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DWG NO.	M5122-1	SH	1	REV.	N/C
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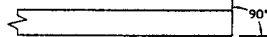
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INSTALLATION INSTRUCTIONS

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
13939		N/C	NEW RELEASE	7/6/01	<i>[Signature]</i>

1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



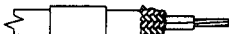
2. STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE **NOT** TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.



3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE. ¹



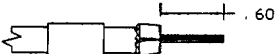
4. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



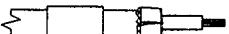
5. SLIT FOIL LONGITUDINALLY AND FOLD BACK OVER THE OTHER SHIELD.



6. 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.



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



8. ENSURE THAT THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. TERMINATE PER CONTACT PER OPTION a OR b BELOW.

- a) SOLDER CONTACT **ONTO** CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER. CLEAN FLUX RESIDUE USING APPROPRIATE CLEANER.
b) CRIMP CONTACT **ONTO** CENTER CONDUCTOR USING A M22520/5-09 DIE (B HEX).



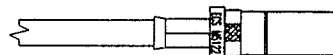
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR. **CAUTION:** PUSH CABLE INTO THE CONDUCTOR STRAIGHT TO AVOID KINKING THE CABLE.



10. FOLD ALL THE BRAIDS 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. ²



NOTES

- ¹ ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
² ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
³ CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: P. PHALPHOUVONG	06/12/01	MODIFIED SIZE 1, ARINC 600 RF	
CHECKED BY: C. Chapman	7/6/01	CONNECTOR FOR ECS CABLE 432101 AND 532101	
DESIGNED BY:		SIZE	CAGE CODE
		B 66197	
PROJECT ENG:		LEVEL	PART NO.
			M5122
ENG. MGR: Randy Hand	7/6/01	SCALE:	FILE NO: FILE/SPEC/CONN/INST/M5122-1-1 SHEET: 1 OF 3

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