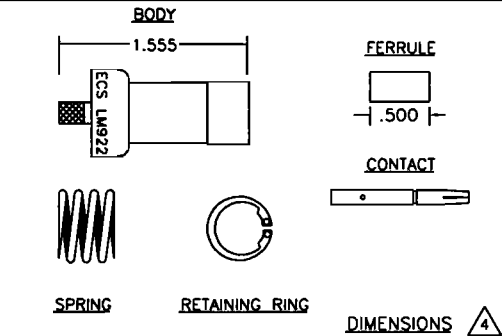


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SPECIFICATIONS

ELECTRICAL

IMPEDANCE: 50 OHMS NOMINAL
FREQUENCY RANGE: 0-6 GHz
VSWR: 1.70:1 MAXIMUM
WORKING VOLTAGE: 1000 VRMS @ SEA LEVEL
INSERTION LOSS: 0.3 dB @ 6 GHz
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
TERMINATION STYLE: INNER CONTACT-SOLDER OR CRIMP
OUTER CONTACT-FERRULE CRIMP
CABLE RETENTION: 40 LBS

ENVIRONMENTAL

TEMPERATURE RATING: -65° TO +200°
VIBRATION: MIL-STD-202, METHOD 204, COND. B
SHOCK: MIL-STD-202, METHOD 213, COND. 1
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

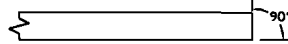
BODY: BRASS PER QQ-B-626
FERRULE: ANNEALED BRASS PER QQ-B-626
CENTER CONTACT: BERYLLIUM COPPER PER QQ-C-530
DIELECTRIC: TEFLON PER L-P-403

FINISHES

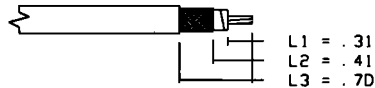
FERRULE: BRIGHT NICKEL PER QQ-N-290
BODY, CENTER CONTACT: GOLD PER MIL-G-45204

INSTALLATION INSTRUCTIONS

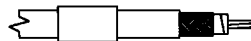
- BEGIN BY CUTTING THE CABLE OFF SQUARE.



- 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.



- SLIDE THE FERRULE AND ADHESIVE SHINK TUBING OVER THE END OF THE CABLE. $\triangle 2$



- SOLDER THE CONTACT ONTO THE CENTER CONDUCTOR, PER MIL-STD-2000, USING 63Sn/37Pb SOLDER OR CRIMP WITH M22520/5-59 DIE (B HEX). ENSURE THE CONTACT IS BUTTED AGAINST THE CABLE DIELECTRIC. CLEAN ALL FLUX RESIDUES USING AN APPROPRIATE FLUX CLEANER.



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



- 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.

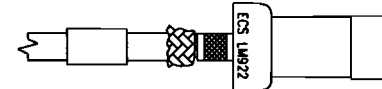


- USING TWEEZERS, FOLD THE INNER BRAID BACK OVER THE OTHER SHIELDS, LEAVING AS MUCH WEAVE AS POSSIBLE. NOTE: DO NOT UNRAVEL DIELECTRIC WHEN PULLING BACK INNER SHIELD.

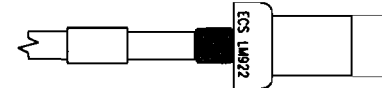


REVISIONS					
ECN	ZONE	REV.	DESCRIPTION	DATE	APPROVED
40680	B2	B	ADDED FLAG NOTE 6	7/6/10	CAC

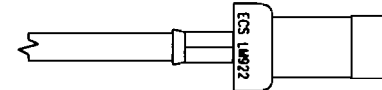
- SLIDE THE BODY OF THE CONNECTOR OVER THE END OF THE CABLE UNTIL THE NOTCH IN THE CONTACT SEATS WITH THE DIELECTRIC RIDGE INSIDE THE CONNECTOR BODY.



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



- 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 M22520/5-59 DIE (A HEX) IN A M22520/5-01 TOOL FRAME. APPLY ADHESIVE HEAT SHRINK. $\triangle 3$



