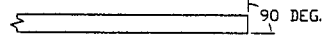


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INSTALLATION INSTRUCTIONS

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
3586		N/C	NEW RELEASE	1/29/97	JBH
6189	A		UPDATED SPECS	9/15/98	MCT
12961	B		SEE ECN	8/14/01	8/14/01

1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



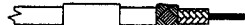
2. STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE NOT TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.



3. SLIDE THE FERRULE AND ADHESIVE HEAT SHRINK ² TUBING OVER THE END OF THE CABLE.



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



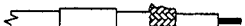
5. USING TWEEZERS, FOLD THE INNER SHIELD BACK OVER THE OUTER SHIELD, LEAVING AS MUCH WEAVE AS POSSIBLE.



6. REMOVE THE DIELECTRIC FROM THE CENTER CONDUCTOR BACK TO THE EDGE OF THE FOLDED BACK SHIELDS, APPROXIMATELY .60 INCHES FROM THE END OF THE CENTER CONDUCTOR. BE CAREFUL NOT TO NICK THE CENTER CONDUCTOR. THERMAL STRIPPERS ARE RECOMMENDED.



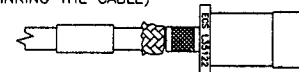
7. INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR, ENSURING THAT IT IS BUTTED AGAINST THE CABLE DIELECTRIC.



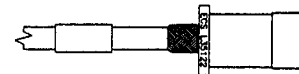
8. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-57 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



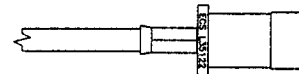
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CONTACT UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY. (CAUTION: PUSH CABLE INTO CONNECTOR STRAIGHT TO AVOID KINKING THE CABLE)



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

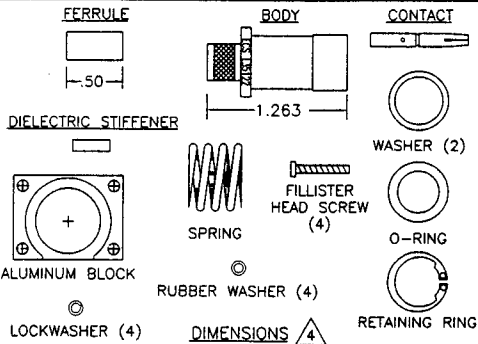


11. SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING THE M22520/5-57 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. ³



NOTES

- ALL DIMENSIONS ARE IN INCHES.
- ² ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- ³ ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- ⁴ CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
- DELETED.
- DELETED.



SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0-6 GHz
VSWR: 1.70:1 MAXIMUM
INSERTION LOSS: 0.3 dB @ 6 GHz
WORKING VOLTAGE: 1000 VRMS @ SEA LEVEL
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: 20 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

ALL LENGTHS IN INCHES

APPROVALS	DATE
DRAWN BY: KW HOFFMAN	11/15/95
CHECKED BY: M TAUBENHIEM	1/28/97
DESIGNED BY:	
PROJECT ENG:	
ENG. MGR: JB HACKETT	1/29/97

ELECTRONIC CABLE SPECIALISTS
FRANKLIN, WI 53132
PHONE: (414) 421-5300

TITLE: CUSTOMER SPECIFICATION
SIZE 1, ARINC 600
RF COAX CONNECTOR FOR ECS CABLE 352001

SIZE	CAGE CODE	LEVEL	PART NO.
B	66197		L35122

SCALE: FILE NO: F:\E\SPEC\COMM\WST\L35122-1 SHEET: 1 OF 2