

Operating and
Service Manual

Keysight Technologies
85054D 50 Ω Type-N
Economy Calibration Kit

Notices

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1 General Information

Calibration Kit Overview

The Keysight 85054D Type-N calibration kit is used to calibrate Keysight network analyzers up to 18 GHz for measurements of components with 50 Ω type-N connectors.

The standards in this calibration kit allow you to perform simple 1- or 2-port and TRM (thru-reflect-match) calibrations.

This manual describes the 85054D calibration kit and provides replacement part numbers, specifications, and procedures for using, maintaining, and troubleshooting the kit.

Kit Contents

The 85054D calibration kit contains the following:

- offset opens and shorts, and broadband load terminations
- four type-N to 7 mm adapters
- two type-N to type-N adapters
- a 3/4 inch, 135 N-cm (12 in-lb) torque wrench for use on the type-N connectors
- a spanner wrench

Refer to **Table 6-1** and **Figure 6-1** for a complete list of kit contents and their associated part numbers.

Offset Opens and Shorts

The offset opens and shorts are built from parts that are machined to the current state-of-the-art in precision machining.

The offset short's inner conductors have a one-piece construction, common with the shorting plane. The construction provides for extremely repeatable connections.

The offset opens have inner conductors that are supported by a strong, low-dielectric constant plastic to minimize compensation values.

Both the opens and shorts are constructed so that the pin depth can be controlled very tightly, thereby minimizing phase errors. The lengths of the offsets in the opens and shorts are designed so that the difference in phase of their reflection coefficients is approximately 180 degrees at all frequencies.

Adapters

Like the other devices in the kit, the adapters are built to very tight tolerances to provide good broadband performance. The adapters utilize a dual-beaded connector structure to ensure stable, repeatable connections. The beads are designed to minimize return loss and are separated far enough so that interaction between the beads is minimized.

Calibration Definitions

The calibration kit must be selected and the calibration definitions for the devices in the kit installed in the network analyzer prior to performing a calibration.

The calibration definitions can be:

- resident within the analyzer
- manually entered from the front panel

Class assignments and standard definitions may change as more accurate model and calibration methods are developed. You can download the most recent class assignments and standard definitions from Keysight's Calibration Kit Definitions Web page at

<https://www.keysight.com/us/en/assets/9922-01521/technical-specifications/Calibration-Kit-Definitions.pdf>.

Refer to your network analyzer user's guide or embedded Help for instructions on manually entering calibration definitions, selecting the calibration kit, and performing a calibration.

Equipment Required but Not Supplied

Connector cleaning supplies and various electrostatic discharge (ESD) protection devices are not supplied with the calibration kit but are required to ensure successful operation of the kit. Refer to **Table 6-2 on page 6-2** for ordering information.

Incoming Inspection

Refer to **"Kit Contents" on page 1-1** to verify a complete shipment. Use **Table 1-1 on page 1-4** to record the serial numbers of all serialized devices in your kit.

General Information
Incoming Inspection

Check for damage. The foam-lined storage case provides protection during shipping. If the case or any device appears damaged, or if the shipment is incomplete, refer to **“Contacting Keysight” on page 5-5**. Keysight will arrange for repair or replacement of incomplete or damaged shipments without waiting for a settlement from the transportation company. See also, **“Returning a Kit or Device to Keysight” on page 5-4**.

Serial Numbers

A serial number is attached to this calibration kit. The first four digits followed by a letter comprise the serial number prefix; the last five digits are the suffix, unique to each calibration kit.

Recording the Device Serial Numbers

In addition to the kit serial number, the devices in the kit are individually serialized (serial numbers are labeled onto the body of each device). Record these serial numbers in **Table 1-1**. Recording the serial numbers will prevent confusing the devices in this kit with similar devices from other kits.

Table 1-1 Serial Number Record for the 85054D

Device	Serial Number
Calibration kit	_____
Broadband load -m-	_____
Broadband load -f-	_____
Open -m-	_____
Open -f-	_____
Short -m-	_____
Short -f-	_____
Adapters	
Type-N -m- to Type-N -m-	_____
Type-N -f- to Type-N -f-	_____
Type-N -f- to 7 mm	_____
Type-N -f- to 7 mm	_____
Type-N -m- to 7 mm	_____
Type-N -m- to 7 mm	_____

Calibration Kits Documented in This Manual

This manual applies to any 85054D calibration kit whose serial number prefix is listed on the title page. If your calibration kit has a different serial number prefix, refer to the **“Calibration Kit History”** section below for information on how this manual applies.

Calibration Kit History

This section describes calibration kits with serial number prefixes lower than the ones listed on the title page.

85054D Kits with Serial Prefix 2901A

These calibration kits did not have a calibration definitions disk to support the Keysight 8510C network analyzer. The part numbers provided in this manual are the recommended replacement parts for these kits. The devices in these kits should meet the specifications published in this manual.

Precision Slotless Connectors

The female type-N connectors in this calibration kit are metrology-grade, precision slotless connectors (PSC). A characteristic of metrology-grade connectors is direct traceability to national measurement standards through their well-defined mechanical dimensions.

Conventional female center conductors are slotted. When mated, the female center conductor is flared by the male pin. Because physical dimensions determine connector impedance, electrical characteristics of the female connector (and connection pair) are dependent upon the mechanical dimensions of the male pin. While connectors are used in pairs, their male and female halves are always specified separately as part of a standard, instrument, or device under test. Because of these facts, making precision measurements with the conventional slotted connector is very difficult, and establishing a direct traceability path to primary dimensional standards is nearly impossible.

The precision slotless connector was developed to eliminate these problems. All PSCs are female. A PSC incorporates a center conductor with a solid cylindrical shell that defines the outside diameter of the female center pin. Its outside diameter and, therefore, the impedance in its region does not change. The inner part provides an internal contact that flexes to accept the allowed range of male pin diameters.

The calibration of a network analyzer having a conventional slotted female connector on the test port remains valid only when the device under test and all calibration standards have identical male pin diameters. For this reason PSC test port adapters are supplied in most calibration kits.

Precision slotless connectors have the following characteristics:

- There is no loss of traceable calibration on test ports when the male pin diameter of the connector on the device under test is different from the male pin diameter of the calibration standard.
- The female PSC and its mating male connector can be measured and specified separately as part of the device either is attached to.
- All female connectors can have a known, stable impedance based only on the diameters of their inner and outer conductors.
- Female calibration standards can be fully specified. Their specifications and traceability are unaffected by the diameter of the male mating pin.
- A fully traceable performance verification is made using a precision 50 ohm airline having a PSC.
- Measurement repeatability is enhanced due to non-changing connector characteristics with various pin diameters.

With PSCs on test ports and standards, the percentage of accuracy achieved when measuring at 50 dB return loss levels is comparable to using conventional slotted connectors measuring devices having only 30 dB return loss. This represents an accuracy improvement of about 10 times.

Clarifying the Terminology of a Connector Interface

In this document and in the prompts of the PNA calibration wizard, the sex of cable connectors and adapters is referred to in terms of the center conductor. For example, a connector or device designated as 1.85 mm –f– has a 1.85 mm female center conductor.

8510-series, 872x, and 875x ONLY: In contrast, during a measurement calibration, the network analyzer softkey menus label a 1.85 mm calibration device with reference to the sex of the analyzer’s test port connector—not the calibration device connector. For example, the label **SHORT (F)** refers to the short that is to be connected to the female test port. This will be a male short from the calibration kit.

Table 1-2 Clarifying the Terminology of Connectors: Examples

Terminology	Meaning
Short –f–	Female short (female center conductor)
Short (f)	Male short (male center conductor) to be connected to female port

A connector gage is referred to in terms of the connector that it measures. For instance, a male connector gage has a female connector on the gage so that it can measure male devices.

