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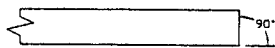
DWG NO.	SH	REV.
M0122-1	1	A

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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 10.



- 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 A Y1757 DIE. 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 OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.



REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
6188		N/C	NEW RELEASE.	9/15/98	MCT
12963		A	SEE ECN	8/14/01	Don B. Head

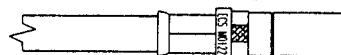
- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR.



- FOLD ALL THE 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 M22520/5-21 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.

ALL LENGTHS IN INCHES		ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: C CHAPMAN	09/04/98	MODIFIED SIZE 1, ARINC 600 RF CONNECTOR FOR ECS CABLE 310801	
CHECKED BY: C CHAPMAN	09/04/98	SIZE	CAGE CODE
DESIGNED BY:		B 66197	LEVEL
PROJECT ENG: M TAUBENHEIN	09/04/98	PART NO.	M0122
ENG. MGR: P JOBE	6/4/99	SCALE:	FILE NO F:\E\SPEC\CONN\INST\M0122-1 SHEET: 1 OF 3

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