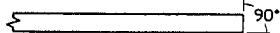


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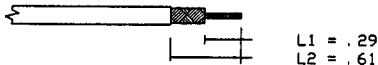
INSTALLATION INSTRUCTIONS

REVISIONS					
ECN	ZONE	REV	DESCRIPTION	DATE	APPROVED
3939		N/C	NEW RELEASE.	6/28/01	<i>[Signature]</i>

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.



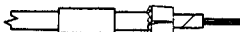
3. SLIDE THE FERRULE OVER THE END OF THE CABLE. ¹



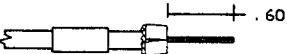
4. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



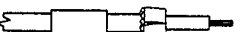
5. SLIT FOIL LONGITUDINALLY AND FOLD BACK OVER THE OTHER SHIELD.



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.

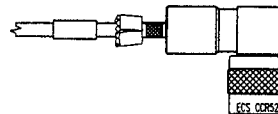


8. ENSURE THAT THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. TERMINATE CONTACT PER OPTION a OR b BELOW.

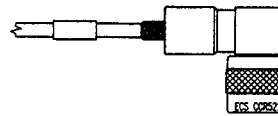
- a) SOLDER CONTACT ONTO CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER. CLEAN FLUX RESIDUE USING APPROPRIATE CLEANER.
- b) CRIMP CONTACT ONTO CENTER CONDUCTOR USING A M22520/5-09 DIE (B HEX).



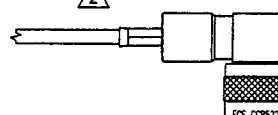
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE RIDGE INSIDE THE CONNECTOR DIELECTRIC. **CAUTION:** PUSH CABLE IN TO THE CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE.



10. FOLD BOTH SHIELDS BACK OVER THE NECK OF THE CONNECTOR BODY.



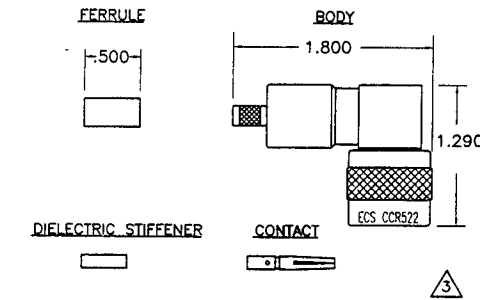
11. SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING A M22520/5-09 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. ²



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.

ALL LENGTHS IN INCHES		ECS		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION			
DRAWN BY: P. PHALPHOUVONG	06/13/01	C RIGHT ANGLE PLUG FOR ECS CABLE 432101 AND 532101			
CHECKED BY: C. Chapman	6/28/01	SIZE	CAGE CODE	LEVEL	PART NO.
DESIGNED BY:		B	66197		CCR522
PROJECT ENG:		SCALE:	F:\STORAGE\ELSPEC\COMM\INST\CCR522		SHEET: 1 OF 1



SPECIFICATIONS

ELECTRICAL
 IMPEDANCE: 50 OHMS NOMINAL
 FREQUENCY RANGE: 0-11 GHz
 VSWR: 1.30:1 MAXIMUM
 INSERTION LOSS: .1 dB MAX • DC TO 2 GHz
 WORKING VOLTAGE: 1000 VRMS • SEA LEVEL
 DIELECTRIC WITHSTANDING: 3000 VRMS • SEA LEVEL
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM
MECHANICAL
 • 500 VOLTS DC
 CONNECTOR INTERFACE DIMENSION PER MIL-STD-348A, FIGURE 302-1.
 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. 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
 CABLE CONTACT: BERYLLIUM COPPER PER ASTM B196
 CENTER CONTACT: BRASS PER ASTM B16
 OUTER CONTACT: BERYLLIUM COPPER PER ASTM B196
 DIELECTRIC: TEFLON PER ASTM D1710
 GASKET: SILICONE RUBBER PER ZZ-R-765

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