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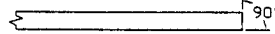
DWG NO. CNR3522-1 SH 1 REV. E

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INSTALLATION INSTRUCTIONS

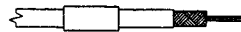
1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



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.



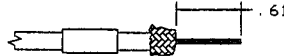
4. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



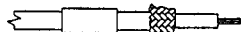
5. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.



6. REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK TO THE BEGINNING OF THE FOLDED BACK SHIELD, APPROXIMATELY .61 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.



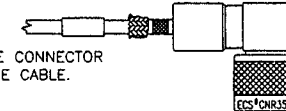
8. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-57 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.


REVISIONS

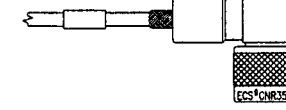
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
2352		N/C	RELEASED BY ECN# 2352	1/20/95	JBH
2808	A	SEE ECN# 2808		4/12/95	JBH
4449	B	SEE ECN# 4449		8/13/96	JBH
6189	C	SEE ECN# 6189		9/10/98	MCT
12890	D	SEE ECN		12/7/00	CAC
13279	E	SEE ECN		7/23/01	<i>Chapman</i>

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.

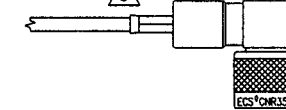
CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT, TO AVOID KINKING THE CABLE.



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

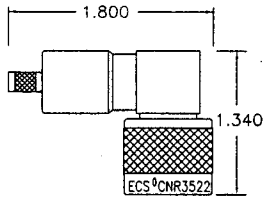


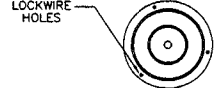
11. SLIDE THE FERRULE OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING AN M22520/5-57 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.


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 W0007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
- DELETED.
- DELETED.

APPROVALS		DATE	ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
DRAWN BY: JB HACKETT		1/11/95	TITLE: CUSTOMER SPECIFICATION N TYPE RIGHT ANGLE PLUG FOR ECS CABLE 352001	
CHECKED BY: T MEYERS		1/20/95		
DESIGNED BY:			SIZE: B CAGE CODE: 66197 LEVEL: PART NO.: CNR3522	A
PROJECT ENG: H STOIBER		1/20/95	SCALE: FILE NO: F:\E\SPEC\CONN\INST\CNR3522 SHEET: 1 OF 1	
ENG. MGR: JB HACKETT		1/20/95		

CABLE CONTACT
BODY

FERRULE

DIELECTRIC STIFFENER

DIMENSIONS

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: 2500 VRMS @ SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM
 @ 500 VOLTS DC

MECHANICAL

CONNECTOR INTERFACE: DIMENSIONS PER MIL-STD-348A
 FIGURE 304-1

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. 1
 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
 CENTER CONTACT: BRASS PER QQ-B-626
 CABLE CONTACT: BERYLLIUM COPPER PER QQ-C-530
 OUTER CONTACT: BRASS PER QQ-B-626
 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

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