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OWG NO.	LM722-1	SH	REV.
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INSTALLATION INSTRUCTIONS

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
6188		N/C	NEW RELEASE.	9/15/98	MCT
12962		A	SEE ECN	8/6/01	<i>C Chapman</i>

- 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 10.

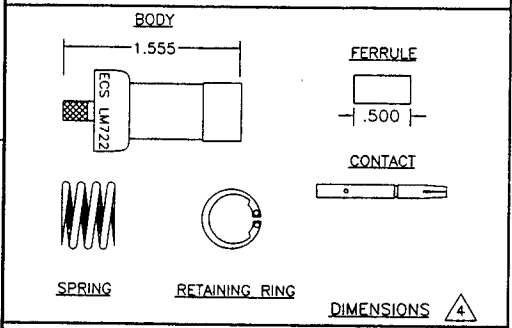
- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.

- 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 M22520/5-57 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 W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
- DELETED.
- DELETED.
- PICTORIALS SHOW CONNECTOR INSTALLATION ON ECS 311901 CABLE. WHEN INSTALLING THIS CONNECTOR ON 3C142B OR 3C058A THERE ARE ONLY ONLY 2 BRAID SHIELDS WHICH SHOULD BE FOLDED BACK AS SHOWN IN STEP 5 AND STEP 6 WOULD BE OMITTED.



SPECIFICATIONS

ELECTRICAL
 IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-6 GHz
 VSWR: 1.70:1 MAXIMUM
 WORKING VOLTAGE: 1000 VRMS @ SEA LEVEL
 INSERTION LOSS: 0.3 dB @ 6 GHz
 DIELECTRIC WITHSTANDING: 2500 VRMS @ SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

MECHANICAL
 MECHANICAL INTERFACE PER ARINC SPEC 600
 FIGURE 19-54.2
 TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP
 OUTER CONTACT-FERRULE CRIMP
 CABLE RETENTION: 30 LBS

ENVIRONMENTAL
 TEMPERATURE RATING: -65° TO +200°
 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
 CENTER CONTACT: BERYLLIUM COPPER PER QQ-C-530
 DIELECTRIC: TEFLON PER L-P-403

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

- SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.
- 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 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.
- SLICE THE ALUMINUM/POLYESTER FOIL LENGTHWISE ABOUT EVERY 1/8". GENTLY ROTATE PIN TO SEPARATE THE FLAT FOIL BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.
- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OUTER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: C CHAPMAN	09/04/98	SIZE 1, ARINC 404 RF CONNECTOR FOR ECS CABLE 311901, 3C142B, AND 3C058A	
CHECKED BY: C CHAPMAN	09/15/98	SIZE	CAGE CODE
DESIGNED BY:		B 66197	LEVEL
PROJECT ENG: M TAUBENHEIN	9/15/98	PART NO. LM722	
ENG. MGR: P JOBE	6/4/99	SCALE:	FILE NO. F:\E\SPEC\CONN\INST\LM722
		SHEET: 1 OF 2	

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