

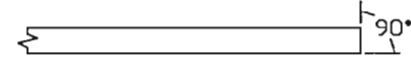
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REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
2975		N/C	NEW RELEASE	8/18/95	JBH
4443		A	SEE ECN# 4443	8/13/96	JBH
6189		B	SEE ECN# 6189	9/10/98	MCT
12885		C	SEE ECN	12/7/00	CAC
13466		D	SEE ECN	7/23/01	CAC
49716	C,D	4	ADDED DIMENSIONS	2/1/13	CAC

INSTALLATION INSTRUCTIONS

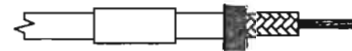
- BEGIN BY CUTTING THE CABLE OFF SQUARE.
- STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.



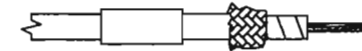
- SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.



- 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 OTHER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.



- 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.



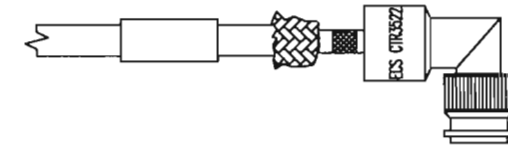
- INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR, ENSURING THAT IT IS BUTTED AGAINST THE CABLE DIELECTRIC.



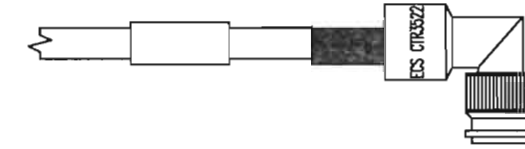
- SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-11 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUE USING AN APPROPRIATE FLUX CLEANER.



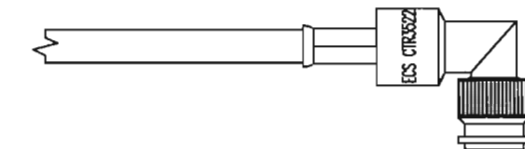
- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE RIDGE INSIDE THE CONNECTOR DIELECTRIC. CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



- FOLD BOTH BRAIDS OVER THE NECK OF THE CONNECTOR BODY.

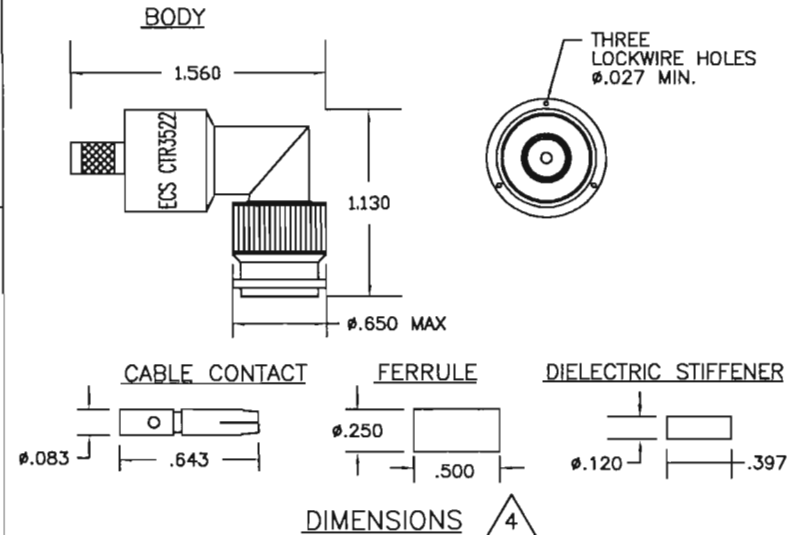


- SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING A M22520/5-11 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



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.
- DELETED.
- DELETED.



SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0-11 GHz
VSWR: 1.2:1 MAXIMUM DC TO 2GHz
INSERTION LOSS: .1dB MAXIMUM DC TO 2GHz
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 313-1
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. 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 AND OUTER CONTACT: BRIGHT NICKEL PER QQ-N-290
CENTER CONTACT: GOLD PER MIL-G-45204

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: KW HOFFMAN	8/3/95	TNC RIGHT ANGLE PLUG FOR ECS CABLE 352001	
CHECKED BY: M TAUBENHEIM	8/18/95	SIZE: B	CAGE CODE: 66197
DESIGNED BY:		LEVEL:	PART NO. CTR3522
PROJECT ENG:		SCALE:	EFFECTIVITY:
ENG. MGR: JB HACKETT	8/18/95	SHEET: 1 OF 1	