

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.

*** EXPORT CONTROLLED DOCUMENT - EAR ***
The information in this document is subject to the export controls in accordance with the export administration regulations. Diversion contrary to U.S. Law is prohibited.

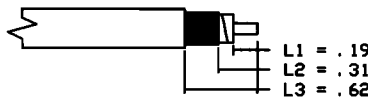
REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
21604	-	N/C	NEW RELEASE.	12/20/04	DEK
30011	C2	A	CHG STRIP DIM FROM .31/.40/.70 TO .19/.31/.62	8/16/07	CAC
40648	C3 B4	B	NOTE 4 DEL "OR CRIMP WITH Y1757 DIE" TERM STYLE SPEC, DELETED "CRIMP"	7/16/10	DEK
45747	A4	C	BODY FINISH WAS BRIGHT NICKEL	1/12/12	CAC

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. ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING 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.



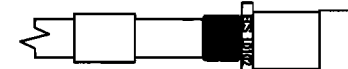
7. USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK OUTER SHIELD.



8. SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS INTO THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



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



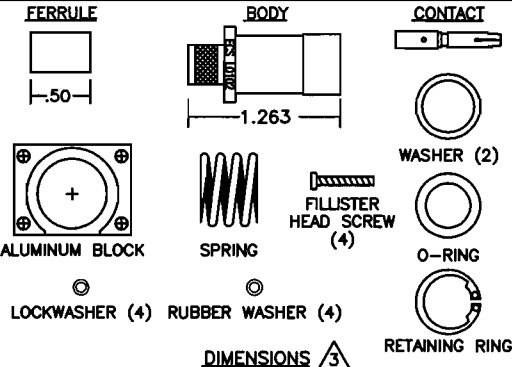
10. SLIDE THE FERRULE UP OVER THE SHIELDS AND AGAINST THE CONNECTOR BODY. TRIM AWAY ANY EXCESS BRAID. CRIMP THE FERRULE ONCE, NEXT TO THE BODY, USING THE M22520/5-31 DIE IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK.



NOTES

- 1. ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- 2. ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- 3. CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.

APPROVALS		DATE	ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-8300	
DRAWN BY: C CHAPMAN		12/14/04	TITLE: CUSTOMER SPECIFICATION	
CHECKED BY: D KNOLL		12/20/04	SIZE 1, ARINC 600, RF CONNECTOR FOR ECS CABLE 310701	
DESIGNED BY:			SIZE	CAGE CODE
PROJECT ENG:			B	66197
ENG. MGR: D KNOLL		12/20/04	LEVEL	DWG NO.
				L0102
			SCALE:	EFFECTIVITY:
				SHEET: 1 of 2



SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0-6 GHz
VSWR: 1.70:1 MAXIMUM
INSERTION LOSS: 0.3 dB @ 6 GHz
WORKING VOLTAGE: 1000 VRMS @ SEA LEVEL
DIELECTRIC WITHSTANDING: 2500 VRMS @ SEA LEVEL
INSULATION RESISTANCE: 5000 MEGOHMS MINIMUM
@ 500 VOLTS DC

MECHANICAL

MECHANICAL INTERFACE PER ARINC SPEC 600
FIGURE 19-54.2 (SIZE 1)
TERMINATION STYLE: CENTER CONTACT-SOLDER
FERRULE-CRIMP
CABLE RETENTION: 60 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 QQ-B-626
FERRULE: ANNEALED BRASS PER QQ-B-626
CENTER CONTACT: BERYLLIUM COPPER PER QQ-C-530
DIELECTRIC: TEFLON PER L-P-403