Preventive Maintenance

The best techniques for maintaining the integrity of the devices in this kit include:

- routine visual inspection
- cleaning
- proper gaging
- proper connection techniques

All of the above are described in **Chapter 3, “Use, Maintenance, and Care of the Devices.”** Failure to detect and remove dirt or metallic particles on a mating plane surface can degrade repeatability and accuracy and can damage any connector mated to it. Improper connections, resulting from pin depth values being out of the **observed** limits (see **Table 2-2 on page 2-4**), or from bad connections, can also damage these devices.

When to Calibrate

A network analyzer calibration remains valid as long as the changes in the systematic error are insignificant. This means that changes to the uncorrected leakages (directivity and isolation), mismatches (source match and load match), and frequency response of the system are small ($<10\%$) relative to accuracy specifications.

Change in the environment (especially temperature) between calibration and measurement is the major cause in calibration accuracy degradation. The major effect is a change in the physical length of external and internal cables. Other important causes are dirty and damaged test port connectors and calibration standards. If the connectors become dirty or damaged, measurement repeatability and accuracy is affected. Fortunately, it is relatively easy to evaluate the general validity of the calibration. To test repeatability, remeasure one of the calibration standards. If you can not obtain repeatable measurements from your calibration standards, maintenance needs to be performed on the test port connectors, cables and calibration standards. Also, maintain at least one sample of the device under test or some known device as your reference device. A verification kit may be used for this purpose. After calibration, measure the reference device and note its responses. Periodically remeasure the device and note any changes in its corrected response which can be attributed to the test system. With experience you will be able to see changes in the reference responses that indicate a need to perform the measurement calibration again.

2 Specifications

Environmental Requirements

Table 2-1 Environmental Requirements

Parameter	Limits
Temperature	
Operating ^a	+20 °C to +26 °C
Storage	−40 °C to +75 °C
Error-corrected range ^b	± 1 °C of measurement calibration temperature
Relative humidity	Type tested, 0% to 95% at 40 °C, non-condensing

- a. The temperature range over which the calibration standards maintain conformance to their specifications.
- b. The allowable network analyzer ambient temperature drift during measurement calibration and during measurements when the network analyzer error correction is turned on. Also, the range over which the network analyzer maintains its specified performance while correction is turned on.

Temperature—What to Watch Out For

Changes in temperature can affect electrical characteristics. Therefore, the operating temperature is a critical factor in performance. During a measurement calibration, the temperature of the calibration devices must be stable and within the range specified in [Table 2-1](#).

NOTE

Avoid unnecessary handling of the devices during calibration because your fingers are a heat source.

Mechanical Characteristics

Mechanical characteristics such as center conductor protrusion and pin depth are not performance specifications. They are, however, important supplemental characteristics related to the electrical performance of devices. Keysight Technologies verifies the mechanical characteristics of the devices in this kit with special gaging processes and electrical testing. This ensures that the device connectors do not exhibit any excess center conductor protrusion or improper pin depth when the kit leaves the factory.

“Gaging Connectors” on page 3- 8 explains how to use gages to determine if the kit devices have maintained their mechanical integrity. (Refer to **Table 2-2 on page 2-4** for typical and observed pin depth limits.)

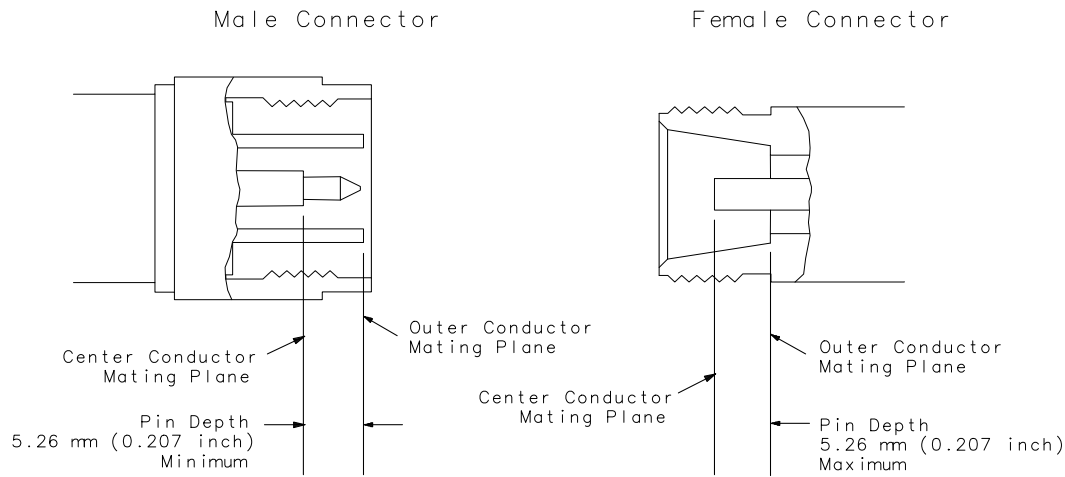
Pin Depth

Pin depth is the distance the center conductor mating plane differs from being flush with the outer conductor mating plane. Refer to **Figure 2-1**. Some coaxial connectors, such as 2.4 mm and 3.5 mm, are designed to have these planes nearly flush. Type-N connectors, however, are designed with a pin depth offset of approximately 5.26 mm (0.207 inch), not permitting these planes to be flush. The male center conductors are recessed by the offset value while the female center conductors compensate by protruding the same amount. This offset necessitates the redefining of pin depth with regard to protrusion and recession.

Protrusion refers to a male type-N connector center conductor having a pin depth value less than 5.26 mm (0.207 inch), or a female type-N connector center conductor having a pin depth value greater than 5.26 mm (0.207 inch).

Recession refers to a male type-N connector center conductor having a pin depth value greater than 5.26 mm (0.207 in), or a female type-N connector center conductor having a pin depth value less than 5.26 mm (0.207 inch).

Figure 2-1 Connector Pin Depth



wj53b

NOTE

The gages for measuring type-N connectors compensate for the designed offset of 5.26 mm (0.207 inch), therefore, protrusion and recession readings are in relation to a zero reference plane (as if the inner and outer conductor planes were intended to be flush). Gauge readings can be directly compared with the observed values listed in [Table 2-2](#).

The pin depth value of each calibration device in this kit is not specified, but is an important mechanical parameter. The electrical performance of the device depends, to some extent, on its pin depth. The electrical specifications for each device in this kit take into account the effect of pin depth on the device's performance. [Table 2-2](#) lists the typical pin depths and measurement uncertainties, and provides observed pin depth limits for the devices in the kit. If the pin depth of a device does not measure within the **observed** pin depth limits, it may be an indication that the device fails to meet electrical specifications. Refer to [Figure 2-1](#) for an illustration of pin depth in type-N connectors.

