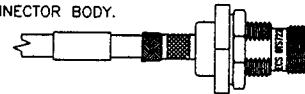
7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OUTER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.



REVISIONS

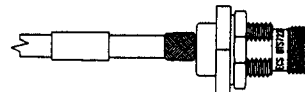
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
6188		N/C	NEW RELEASE	9/10/98	MCT
13273		A	SEE ECN	7/24/01	ccl/pma

8. 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.

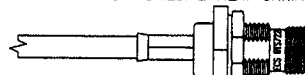


CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT, TO AVOID KINKING THE CABLE.

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



10. 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 M22520/5-57 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



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 W10007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
- INSTALL MOUNTING SEAL, LOCK WASHER AND JAMNUT IN ORDER SHOWN.
- DELETED.
- DELETED.
- PICTORIALS SHOW CONNECTOR INSTALLATION ON 311901 CABLE. WHEN INSTALLING THIS CONNECTOR ON 3C142B OR 3C058A THERE ARE ONLY 2 BRAID SHIELDS WHICH SHOULD BE FOLDED BACK AS SHOWN IN STEP 5 AND STEP 6 WOULD BE OMITTED.

APPROVALS		DATE	ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300			
DRAWN BY: E ANDERSON		10/22/97	TITLE: CUSTOMER SPECIFICATION			
CHECKED BY: C CHAPMAN		10/22/97	TNC BULKHEAD JACK FOR ECS CABLE 3C142B, 311901, AND 3C058A			
DESIGNED BY:			SIZE	CAGE CODE	LEVEL	PART NO.
PROJECT ENG: M TAUBENHEIM		9/10/98	B	66197		BTS722
ENG. MGR: P JOBE		6/4/99	SCALE:	FILE NO F:\ECSPEC\CONM\NST\BTS722	SHEET: 1 OF 1	

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