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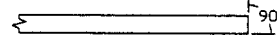
DWG NO.	BNS522-1	SH	1	REV.	N/C
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INSTALLATION INSTRUCTIONS

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.



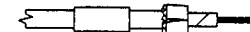
3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.



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



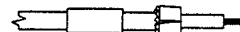
5. SLIT FOIL LONGITUDINALLY AND FOLD BACK OVER THE OTHER SHIELD.



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.



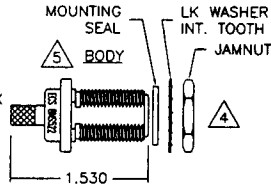
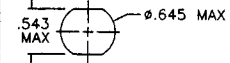
8. ENSURE THAT THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. TERMINATE CONTACT PER OPTION a OR b BELOW.

- 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).



REVISIONS					
ECH	ZONE	REV.	DESCRIPTION	DATE	APPROVED
13939		N/C	NEW RELEASE.	7/6/01	David G. Knoll

MOUNTING HOLE SIZE



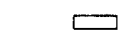
FERRULE



CONTACT



DIELECTRIC STIFFENER



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: 1000 VRMS @ SEA LEVEL
 DIELECTRIC WITHSTANDING: 1500 VRMS @ SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM
 MECHANICAL: 500 VOLTS DC

CONNECTOR INTERFACE DIMENSION PER MIL-STD-348A FIGURE 304-2

TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP
 OUTER CONTACT-FERRULE CRIMP

CABLE RETENTION: 20 LBS

ENVIRONMENTAL

TEMPERATURE RATING: -65° TO +165°
 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

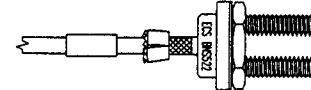
MATERIALS

BODY: BRASS PER ASTM B16
 FERRULE: ANNEALED BRASS PER ASTM B16
 CENTER CONTACT: BERYLLIUM COPPER PER ASTM B196
 DIELECTRIC: TEFLON PER ASTM D1710
 GASKET: SILICON RUBBER PER ZZ-R-765

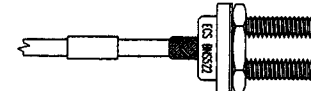
FINISHES

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

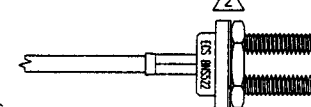
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE RIDGE INSIDE THE CONNECTOR DIELECTRIC. **CAUTION:** PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



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.
 4. INSTALL MOUNTING SEAL, BULKHEAD, LOCK WASHER AND JAMNUT IN ORDER SHOWN.

ALL LENGTHS IN INCHES

APPROVALS	DATE
DRAWN BY: V. LEX	6/19/01
CHECKED BY: C. Chapman	7/5/01
DESIGNED BY:	
PROJECT ENG:	
ENG MGR: David G. Knoll	7/6/01

ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300			
TITLE: CUSTOMER SPECIFICATION			
N BULKHEAD JACK FOR ECS CABLE 432101 AND 532101			
SIZE	CAGE CODE	LEVEL	PART NO.
B	66197		BNS522
SCALE:		F:\STORAGE\E\SPEC\CONN\INST\BNS522	
SHEET: 1		OF 1	

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