Table 2-2 Pin Depth Limits

Device	Typical Pin Depth micrometers (10–4 inches)	Measurement Uncertainty ^a micrometers (10–4 inches)	Observed Pin Depth Limits ^b micrometers (10–4 inches)
Opens	0 to –12.7 (0 to –5.0)	+3.8 to –3.8 (+ 1.5 to –1.5)	+3.8 to –16.5 (+ 1.5 to –6.5)
Shorts	0 to –12.7 (0 to –5.0)	+3.8 to –3.8 (+ 1.5 to –1.5)	+3.8 to –16.5 (+ 1.5 to –6.5)
Broadband loads	0 to –50.8 (0 to –20.0)	+3.8 to –3.8 (+ 1.5 to –1.5)	+3.8 to –54.6 (+ 1.5 to –21.5)
Adapters ^c (7 mm end) 85054-60031 85054-60032	0 to –50.8 (0 to –20.0)	+3.8 to –3.8 (+ 1.5 to –1.5)	+3.8 to –54.6 (+ 1.5 to –21.5)
Adapters (type-N end) 85054-60037 85054-60038	0 to –12.7 (0 to –5.0)	+3.8 to –3.8 (+ 1.5 to –1.5)	+3.8 to –16.5 (+ 1.5 to –6.5)
Adapters ^{c, d} (type-N end) 85054-60031 85054-60032	–12.7 to –22.86 (–5.0 to –9.0)	+3.8 to –3.8 (+ 1.5 to –1.5)	–8.9 to –26.66 (–3.5 to –10.5)

- a. Approximately +2 sigma to –2 sigma of gage uncertainty based on studies done at the factory according to recommended procedures.
- b. Observed pin depth limits are the range of observation limits seen on the gage reading due to measurement uncertainty. The depth could still be within specifications.
- c. For a description of these adapters, refer to **Table 6-1 on page 6-1**.
- d. In May 2015, this specification was changed from "0 to –12.7 μ m (0 to –0.0005 inch)" to "–12.7 to –22.8 μ m (–0.0005 to –0.0009 inch)". The Keysight factory began manufacturing adapters to this new specification a few months earlier. This change was made to improve the electrical transmission performance and repeatability of the adapter. On incoming inspection, Keysight will pass all devices which meet either specification and will ensure all devices meet the new specification when they are returned.

NOTE

When measuring pin depth, the measured value (resultant average of three or more measurements) is not the true value. Always compare the measured value with the observed pin depth limits in **Table 2-2** to evaluate the condition of device connectors.

Electrical Specifications

The electrical specifications in **Table 2-3** apply to the devices in your calibration kit when connected with a Keysight precision interface.

Table 2-3 **Electrical Specifications**

Device	Frequency (GHz)	Parameter	Specification
Broadband loads	DC to ≤ 2	Return Loss	≥ 40 dB ($\leq 0.01000\rho$)
	> 2 to ≤ 8	Return Loss	≥ 36 dB ($\leq 0.01585\rho$)
	> 8 to ≤ 18	Return Loss	≥ 34 dB ($\leq 0.01995\rho$)
Adapters (both styles)	DC to ≤ 8	Return Loss	≥ 34 dB ($\leq 0.0200\rho$)
	> 8 to ≤ 18	Return Loss	≥ 28 dB ($\leq 0.0398\rho$)
Offset Opens ^a	at 18	Deviation from Nominal Phase	$\pm 1.5^\circ$
Offset Shorts ^a	at 18	Deviation from Nominal Phase	$\pm 1.0^\circ$

a. The specifications for the opens and shorts are given as allowed deviation from the nominal model as defined in the standard definitions (see **“Class Assignments and Standard Definitions Values are Available on the Web” on page A-1**).

Certification

Keysight Technologies certifies that this product met its published specifications at the time of shipment from the factory. Keysight further certifies that its calibration measurements are traceable to the United States National Institute of Standards and Technology (NIST) to the extent allowed by the institute’s calibration facility, and to the calibration facilities of other International Standards Organization members. See **“How Keysight Verifies the Devices in This Kit” on page 4- 1** for more information.

Specifications
Electrical Specifications

3 Use, Maintenance, and Care of the Devices

Electrostatic Discharge

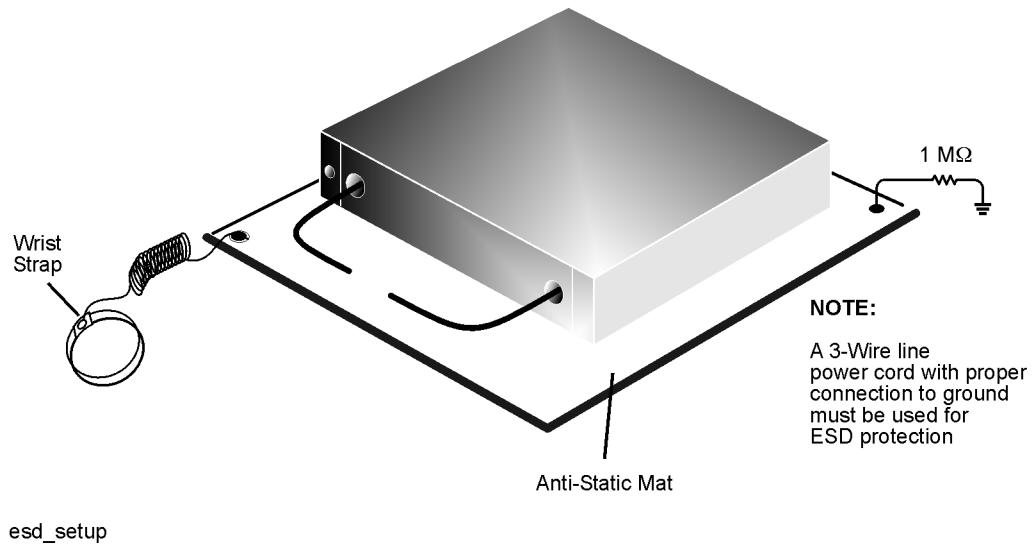
Protection against ESD (electrostatic discharge) is essential while connecting, inspecting, or cleaning connectors attached to a static-sensitive circuit (such as those found in test sets).

Static electricity can build up on your body and can easily damage sensitive internal circuit elements when discharged. Static discharges too small to be felt can cause permanent damage. Devices such as calibration components and devices under test (DUTs), can also carry an electrostatic charge. To prevent damage to the test set, components, and devices:

- **always** wear a grounded wrist strap having a 1 MΩ resistor in series with it when handling components and devices or when making connections to the test set.
- **always** use a grounded, conductive table mat while making connections.
- **always** wear a heel strap when working in an area with a conductive floor. If you are uncertain about the conductivity of your floor, wear a heel strap.
- **always** ground yourself before you clean, inspect, or make a connection to a static-sensitive device or test port. You can, for example, grasp the grounded outer shell of the test port or cable connector briefly.
- **always** ground the center conductor of a test cable before making a connection to the analyzer test port or other static-sensitive device. This can be done as follows:
 1. Connect a short (from your calibration kit) to one end of the cable to short the center conductor to the outer conductor.
 2. While wearing a grounded wrist strap, grasp the outer shell of the cable connector.
 3. Connect the other end of the cable to the test port.
 4. Remove the short from the cable.

Refer to **Chapter 6, “Replaceable Parts.”** for part numbers and instructions for ordering ESD protection devices.

Figure 3-1 ESD Protection Setup



Visual Inspection

Visual inspection and, if necessary, cleaning should be done every time a connection is made. Metal particles from the connector threads may fall into the connector when it is disconnected. One connection made with a dirty or damaged connector can damage both connectors beyond repair.

Magnification is helpful when inspecting connectors, but it is not required and may actually be misleading. Defects and damage that cannot be seen without magnification generally have no effect on electrical or mechanical performance. Magnification is of great use in analyzing the nature and cause of damage and in cleaning connectors, but it is not required for inspection.

Look for Obvious Defects and Damage First

Examine the connectors first for obvious defects and damage: badly worn plating on the connector interface, deformed threads, or bent, broken, or misaligned center conductors. Connector nuts should move smoothly and be free of burrs, loose metal particles, and rough spots.

What Causes Connector Wear?

Connector wear is caused by connecting and disconnecting the devices. The more use a connector gets, the faster it wears and degrades. The wear is greatly accelerated when connectors are not kept clean, or are connected incorrectly.

Connector wear eventually degrades performance of the device. Calibration devices should have a long life if their use is on the order of a few times per week. Replace devices with worn connectors.

The test port connectors on the network analyzer test set may have many connections each day, and are therefore more subject to wear. It is recommended that an adapter be used as a test port saver to minimize the wear on the test set's test port connectors.