FINISHES

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

4

3

DWG NO.	SH	REV.
L0102-1	2	C

1

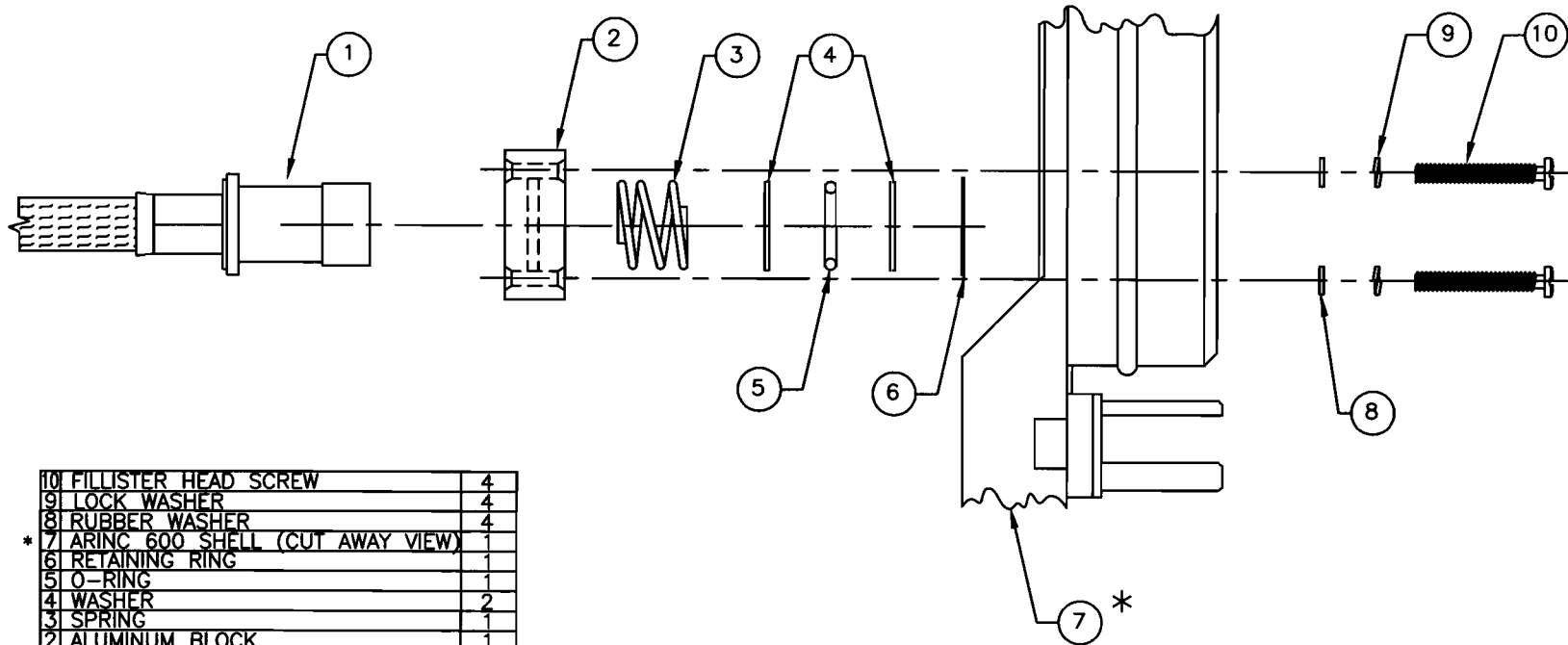
This print and associated documents and the contained information are the confidential property of ELECTRONIC CABLE SPECIALISTS. Disclosure of, and/or reproduction of, all or part thereof or manufacture of any part from information contained on this print not specifically permitted by ELECTRONIC CABLE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

**** EAR CONTROLLED ****


INSTALLATION INSTRUCTIONS--RETAINING HARDWARE

1. SLIDE ITEMS 2 THRU 6 ONTO ITEM 1 IN THE ORDER SHOWN.
 2. COMPRESS ITEM 3 UNTIL ITEM 6 SNAPS INTO PLACE BENEATH THE RIDGE OF ITEM 1.
 3. INSERT ITEM 7 AND ITS ACCOMPANYING HARDWARE INTO ITEM *7. ITEM 2 MAY HAVE TO BE ROTATED TO INSURE PROPER SEATING.
 4. SLIDE ITEMS 8 AND 9 ONTO ITEM 10 IN THE ORDER SHOWN.
 5. SCREW ITEM 10 AND ITS ACCOMPANYING HARDWARE THROUGH ITEM *7 INTO ITEM 2. TIGHTEN ITEM 10 TO 2.0 - 2.9 IN.-LBS TORQUE.
 6. REPEAT STEPS 4 & 5 FOR REMAINING HARDWARE.
- * NOT SUPPLIED WITH L-SERIES CONNECTOR.

NOTE: ASSEMBLE CONNECTOR BODY TO CABLE PER SHEET 1 OF THIS DRAWING.



ITEM NUMBER	DESCRIPTION	QTY EACH
10	FILLISTER HEAD SCREW	4
9	LOCK WASHER	4
8	RUBBER WASHER	4
* 7	ARINC 600 SHELL (CUT AWAY VIEW)	1
6	RETAINING RING	1
5	O-RING	1
4	WASHER	2
3	SPRING	1
2	ALUMINUM BLOCK	1
1	L TYPE CONNECTOR ATTACHED TO CABLE	1

		ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300	
SIZE	CAGE CODE	LEVEL	PART NO.
B	66197		L0102
SCALE:	FILE NO. F:\ECSPEC\COMM\INST\L0122-2		SHEET: 2 OF 2