NOTES

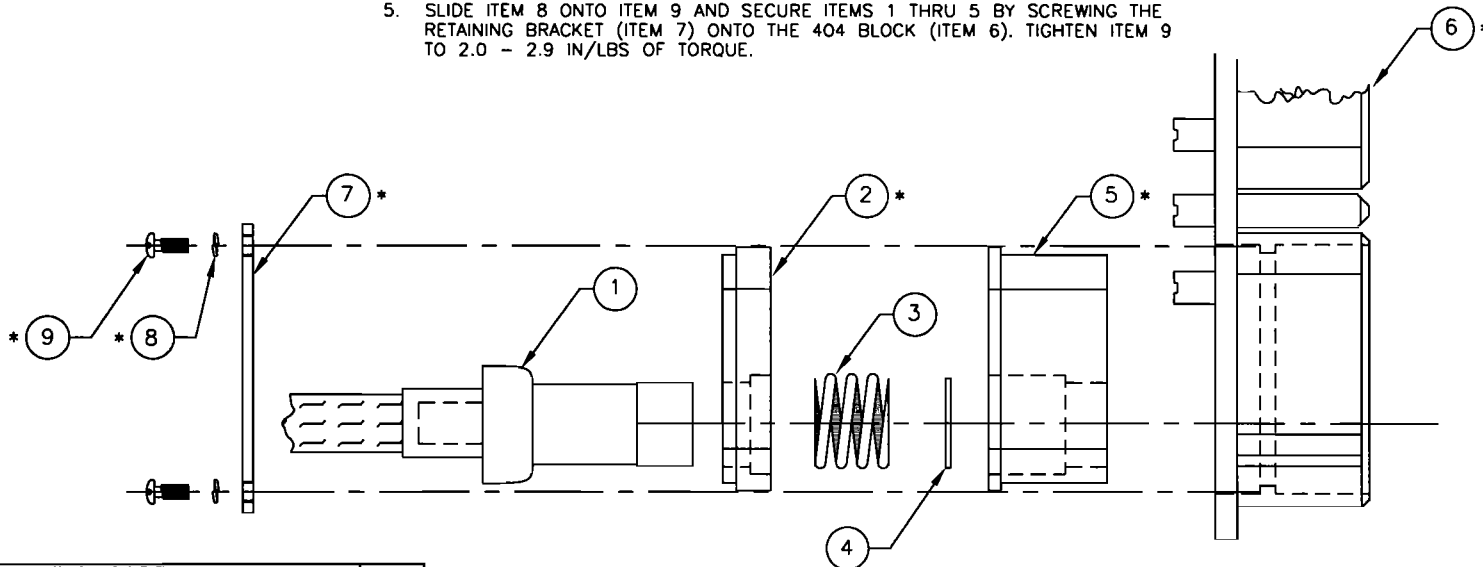
- ALL DIMENSIONS ARE IN INCHES.
- ENSURE HEAT SHRINK IS INSTALLED PRIOR TO CRIMPING CONNECTOR.
- ADHESIVE HEAT SHRINK SHOULD BE APPLIED IN ACCORDANCE WITH ECS WORK INSTRUCTION W1007. CONTACT ECS FOR A COPY OF THIS WORK INSTRUCTION.
- CONNECTOR DIMENSIONS ARE FOR REFERENCE ONLY.
- PICTORIALS SHOW CONNECTOR 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.
- WHEN TERMINATING TO 421601 CABLE CENTER CONTACT SHALL BE SOLDERED. DO NOT CRIMP.

APPROVALS		DATE	ECS ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300		
DRAWN BY: C CHAPMAN		09/04/98	TITLE: CUSTOMER SPECIFICATION		
CHECKED BY: C CHAPMAN		9/15/98	SIZE 1, ARINC 404 RF CONNECTOR FOR ECS CABLE 311501, 311601 AND 421601		
DESIGNED BY:			SIZE	CAGE CODE	LEVEL PART NO.
PROJECT ENG: M TAUBENHEIN		9/15/98	B	66197	LM922
ENG. MGR: P JOBE		6/4/99	SCALE:	FILE NO. F:\ECSPEC\CONN\INST\LM922	SHEET: 1 OF 2

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INSTALLATION INSTRUCTIONS--RETAINING HARDWARE


1. REMOVE THE FOUR SCREWS (ITEM 9) FROM THE 404 BLOCK (ITEM 6) SO THAT ONE OF THE RETAINING BRACKETS (ITEM 7) CAN BE REMOVED. REMOVE ITEM 2 AND ITEM 5 FROM THE CAVITY OF ITEM 6.
2. SLIDE RETAINING BRACKET (ITEM 7) OVER CONNECTOR AND ONTO CABLE.
3. SLIDE ITEMS 2 THRU 4 OVER THE END OF ITEM 1 IN THE ORDER SHOWN UNTIL ITEM 4 SNAPS INTO THE GROOVE OF ITEM 1. REPEAT STEPS 1 AND 2 FOR THE REMAINING CONNECTORS ENSURING THAT EACH CONNECTOR GOES INTO THE CORRECT JACK.
4. INSERT ITEM 1 AND ITS ACCOMPANYING HARDWARE INTO ITEM 5 WHILE OBSERVING PROPER POLARITY OF JACK LOCATIONS. INSERT ITEMS 1 THRU 5 INTO ITEM 6.
5. SLIDE ITEM 8 ONTO ITEM 9 AND SECURE ITEMS 1 THRU 5 BY SCREWING THE RETAINING BRACKET (ITEM 7) ONTO THE 404 BLOCK (ITEM 6). TIGHTEN ITEM 9 TO 2.0 - 2.9 IN/LBS OF TORQUE.



9	FILLISTER HEAD SCREW	*
8	LOCK WASHER	*
7	RETAINING BRACKET	*
6	ARINC 404 SHELL (CUT AWAY VIEW)	*
5	FRONT BLOCK	*
4	RETAINING RING	1
3	SPRING	1
2	REAR BLOCK	*
1	LM TYPE CONNECTOR (ATTACHED TO CABLE)	1
ITEM NUMBER	DESCRIPTION	QTY EACH

NOTES:

1. ASSEMBLE CONNECTOR BODY TO THE CABLE PER SHEET 1 THIS DRAWING.
- * NOT SUPPLIED WITH LM-SERIES CONNECTOR, QUANTITIES WILL VARY PER ARINC 404 CAVITY.

 ELECTRONIC CABLE SPECIALISTS FRANKLIN, WI 53132 PHONE: (414) 421-5300			
SIZE	CAGE CODE	LEVEL	PART NO.
B	66197		LM922
SCALE:	FILE NO. F:\E\SPEC\COMM\INST\LM922-2	SHEET: 2 OF 2	