Inspect the Mating Plane Surfaces

Flat contact between the connectors at all points on their mating plane surfaces is required for a good connection. See **Figure 2-1 on page 2-3**. Look especially for deep scratches or dents, and for dirt and metal particles on the connector mating plane surfaces. Also look for signs of damage due to excessive or uneven wear or misalignment.

Light burnishing of the mating plane surfaces is normal, and is evident as light scratches or shallow circular marks distributed more or less uniformly over the mating plane surface. Other small defects and cosmetic imperfections are also normal. None of these affect electrical or mechanical performance.

Use, Maintenance, and Care of the Devices
Visual Inspection

If a connector shows deep scratches or dents, particles clinging to the mating plane surfaces, or uneven wear, clean and inspect it again. Devices with damaged connectors should be discarded. Determine the cause of damage before connecting a new, undamaged connector in the same configuration.

Inspect the Precision Slotless Connectors (female)

Precision slotless female connectors are used to improve accuracy. The slotless contacts are not affected by the slight variations in male contact pin diameter. However, it is still advisable to inspect them regularly for damage.

NOTE

This is particularly important when mating nonprecision to precision devices.

Cleaning Connectors

Clean connectors are essential for ensuring the integrity of RF and microwave coaxial connections.

1. Use Compressed Air or Nitrogen

WARNING

Always use protective eyewear when using compressed air or nitrogen.

Use compressed air (or nitrogen) to loosen particles on the connector mating plane surfaces.

You can use any source of clean, dry, low-pressure compressed air or nitrogen that has an effective oil-vapor filter and liquid condensation trap placed just before the outlet hose.

Ground the hose nozzle to prevent electrostatic discharge, and set the air pressure to less than 414 kPa (60 psi) to control the velocity of the air stream. High-velocity streams of compressed air can cause electrostatic effects when directed into a connector. These electrostatic effects can damage the device. Refer to “**Electrostatic Discharge**” earlier in this chapter for additional information.

2. Clean the Connector Threads

WARNING

Keep isopropyl alcohol away from heat, sparks, and flame. Store in a tightly closed container. It is extremely flammable. In case of fire, use alcohol foam, dry chemical, or carbon dioxide; water may be ineffective.

Use isopropyl alcohol with adequate ventilation and avoid contact with eyes, skin, and clothing. It causes skin irritation, may cause eye damage, and is harmful if swallowed or inhaled. It may be harmful if absorbed through the skin. Wash thoroughly after handling.

In case of spill, soak up with sand or earth. Flush spill area with water.

Dispose of isopropyl alcohol in accordance with all applicable federal, state, and local environmental regulations.

Use a lint-free swab or cleaning cloth moistened with isopropyl alcohol to remove any dirt or stubborn contaminants on a connector that cannot be removed with compressed air or nitrogen. Refer to **Table 6-2 on page 6-2** for a part number for cleaning swabs.

- a. Apply a small amount of isopropyl alcohol to a lint-free cleaning swab.
- b. Clean the connector threads.

- c. Let the alcohol evaporate, then blow the threads dry with a gentle stream of clean, low-pressure compressed air or nitrogen. Always completely dry a connector before you reassemble or use it.

3. Clean the Mating Plane Surfaces

- a. Apply a small amount of isopropyl alcohol to a lint-free cleaning swab.
- b. Clean the center and outer conductor mating plane surfaces. Refer to **Figure 2-1 on page 2-3**. When cleaning a female connector, avoid snagging the swab on the center conductor contact fingers by using short strokes.
- c. Let the alcohol evaporate, then blow the connector dry with a gentle stream of clean, low-pressure compressed air or nitrogen. Always completely dry a connector before you reassemble or use it.

4. Inspect

Inspect the connector again to make sure that no particles or residue are present.

Gaging Connectors

The gages available from Keysight Technologies are intended for preventive maintenance and troubleshooting purposes only. (See [Table 6-1 on page 6-1](#) for part number information.) They are effective in detecting excessive center conductor protrusion or recession, and conductor damage on DUTs, test accessories, and the calibration kit devices. **Do not use the gages for precise pin depth measurements.**

Connector Gage Accuracy

The connector gages are only capable of performing coarse measurements. They do not provide the degree of accuracy necessary to precisely measure the pin depth of the kit devices. This is partially due to the repeatability uncertainties that are associated with the measurement. Only the factory—through special gaging processes and electrical testing— can accurately verify the mechanical characteristics of the devices.

With proper technique, however, the gages are useful in detecting gross pin depth errors on device connectors. To achieve maximum accuracy, random errors must be reduced by taking the average of at least three measurements having different gage orientations on the connector. Even the resultant average can be in error by as much as ± 0.0001 inch due to systematic (biasing) errors usually resulting from worn gages and gage masters. The information in [Table 2-2 on page 2-4](#) assumes new gages and gage masters. Therefore, these systematic errors were not included in the uncertainty analysis. As the gages undergo more use, the systematic errors can become more significant in the accuracy of the measurement.

The measurement uncertainties (see [Table 2-2 on page 2-4](#)) are primarily a function of the assembly materials and design, and the unique interaction each device type has with the gage. Therefore, these uncertainties can vary among the different devices. For example, note the difference between the uncertainties of the opens and shorts in [Table 2-2](#).

The observed pin depth limits in [Table 2-2](#) add these uncertainties to the typical factory pin depth values to provide practical limits that can be referenced when using the gages. See [“Pin Depth” on page 2-2](#). Refer to [“Kit Contents” on page 1-1](#) for more information on the design of the calibration devices in this kit.

NOTE

When measuring pin depth, the measured value (resultant average of three or more measurements) contains measurement uncertainty and is **not** necessarily the true value. Always compare the measured value with the **observed** pin depth limits (which account for measurement uncertainties) in [Table 2-2 on page 2-4](#) to evaluate the condition of device connectors.

When to Gage Connectors

Gage a connector at the following times:

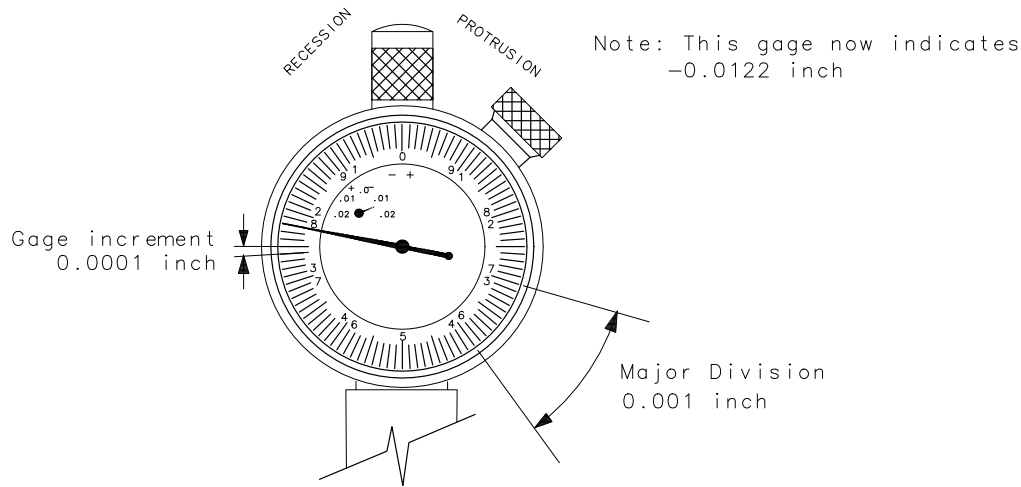
- Prior to using a device for the first time: record the pin depth measurement so that it can be compared with future readings. (It will serve as a good troubleshooting tool when you suspect damage may have occurred to the device.)
- If either visual inspection or electrical performance suggests that the connector interface may be out of typical range (due to wear or damage, for example).
- If a calibration device is used by someone else or on another system or piece of equipment.
- Initially after every 100 connections, and after that as often as experience indicates.

