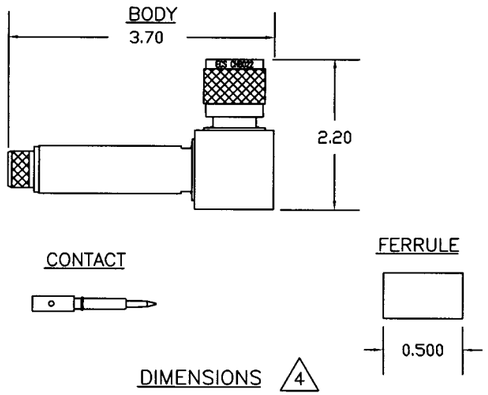
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DIMENSIONS (4)

SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0–4 GHz
VSWR: 1.35:1 MAXIMUM
INSERTION LOSS: .1 dB MAXIMUM DC TO 2 GHz
WORKING VOLTAGE: 2500 VRMS @ –55°C AND 55,000 FT
DIELECTRIC WITHSTANDING: 5000 VRMS @ SEA LEVEL
INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM

MECHANICAL

CONNECTOR INTERFACE DIMENSION PER MIL–STD–348A FIGURE 317–1 WITH EXCEPTION OF INTERFACE DIELECTRIC INTERFACE IS COMPATIBLE WITH HN JACK.
TERMINATION STYLE: CONTACT–SOLDER OR CRIMP
FERRULE–CRIMP
CABLE RETENTION: 50 LBS

ENVIRONMENTAL

TEMPERATURE RATING: –65° TO +165° C
CORROSION: MIL–STD–202, METHOD 101, COND. B
MOISTURE RESISTANCE: MIL–STD–202, METHOD 106

MATERIALS

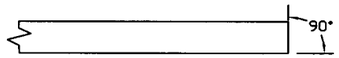
BODY: BRASS PER ASTM B16
FERRULE: ANNEALED, BRASS PER ASTM B16 OR COPPER PER ASTM B124
CABLE CONTACT: BRASS PER ASTM B16
CENTER CONTACT: BERYLLIUM COPPER PER ASTM B196
DIELECTRIC: TEFLON PER ASTM D1710
GASKET: SILICONE RUBBER PER ZZ–R–765

FINISHES

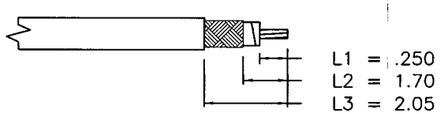
BODY, FERRULE: BRIGHT NICKEL PER QQ–N–290
CENTER CONTACT: GOLD PER MIL–G–45204
CABLE CONTACT: GOLD PER MIL–G–45204

INSTALLATION INSTRUCTIONS

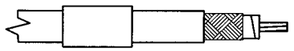
1. BEGIN BY CUTTING THE CABLE OFF SQUARE.



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.



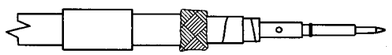
3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING (2) OVER THE END OF THE CABLE.



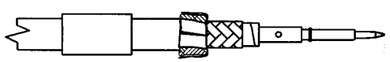
4. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL–STD–2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH Y1757 DIE. ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



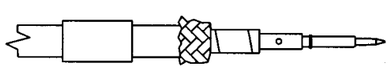
5. USING TWEEZERS, FOLD THE OUTER BRAID BACK OVER THE CABLE JACKET, LEAVING AS MUCH WEAVE AS POSSIBLE.



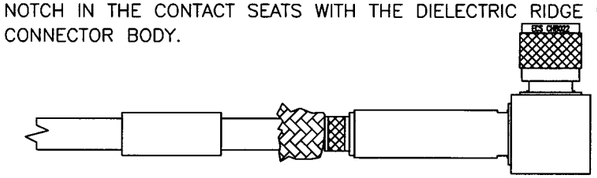
6. SLICE THE ALUMINUM/POLYESTER FOIL LENGTHWISE ABOUT EVERY 1/8". GENTLY ROTATE PIN TO SEPARATE THE FLAT FOIL BRAID AND ALUMINUM/POLYESTER FOIL FROM THE DIELECTRIC. USING TWEEZERS, FOLD BACK ALUMINUM/POLYESTER FOIL OVER THE OUTER BRAID.



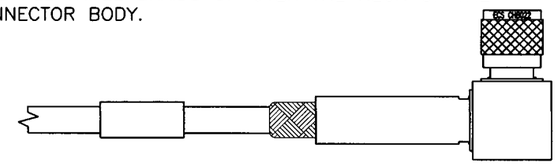
7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK OUTER SHIELD.



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 BODY.

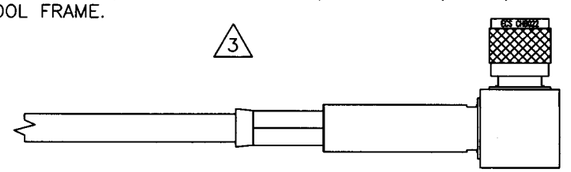


9. FOLD ALL THREE BRAIDS UP OVER THE NECK OF THE CONNECTOR BODY.



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 M22520/5–21 DIE (A HEX) IN A M22520/5–01 TOOL FRAME.

(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 WI007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
4. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
18282	–	N/C	NEW RELEASE.	9/18/03	D KNOLL
19292	D4 C3 A4	A	CHANGED CONNECTOR DIMENSIONS CHANGED STRIP DIMENSIONS REMOVED CONTACT GASKET FROM MATERIALS	2/16/04	

ALL LENGTHS IN INCHES	
APPROVALS	DATE
DRAWN BY: T. SEROOGY II	09/18/03
CHECKED BY: DAVID E KNOLL	09/18/03
DESIGNED BY:	
PROJECT ENG:	
ENG. MGR: DAVID E KNOLL	09/18/03

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

TITLE: CUSTOMER SPECIFICATION
HN RIGHT ANGLE PLUG WITH EXTENDED PIN CONTACT FOR ECS CABLE 310801

SIZE	CAGE CODE	LEVEL	ECS PART NO.
B	66197		CHB022

SCALE: | EFFECTIVITY: | SHEET: 1 OF 1