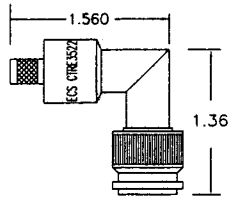
DWG NO.	SH	REV.
CTRE3522-1	1	C

This print and associated documents and the contained information are the confidential property of ELECTRONIC CABLE SPECIALISTS. Disclosure of, and/or reproduction of, all or part thereof or manufacture of any part from information contained on this print not specifically permitted by ELECTRONIC CABLE SPECIALISTS in writing is forbidden.

FERRULE

BODY



CABLE CONTACT

DIELECTRIC STIFFENER

DIMENSIONS (4)

SPECIFICATIONS

ELECTRICAL
IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0-11GHz
VSWR: 1.2:1 MAXIMUM DC TO 2GHz
INSERTION LOSS: .1dB MAXIMUM DC TO 2GHz
WORKING VOLTAGE: 500 VRMS @ SEA LEVEL
DIELECTRIC WITHSTANDING: 1500 VRMS @ SEA LEVEL
INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

MECHANICAL
CONNECTOR INTERFACE: DIMENSIONS PER MIL-STD-348A FIGURE 313-1
TERMINATION STYLE: CABLE CONTACT-SOLDER OR CRIMP FERRULE-CRIMP
CABLE RETENTION: 20 LBS

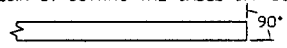
ENVIRONMENTAL
TEMPERATURE RATING: -65° TO +165° C
VIBRATION: MIL-STD-202, METHOD 204, COND. B
SHOCK: MIL-STD-202, METHOD 213, COND. I
THERMAL SHOCK: MIL-STD-202, METHOD 107, COND. B
CORROSION: MIL-STD-202, METHOD 101, COND. B
MOISTURE RESISTANCE: MIL-STD-202, METHOD 106

MATERIALS
BODY: BRASS PER QQ-B-626
FERRULE: ANNEALED BRASS PER QQ-B-626
CABLE CONTACT: BERYLLIUM COPPER PER QQ-C-530
CENTER CONTACT: BRASS PER QQ-B-626
OUTER CONTACT: BERYLLIUM COPPER PER QQ-C-530
DIELECTRIC: TEFLON PER L-P-403
GASKET: SILICON RUBBER PER ZZ-R-765

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

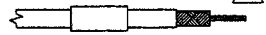
INSTALLATION INSTRUCTIONS

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.

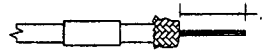
3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE. (2)



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

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

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.

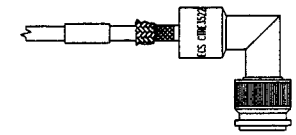


7. INSTALL DIELECTRIC STIFFENER OVER CENTER CONDUCTOR, ENSURING THAT IT IS BUTTED AGAINST THE CABLE DIELECTRIC.

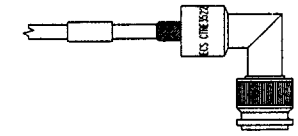
8. SOLDER THE CENTER CONTACT ONTO THE CENTER CONDUCTOR PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH A M22520/5-11 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC STIFFENER. CLEAN ALL FLUX RESIDUES USING APPROPRIATE FLUX CLEANER.

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APROVED
5884		N/C	NEW RELEASE.	8/26/97	MCT
6189		A	ADDED INNER DIMENSIONS FOR CONN.	9/10/98	MCT
12904		B	SEE ECN	12/19/00	CAC
13466		C	SEE ECN	7/24/01	C Bayne

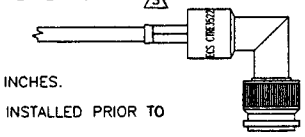
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR. CAUTION: PUSH CABLE INTO CONNECTOR STRAIGHT TO AVOID KINKING.



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



10. 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 M22520/5-11 DIE, (A HEX), IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. (3)



NOTES
1. 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 WI0007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
(4) CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
5 -DELETED-
6 -DELETED-

ALL LENGTHS IN INCHES	
APPROVALS	DATE
DRAWN BY: M TAUBENHEIM	8/26/97
CHECKED BY: M TAUBENHEIM	8/26/97
DESIGNED BY:	
PROJECT ENG: JB HACKETT	8/26/97
ENG. MGR:	

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

TITLE: CUSTOMER SPECIFICATION
90 DEG TNC EXTENDED BODY PLUG FOR ECS COAX CABLE 352001

SIZE	CAGE CODE	LEVEL	PART NO.
B	66197		CTRE3522

SCALE: | FILE NO. : F:\E\SPEC\CONN\INST\CTRE3522 | SHEET: 1 OF 1