Reading the Connector Gage

The gage dial is divided into increments of 0.0001 inch and major divisions of 0.001 inch (see **Figure 3-2**). For each revolution of the large dial, the smaller dial indicates a change of 0.01 inch. Use the small dial as the indicator of multiples of 0.01 inch. In most connector measuring applications, this value will be zero.

When making a measurement, the gage dial indicator will travel in one of two directions. If the center conductor is recessed from the zero reference plane, the indicator will move counterclockwise to indicate the amount of **recession**, which is read as a negative value. If the center conductor protrudes, the indicator will move clockwise to indicate the amount of **protrusion**, which is read as a positive value. Refer to **“Pin Depth” on page 2-2** for definitions of protrusion and recession.

Figure 3-2 Reading the Connector Gage



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Gaging Procedures

Gaging Male Type-N Connectors

NOTE

Always hold a connector gage by the gage barrel, below the dial indicator. This gives the best stability, and improves measurement accuracy.

1. Select the proper gage for your connector. (Refer to [Table 6-2](#) for the gage set part number).
2. Inspect and clean the gage, gage master, and device to be gaged. Refer to [“Visual Inspection”](#) and [“Cleaning Connectors”](#) earlier in this chapter.
3. Zero the connector gage (refer to [Figure 3-3](#)):
 - a. While holding the gage by the barrel, and without turning the gage or the gage master, screw the gage master connecting nut onto the male gage, just until you meet resistance. Connect the nut finger tight. Do not overtighten.
 - b. Use the torque wrench recommended for use with this kit to tighten the connecting nut to 135 N-cm (12 in-lb). Refer to [“Connections” on page 3-16](#) for more information.
 - c. Loosen the dial lock screw on the gage and rotate the gage dial so that the pointer corresponds to the correction value noted on the gage master. Do not adjust the gage dial to zero, unless the correction value on the gage master is zero.

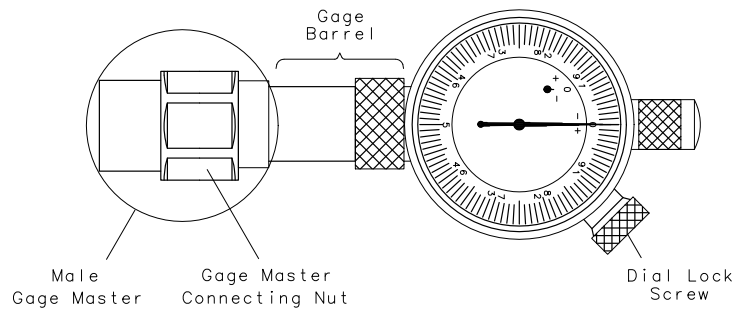
- d. Tighten the dial lock screw and remove the gage master.
 - e. Attach and torque the gage master to the gage once again to verify that the setting is repeatable. Remove the gage master.
 4. Gage the device connector (refer to **Figure 3-3**):
 - a. While holding the gage by the barrel, and without turning the gage or the device, screw the connecting nut of the device being measured onto the gage, just until you meet resistance. Connect the nut finger-tight. Do not overtighten.
 - b. Use the torque wrench recommended for use with this kit to tighten the connecting nut to 135 N-cm (12 in-lb). Refer to **“Connections” on page 3-16** for more information.
 - c. Gently tap the barrel of the gage with your finger to settle the gage reading.
 - d. Read the gage indicator dial. If the needle has moved clockwise, the center conductor is **protruding** by an amount indicated by the black numbers. If the needle has moved counterclockwise, the center conductor is **recessed** by an amount indicated by the red numbers.

For maximum accuracy, measure the connector a minimum of three times and take an average of the readings. After each measurement, rotate the gage a quarter-turn to reduce measurement variations that result from the gage or the connector face not being exactly perpendicular to the center axis.
 - e. Compare the average reading with the observed pin depth limits in **Table 2-2 on page 2-4**.

Figure 3-3 Gaging Male Type-N Connectors

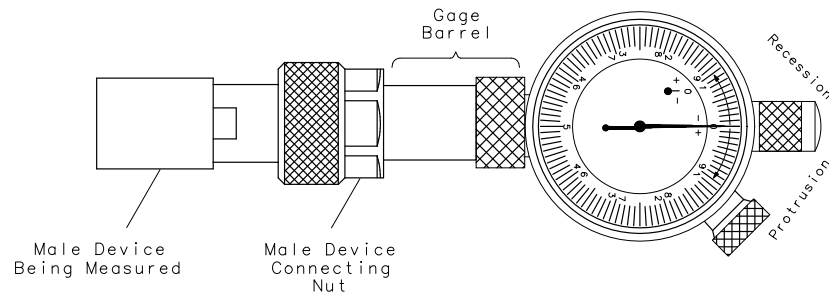
Zero the Connector Gage

- Screw the male gage master connecting nut onto the male gage.
- Torque the connecting nut.
- Loosen the dial lock screw.
- Adjust the gage to the correction value noted on the gage master.
- Tighten the dial lock screw.
- Remove the gage master.



Gage the Device Connector

- Screw the male device connecting nut onto the male gage.
- Torque the connecting nut.
- Gently tap the gage barrel to settle the reading.
- Read recession or protrusion from the gage.
- Remove the device.



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Gaging Female Type-N Connectors

NOTE

Always hold a connector gage by the gage barrel, below the dial indicator. This gives the best stability, and improves measurement accuracy.

1. Select the proper gage for your connector. (Refer to [Table 6-2](#) for the gage set part number).
2. Inspect and clean the gage, gage master, and device to be gaged. Refer to [“Visual Inspection”](#) and [“Cleaning Connectors”](#) earlier in this chapter.
3. Zero the connector gage (refer to [Figure 3-4](#)):
 - a. While holding the gage by the barrel, and without turning the gage or the gage master, screw the gage connecting nut onto the female gage master, just until you meet resistance. Connect the nut finger-tight. Do not overtighten.
 - b. Use the torque wrench recommended for use with this kit to tighten the connecting nut to 135 N-cm (12 in-lb). Refer to [“Connections” on page 3-16](#) for more information.
 - c. Loosen the dial lock screw on the gage and rotate the gage dial so that the pointer corresponds to the correction value noted on the gage master. Do not adjust the gage dial to zero, unless the correction value on the gage master is zero.
 - d. Tighten the dial lock screw and remove the gage master.
 - e. Attach and torque the gage master to the gage once again to verify that the setting is repeatable. Remove the gage master.
4. Gage the device connector (refer to [Figure 3-3 on page 3-12](#)):
 - a. While holding the gage by the barrel, and without turning the gage or the device, screw the gage connecting nut onto the device being measured, just until you meet resistance. Connect the nut finger-tight. Do not overtighten.
 - b. Use the torque wrench recommended for use with this kit to tighten the connecting nut to 135 N-cm (12 in-lb). Refer to [“Connections” on page 3-16](#) for more information.
 - c. Gently tap the barrel of the gage with your finger to settle the gage reading.
 - d. Read the gage indicator dial. If the needle has moved clockwise, the center conductor is **protruding** by an amount indicated by the black numbers. If the needle has moved counterclockwise, the center conductor is **recessed** by an amount indicated by the red numbers.

