

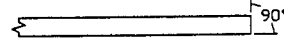
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REVISIONS

ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
2941		N/C	NEW RELEASE	5/20/99	MCT
14171		A	SEE ECN	9/19/01	C Chapman

INSTALLATION INSTRUCTIONS

- BEGIN BY CUTTING THE CABLE OFF SQUARE.



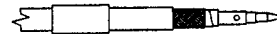
- WHEN USING AUTOMATIC STRIPPING EQUIPMENT, STRIP CABLE AS SHOWN STARTING WITH L1 AND ENDING WITH L3. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. IF AUTOMATIC STRIPPING EQUIPMENT IS NOT AVAILABLE, STRIP ONLY L1 AND L3 AND TRIM EXCESS BRAID AT STEP 9.



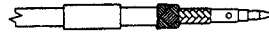
- SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE



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



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

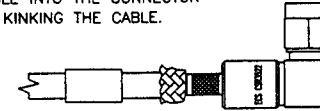


- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.

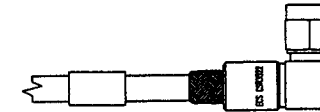


- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE RIDGE OF THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR.

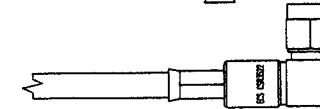
CAUTION: PUSH CABLE INTO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



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



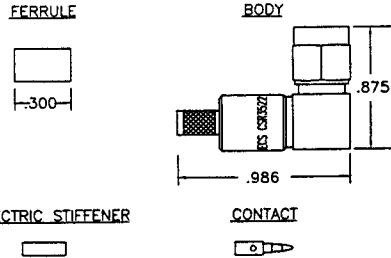
- SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING THE M22520/5-11 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



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 W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

DIMENSIONS



SPECIFICATIONS

ELECTRICAL
 IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-18 GHz
 VSWR: 1.05 ± .05 MAXIMUM
 INSERTION LOSS: .03 dBGHz dB MAX.
 WORKING VOLTAGE: 500 VRMS @ SEA LEVEL
 DIELECTRIC WITHSTANDING: 1500 VRMS @ SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

MECHANICAL
 CONNECTOR INTERFACE DIMENSION PER MIL-STD-348A FIGURE 310-1
 TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP
 OUTER CONTACT-FERRULE CRIMP
 CABLE RETENTION: 20 LBS

ENVIRONMENTAL
 TEMPERATURE RATING: -65° TO +165° C
 VIBRATION: MIL-STD-202, METHOD 204, COND. D
 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, OUTER CONTACT: STAINLESS STEEL PER QQ-S-763
 FERRULE: ANNEALED BRASS PER QQ-B-626
 CABLE CONTACT: BRASS PER QQ-B-626
 CONN. CONTACT: BERYLLIUM COPPER PER QQ-C-530
 DIELECTRIC: TEFLON PER L-P-403
 GASKET: SILICON RUBBER PER ZZ-R-765

FINISHES
 BODY: STAINLESS STEEL PER QQ-S-763
 CONTACTS: GOLD PER MIL-G-45204

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE	
DRAWN BY C CHAPMAN	05/14/99	CUSTOMER SPECIFICATION	
CHECKED BY C CHAPMAN	05/20/99	SMA 90° PLUG FOR ECS CABLE 352001	
DESIGNED BY:		SIZE	CAGE CODE
PROJECT ENG: M TAUBENHEIN	05/20/99	B	66197
ENG. MGR: P JOBE	06/04/99	LEVEL	PART NO.
			CSR3522
		FILE NO. F:\E\SPEC\CONN\INST\CSR3522 SHEET 1 OF 1	