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DWG NO.	M5122-1	SH	1	REV.	N/C
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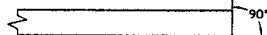
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### INSTALLATION INSTRUCTIONS

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
13939		N/C	NEW RELEASE	7/6/01	<i>[Signature]</i>

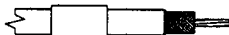
1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



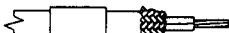
2. STRIP THE CABLE AS SHOWN, BEGINNING WITH L1 AND ENDING WITH L2. TAKE CARE **NOT** TO NICK THE CONDUCTORS WHILE STRIPPING THE DIELECTRIC AND JACKET. THE USE OF A STRIPPER DESIGNED FOR COAXIAL CABLE IS RECOMMENDED.



3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE. <sup>1</sup>



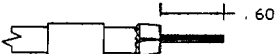
4. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



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 PER 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).



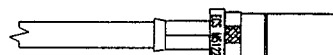
9. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR. **CAUTION:** PUSH CABLE INTO THE CONDUCTOR STRAIGHT TO AVOID KINKING THE CABLE.



10. FOLD ALL THE BRAIDS 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. <sup>2</sup>



### NOTES

- <sup>1</sup> ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.  
<sup>2</sup> ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.  
<sup>3</sup> CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

ALL LENGTHS IN INCHES		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS	DATE	TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: P. PHALPHOUVONG	06/12/01	MODIFIED SIZE 1, ARINC 600 RF	
CHECKED BY: C. Chapman	7/6/01	CONNECTOR FOR ECS CABLE 432101 AND 532101	
DESIGNED BY:		SIZE	CAGE CODE
		B	66197
PROJECT ENG:		LEVEL	PART NO.
			M5122
ENG. MGR: Randy Hand	7/6/01	SCALE:	FILE NO. FILE/SPEC/COMM/INST/M5122-1-1
			SHEET: 1 OF 3

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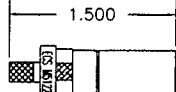
### FERRULE

.500



### BODY

1.500



### CONTACT



### RETAINING RING



### SPRING



### DIELECTRIC STIFFENER



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### SPECIFICATIONS

#### ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL  
FREQUENCY RANGE: 0-6 GHz  
VSWR: 1.70:1 MAXIMUM  
INSERTION LOSS: 0.3 dB @ 6 GHz  
DIELECTRIC WITHSTANDING: 2500 VRMS @ SEA LEVEL  
WORKING VOLTAGE: 1000 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 ASTM B16  
FERRULE: ANNEALED BRASS PER ASTM B16  
CABLE CONTACT: BRASS PER ASTM B16  
CENTER CONTACT: BERYLLIUM COPPER PER ASTM B196  
DIELECTRIC: TEFLON PER ASTM D1710

#### FINISHES

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