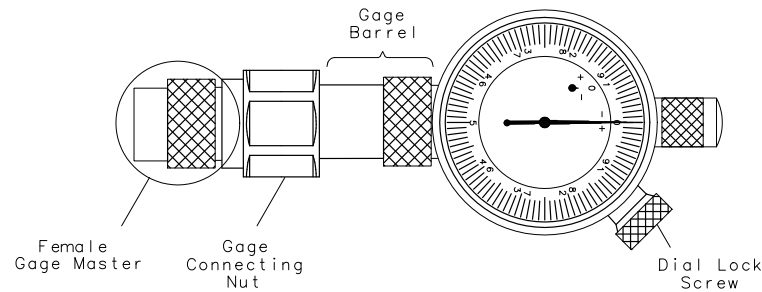
For maximum accuracy, measure the connector a minimum of three times and take an average of the readings. After each measurement, rotate the gage a quarter-turn to reduce measurement variations that result from the gage or the connector face not being exactly perpendicular to the center axis.

- e. Compare the average reading with the observed pin depth limits in [Table 2-2 on page 2-4](#).

Figure 3-4 Gaging Female Type-N Connectors

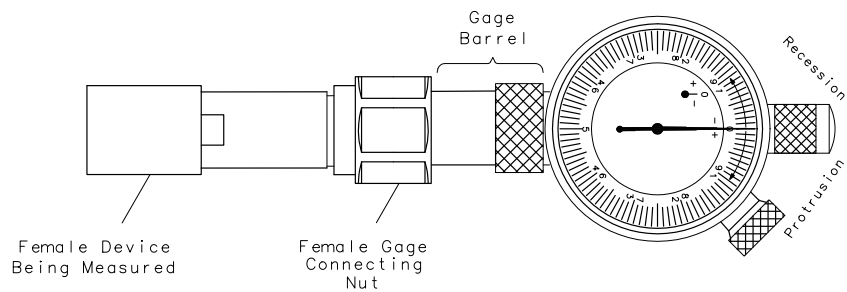
Zero the Connector Gage

- Screw the female gage connecting nut onto the female gage master.
- Torque the connecting nut.
- Loosen the dial lock screw.
- Adjust the gage to the correction value noted on the gage master.
- Tighten the dial lock screw.
- Remove the gage master.



Gage the Device Connector

- Screw the female gage connecting nut onto the female device.
- Torque the connecting nut.
- Gently tap the gage barrel to settle the reading.
- Read recession or protrusion from the gage.
- Remove the device.



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Connections

Good connections require a skilled operator. **The most common cause of measurement error is bad connections.** The following procedures illustrate how to make good connections.

How to Make a Connection

Preliminary Connection

1. Ground yourself and all devices. Wear a grounded wrist strap and work on a grounded, conductive table mat. Refer to **“Electrostatic Discharge” on page 3-1** for ESD precautions.
2. Visually inspect the connectors. Refer to **“Visual Inspection” on page 3-3**.
3. If necessary, clean the connectors. Refer to **“Cleaning Connectors” on page 3-6**.
4. Use a connector gage to verify that all center conductors are within the observed pin depth values in **Table 2-2 on page 2-4**. Refer to **“Gaging Connectors” on page 3-8**.
5. Carefully align the connectors. The male connector center pin must slip concentrically into the contact finger of the female connector.
6. Push the connectors straight together.

CAUTION

Do not turn the device body. Only turn the connector nut. Damage to the center conductor can occur if the device body is twisted

Do **not** twist or screw the connectors together. As the center conductors mate, there is usually a slight resistance.

7. The preliminary connection is tight enough when the mating plane surfaces make uniform, light contact. Do not overtighten this connection.

A connection in which the outer conductors make gentle contact at all points on both mating surfaces is sufficient. Very light finger pressure is enough to accomplish this.

8. Make sure the connectors are properly supported. Relieve any side pressure on the connection from long or heavy devices or cables.

Final Connection Using a Torque Wrench

Use a torque wrench to make a final connection. **Table 3-1** provides information about the torque wrench recommended for use with this calibration kit. A torque wrench is **not** included in the calibration kit. Refer to **Chapter 6** for part number and ordering information.

Table 3-1 Torque Wrench Information

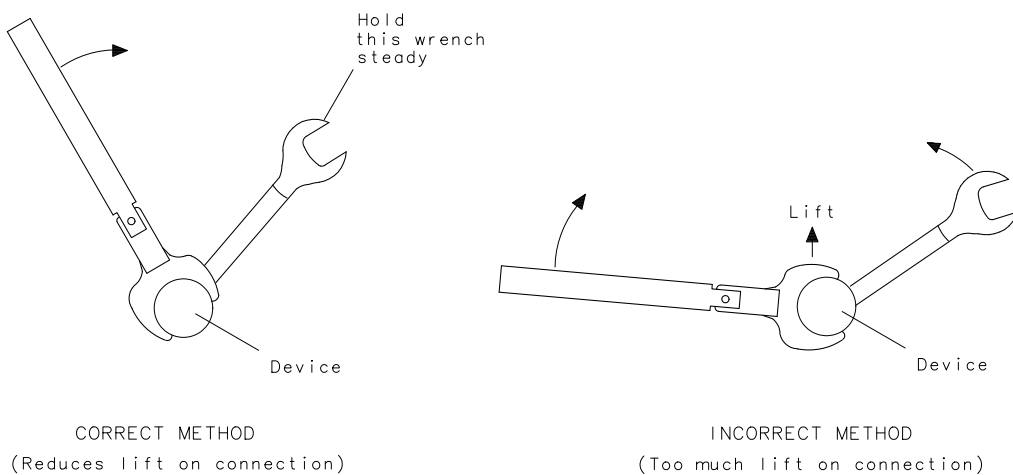
Connector Type	Torque Setting	Torque Tolerance
Type-N	135 N-cm (12 in-lb)	± 13.5 N-cm (± 1.2 in-lb)

Using a torque wrench guarantees that the connection is not too tight, preventing possible connector damage. It also guarantees that all connections are equally tight each time.

Prevent the rotation of anything other than the connector nut that you are tightening. It may be possible to do this by hand if one of the connectors is fixed (as on a test port). In all situations, however, it is recommended that you use an open-end wrench to keep the body of the device from turning. Refer to **Chapter 6** for part number and ordering information.

1. Position both wrenches within 90 degrees of each other before applying force. See **Figure 3-5**. Wrenches opposing each other (greater than 90 degrees apart) will cause a lifting action which can misalign and stress the connections of the devices involved. This is especially true when several devices are connected together.

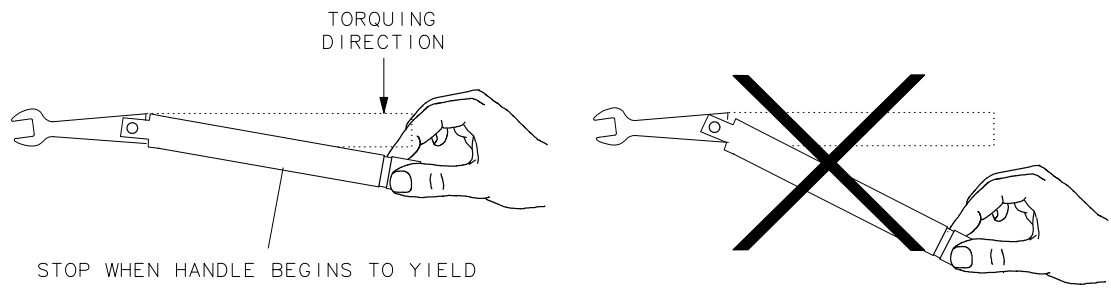
Figure 3-5 Wrench Positions



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2. Hold the torque wrench lightly, at the end of the handle only (beyond the groove). See **Figure 3-6**.

Figure 3-6 Using the Torque Wrench



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3. Apply downward force perpendicular to the wrench handle. See **Figure 3-6**. This applies torque to the connection through the wrench.

