

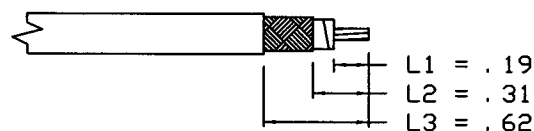
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**INSTALLATION INSTRUCTIONS**

1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



2. 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.



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



4. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-13 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



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



6. 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.

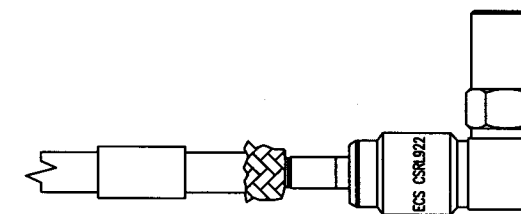


7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.

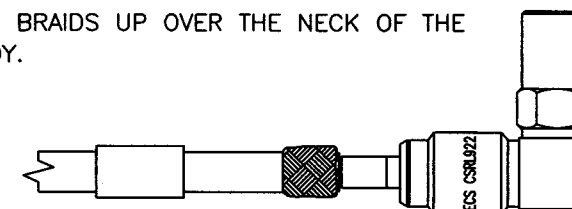


REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
20488	-	1	PROTOTYPE	8/4/04	PETER LEE
20566	-	2	PREPRODUCTION RELEASE	8/11/04	D. KNOLL
20783	-	N/C	CHANGED CONTACT & STRIPP DIM'S	9/13/04	D. Knoll

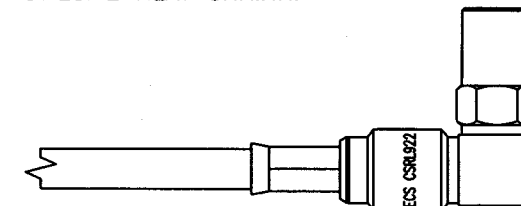
8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE RIDGE ON THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



9. FOLD ALL THREE 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 THE M22520/5-13 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



**NOTES**

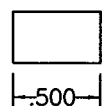
1. ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.

2. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

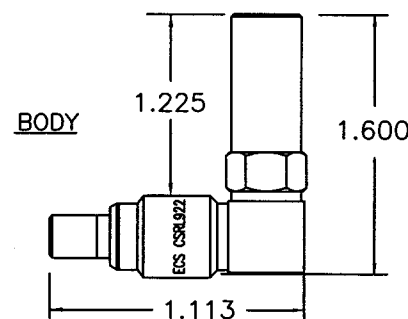
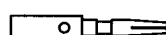
3. PICTORIALS SHOW CONNECTOR INSTALLATION ON ECS 311501 AND 311601 CABLE. WHEN INSTALLING THIS CONNECTOR ON 421601 THERE ARE ONLY ONLY 2 SHIELDS WHICH SHOULD BE FOLDED BACK AS SHOWN IN STEP 6 AND STEP 7 WOULD BE OMITTED.

**DIMENSIONS**

**FERRULE**



**CONTACT**



**SPECIFICATIONS**

**ELECTRICAL**

IMPEDANCE: 50 OHMS NOMINAL  
 FREQUENCY RANGE: 0-18 GHz  
 VSWR: 1.2:1 MAXIMUM DC TO 2 GHz.  
 INSERTION LOSS: .1 dB MAXIMUM DC TO 2 GHz.  
 WORKING VOLTAGE: 500 VRMS @ SEA LEVEL  
 DIELECTRIC WITHSTANDING: 1500 VRMS @ SEA LEVEL  
 INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM @ 500 VOLTS DC

**MECHANICAL**

CONNECTOR INTERFACE DIMENSION PER MIL-STD-348A FIGURE 310-1 (SMA)  
 TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP  
 OUTER CONTACT-FERRULE CRIMP  
 CABLE RETENTION: 40 LBS

**ENVIRONMENTAL**

TEMPERATURE RATING: -65° TO +165° C  
 VIBRATION: MIL-STD-202, METHOD 204, COND. D  
 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: STAINLESS STEEL PER QQ-S-763  
 FERRULE: ANNEALED BRASS PER QQ-B-626  
 CABLE CONTACT: BRASS PER QQ-B-626  
 CONN. CONTACT: BERYLLIUM COPPER PER QQ-C-530  
 OUTER CONTACT: STAINLESS STEEL PER QQ-S-763  
 DIELECTRIC: TEFLON PER L-P-403  
 GASKET: SILICON RUBBER PER ZZ-R-765  
**FINISHES**  
 BODY: STAINLESS STEEL PER QQ-S-763  
 CONTACTS: GOLD PER MIL-G-45204

ALL LENGTHS IN INCHES		ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: <b>CUSTOMER SPECIFICATION</b>	
DRAWN BY C CHAPMAN	08/02/04	SMA 90° EXTENDED PLUG FOR ECS CABLE 311601, 311501 & 421601	
CHECKED BY PETER LEE	08/04/04	SIZE <b>B</b>	CAGE CODE <b>66197</b>
DESIGNED BY:		LEVEL	PART NO. <b>CSRL922</b>
PROJECT ENG: C CHAPMAN	08/04/04	FILE NO. F:\STORAGE\E\SPEC\CONN\INST\CSRL922 SHEET 1 OF 1	
ENG. MGR:			