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DWG NO.

M1122-1

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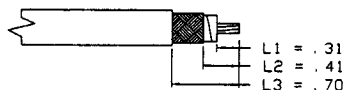
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INSTALLATION INSTRUCTIONS

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.



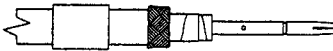
3. SLIDE THE FERRULE AND ADHESIVE SHRINK TUBING OVER THE END OF THE CABLE.



4. SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-57 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				DATE	APPROVED
ECN	ZONE	REV.	DESCRIPTION		
6188		N/C	NEW RELEASE.	9/15/98	MCT
12963		A	SEE ECN	8/14/01	Paul M. Hall

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.



9. FOLD ALL THE BRAIDS 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 M22520/5-47 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



NOTES

- ALL DIMENSIONS ARE IN INCHES.
- ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
- DELETED.
- DELETED.
- PICTORIALS SHOW CONNECTOR INSTALLATION ON ECS 311201 CABLE. WHEN INSTALLING THIS CONNECTOR ON 421201 THERE ARE ONLY 2 SHIELDS WHICH SHOULD BE FOLDED BACK AS SHOWN IN STEP 6 AND STEP 7 WOULD BE OMITTED.

ALL LENGTHS IN INCHES		ECS		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
APPROVALS		DATE		TITLE: CUSTOMER SPECIFICATION	
DRAWN BY: C CHAPMAN		09/04/98		MODIFIED SIZE 1, ARINC 600 RF	
CHECKED BY: C CHAPMAN		9/15/98		CONNECTOR FOR ECS CABLE 311201 AND 421201	
DESIGNED BY:		SIZE		CAGE CODE	
PROJECT ENG: M. TAUBENHEIN		09/15/98		LEVEL	
ENG. MGR: P JOBE		6/4/99		PART NO.	
SCALE:		FILE NO. F:\E\SPEC\CONN\INST\M1122-1		SHEET: 1 OF 3	

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