Do not hold the wrench so tightly that you push the handle straight down along its length rather than pivoting it, otherwise you apply an unknown amount of torque.

4. Tighten the connection just to the torque wrench break point. The wrench handle gives way at its internal pivot point. See **Figure 3-6**. Do not tighten the connection further.

CAUTION

You don't have to fully break the handle of the torque wrench to reach the specified torque; doing so can cause the handle to kick back and loosen the connection. Any give at all in the handle is sufficient torque.

Do not pivot the wrench handle on your thumb or other fingers, otherwise you apply an unknown amount of torque to the connection when the wrench reaches its break point.

Do not twist the head of the wrench relative to the outer conductor mating plane. If you do, you apply more than the recommended torque.

How to Separate a Connection

To avoid lateral (bending) force on the connector mating plane surfaces, always support the devices and connections.

CAUTION

Turn the connector nut, not the device body. Major damage to the center conductor can occur if the device body is twisted.

1. Use an open-end wrench to prevent the device body from turning.
2. Use the torque wrench to loosen the connector nut.
3. Complete the separation by hand, turning only the connector nut.
4. Pull the connectors straight apart without twisting, rocking, or bending either of the connectors.

Handling and Storage

- Install the protective end caps and store the calibration devices in the foam-lined storage case when not in use.
- Never store connectors loose in a box, desk, or bench drawer. This is the most common cause of connector damage during storage.
- Keep connectors clean.

Use, Maintenance, and Care of the Devices
Handling and Storage

- Do not touch mating plane surfaces. Natural skin oils and microscopic particles of dirt are easily transferred to a connector interface and are very difficult to remove.
- Do not set connectors contact-end down on a hard surface. The plating and the mating plane surfaces can be damaged if the interface comes in contact with any hard surface.

4 Performance Verification

Introduction

The performance of your calibration kit can only be verified by returning the kit to Keysight Technologies for recertification. The equipment required to verify the specifications of the devices in the kit has been specially manufactured and is not commercially available.

How Keysight Verifies the Devices in This Kit

Keysight verifies the specifications of these devices as follows:

- 1. The residual microwave error terms of the test system are verified with precision airlines and shorts that are directly traced to NIST (National Institute of Standards and Technology). The airline and short characteristics are developed from mechanical measurements. The mechanical measurements and material properties are carefully modeled to give very accurate electrical representation. The mechanical measurements are then traced to NIST through various plug and ring gages and other mechanical measurements.**
- 2. Each calibration device is electrically tested on this system. For the initial (before sale) testing of the calibration devices, Keysight includes the test measurement uncertainty as a guardband to guarantee each device meets the published specification. For recertifications (after sale), no guardband is used and the measured data is compared directly with the specification to determine the pass or fail status. The measurement uncertainty for each device is, however, recorded in the calibration report that accompanies recertified kits.**

These two steps establish a traceable link to NIST for Keysight to the extent allowed by the institute's calibration facility. The specifications data provided for the devices in this kit is traceable to NIST through Keysight Technologies.

Recertification

The following will be provided with a recertified kit:

- a new calibration sticker affixed to the case
- a certificate of calibration
- a calibration report for each device in the kit listing measured values, specifications, and uncertainties

NOTE

A list of NIST traceable numbers may be purchased upon request to be included in the calibration report.

Keysight Technologies offers a **Standard** calibration for the recertification of this kit. For more information, contact Keysight Technologies. For contact information, see [page 5-5](#).

How Often to Recertify

The suggested initial interval for recertification is 12 months or sooner. The actual need for recertification depends on the use of the kit. After reviewing the results of the initial recertification, you may establish a different recertification interval that reflects the usage and wear of the kit.

NOTE

The recertification interval should begin on the date the kit is first used after the recertification date.

Where to Send a Kit for Recertification

Contact Keysight Technologies for information on where to send your kit for recertification. For contact information, refer to [page 5-5](#).

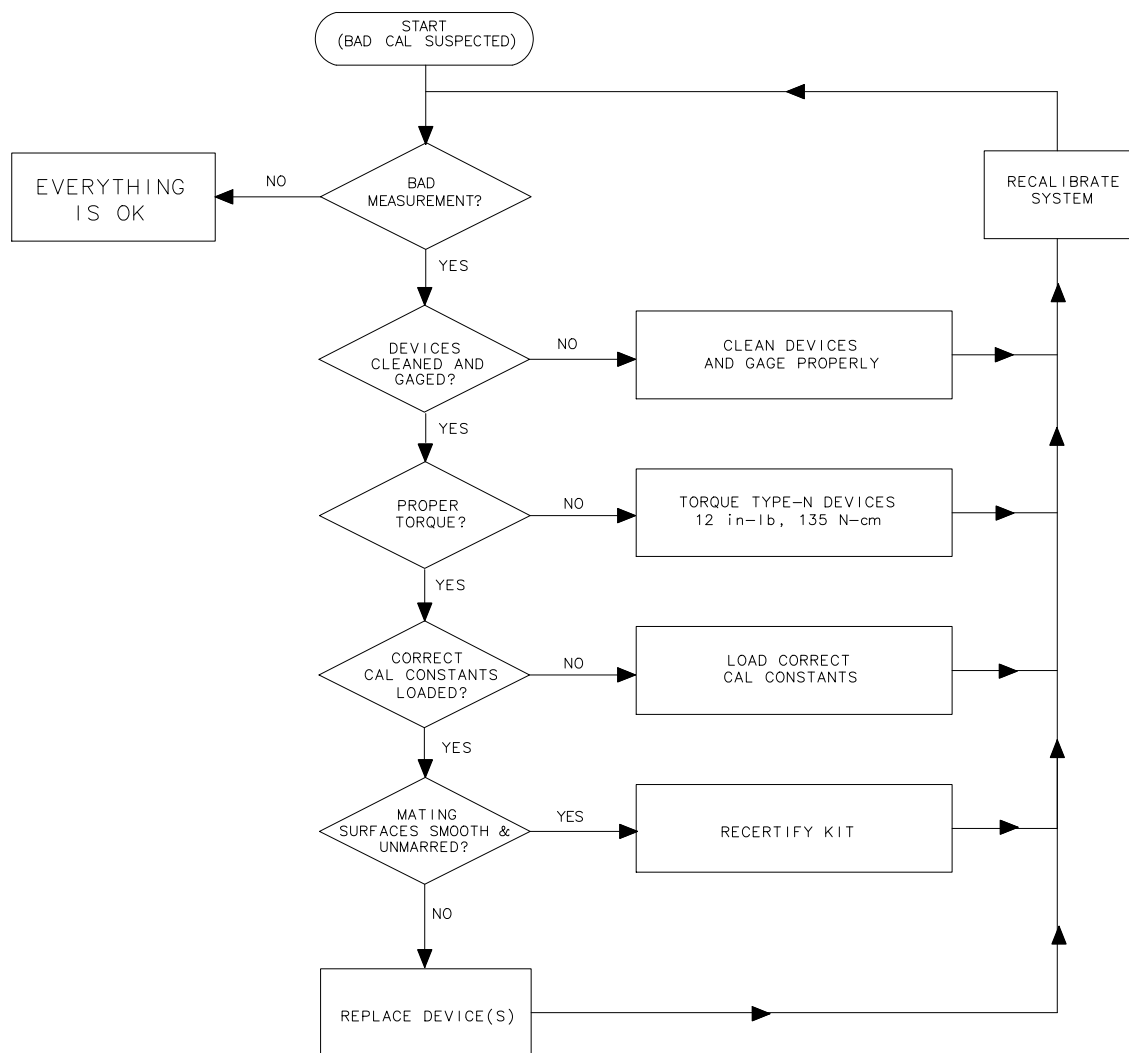
When you return the kit, complete and attach a service tag. Refer to [“Returning a Kit or Device to Keysight” on page 5- 4](#) for details.

5 Troubleshooting

Troubleshooting Process

If you suspect a bad calibration, or if your network analyzer does not pass performance verification, follow the steps in **Figure 5-1**.

Figure 5-1 Troubleshooting Flowchart



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Where to Look for More Information

This manual contains limited information about network analyzer system operation. For detailed information on using a VNA, ENA or PNA series network analyzer, refer to the appropriate user guide or online Help.

- To view the ENA or PNA online Help, press the Help key on the front panel of the network analyzer.
- To view an online VNA user guide, use the following steps:
 1. Go to www.keysight.com.
 2. Enter your VNA model number (Ex: N5242A) in the Search box and click Search.
 3. Under the heading Manuals & Guides, click on the title/hyperlink for the document PDF you want to view.

If you need additional information, see **“Contacting Keysight” on page 5- 5.**

Returning a Kit or Device to Keysight

If your kit or device requires service, contact Keysight Technologies for information on where to send it. See **“Contacting Keysight” on page 5-5** for contact information. Include a service tag (located near the end of this manual) on which you provide the following information:

- your company name and address
- a technical contact person within your company, and the person's complete telephone number
- the model number and serial number of the kit
- the part number and serial number of each device
- the type of service required
- a **detailed** description of the problem and how the device was being used when the problem occurred (such as calibration or measurement)

Contacting Keysight

Assistance with test and measurements needs and information on finding a local Keysight office are available on the Web at:

www.keysight.com/find/assist

If you do not have access to the Internet, please contact your Keysight field engineer.

NOTE

In any correspondence or telephone conversation, refer to the Keysight product by its model number and full serial number. With this information, the Keysight representative can determine whether your product is still within its warranty period.

6 Replaceable Parts

Introduction

Table 6-1 lists the replacement part numbers for items included in the 85054D calibration kit and **Figure 6-1** illustrates each of these items.

Table 6-2 lists the replacement part numbers for items recommended or required for successful operation but not included in the calibration kit.

To order a listed part, note the description, the part number, and the quantity desired. Refer to **“Contacting Keysight” on page 5-5**.

Table 6-1 Replaceable Parts for the 85054D Calibration Kit^a

Description	Qty Per Kit	Keysight Part Number
Calibration Devices (50Ω Type-N)		
Type-N -m- broadband load	1	85054-60063 85054-60046 ^b
Type-N -f- broadband load	1	85054-60064 85054-60047 ^b
Type-N -m- offset short	1	85054-60025
Type-N -f- offset short	1	85054-60026
Type-N -m- offset open	1	85054-60027
Type-N -f- offset open	1	85054-60028
Adapters		
Type-N -m- to Type-N -m-	1	85054-60038
Type-N -f- to Type-N -f-	1	85054-60037
Type-N -f- to 7 mm	2	85054-60031
Type-N -m- to 7 mm	2	85054-60032
Wrenches		
3/4 in., 135 N-cm (12 in-lb) Torque	1	8710-1766
Spanner	1	08513-20014

Table 6-1 Replaceable Parts for the 85054D Calibration Kit^a

Description	Qty Per Kit	Keysight Part Number
Miscellaneous Items		
Storage case assembly	1	5180-8419
Foam pad (for lid of case)	1	5181-5542
Foam pad (for body of case)	1	85054-80033
User's and service guide	1	85054-90050
Protective End Cap -f-	as required	1401-0225
See footnotes on the following page.		

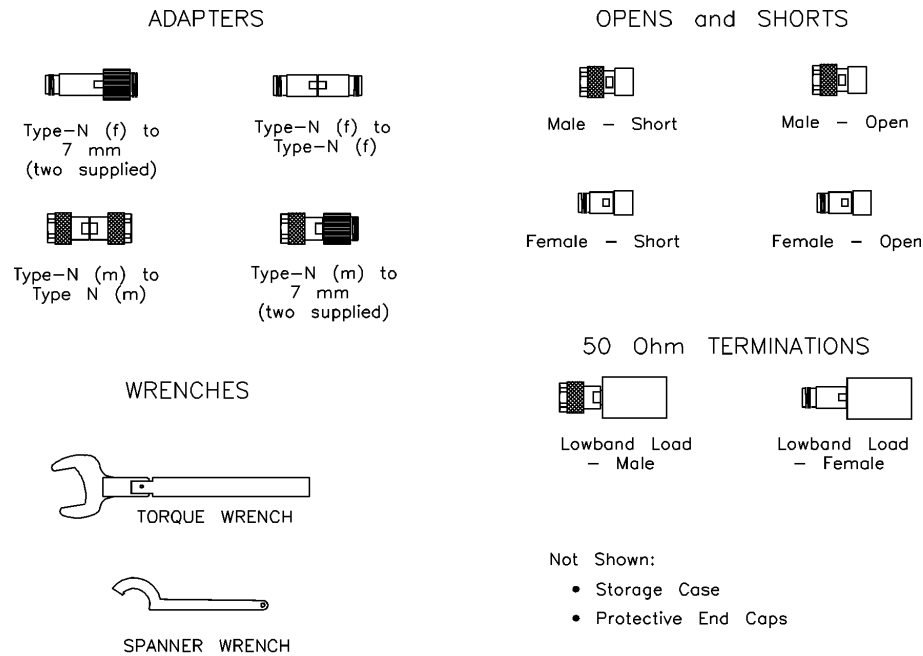
- Refer to **"Clarifying the Terminology of a Connector Interface" on page 1-7.**
- Part numbers in italic typeface are for production assemblies and cannot be ordered by customers. Both the replacement part number and the production part number are interchangeable and have identical performance.

Table 6-2 Replaceable Parts—Items Not Included in the Calibration Kit^a

Description	Qty	Keysight Part Number
Type-N gage set	1	85054-60049
Keysight Application Note AN 1287-11	1	5989-4840EN
1/2 in and 9/16 in open-end wrench	1	8710-1770
Adapter: Type-N to 7 mm 50 ohm -m- (extendable/retractable sleeve)	1	85054-60009
Adapter: Type-N to 7 mm 50 ohm -f- (extendable/retractable sleeve)	1	85054-60001
Grounding wrist strap	1	9300-1367
5 ft grounding cord for wrist strap	1	9300-0980
2 ft by 4 ft conductive table mat with 15 ft grounding wire	1	9300-0797
ESD heel strap	1	9300-1308
Anhydrous isopropyl alcohol (>92% pure) ^b	--	--
Foam tipped cleaning swabs	100	9301-1243

- Refer to **"Clarifying the Terminology of a Connector Interface" on page 1-7.**
- Keysight can no longer safely ship isopropyl alcohol, so customers should purchase it locally.

Figure 6-1 Replaceable Parts for the 85054D Calibration Kit



parts

A: Standard Definitions

Class Assignments and Standard Definitions Values are Available on the Web

Class assignments and standard definitions may change as more accurate model and calibration methods are developed. You can download the most accurate class assignments and standard definitions from Keysight's Calibration Kit Definitions Web page at

<https://www.keysight.com/us/en/assets/9922-01521/technical-specifications/Calibration-Kit-Definitions.pdf>.

For a detailed discussion of calibration kits, refer to the Keysight Application Note, "Specifying Calibration Standards and Kits for Keysight Vector Network Analyzers." This application note covers calibration standard definitions, calibration kit content and its structure requirements for Keysight vector network analyzers. It also provides some examples of how to set up a new calibration kit and how to modify an existing calibration kit definition file. To download a free copy, go to www.keysight.com and enter literature number 5989-4840EN in the Search window.

Standard Definitions

Class Assignments and Standard Definitions Values are Available on the Web

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