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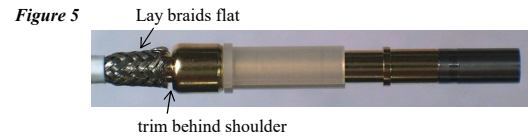
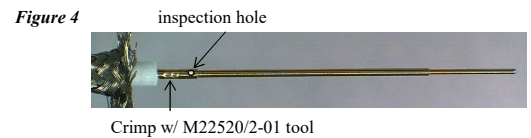
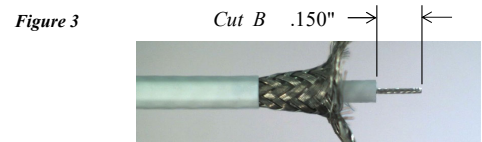
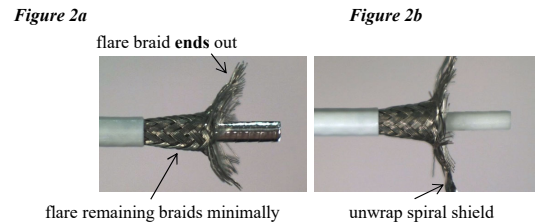
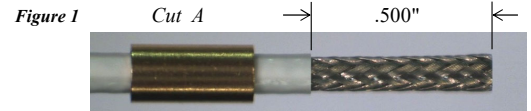
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Termination Instructions for PIC P/N 190767 - M39029 Size 12 Socket Contact
(for V73263 / V76261 / V75268 Coax Cable)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Tweezers
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool Daniels Y187 Hex Crimp Die Set, cavity B (.156") <i>Alternate:</i> M22520 / 5 - 39 Hex Crimp Die Set, cavity B (.160") Soldering equipment, <i>OR</i> M22520 / 2 - 01 Center Contact Crimp Tool, dial setting @ # 5 PIC Positioner P/N 110919

Dimensions in Inches - NOT to Scale

- 1) Cut cable end squarely, and re-shape the cut end to concentric. Install the crimp ferrule onto the cable (Fig. 1). Make Cut A @ .500" from cable end, scoring the jacket only (Fig. 1). Do Not nick or cut into wire braids. Remove jacket (Fig. 1).
- 2) Flare the braid ends out, keeping at least half the braid weave intact (Fig. 2a). Flare the remaining braids minimally, to keep braid weave as intact as possible (Figs. 2a & 2b).
- 3) For **V73263**, unwrap the helical inner shield all the way down to the bottom (of Cut A), without twisting it (Fig. 2b). Tweezers may be used to grip and unwind helical strip. The helical strip can be positioned straight along the inside of the flared braids (Fig. 2b). The dielectric must be exposed for the full strip length (to Cut A).
 For **V76261**, flare the wire braids minimally, enough to allow access with the X-acto knife blade to slit the foil lengthwise in two or three locations around the cable. Flare out the foil to the same extent as the wire braids. The dielectric must be exposed for the full strip length (to Cut A).
 For **V75268**, flare all braids out minimally. The dielectric must be exposed for the full strip length (to Cut A).
- 4) Make Cut @ .150" from the cable end, through the dielectric (Fig 3). Do Not nick or cut into the center conductor. Remove dielectric, verify center conductor integrity.
- 5) Verify proper fit of the center contact onto the center conductor. Solder or crimp the center contact onto cable center conductor (Fig. 4). If crimping, use M22520/2-01 crimp tool, with dial setting @ # 5. Use PIC # 110919 positioner (Daniels # K1972), or crimp between inspection hole and end of contact (Fig. 4).
- 6) Inspect and clean dielectric and center contact as needed, using clean, dry compressed air if necessary (carefully). Inspect and clean connector body as needed.
- 7) Install the connector body over the dielectric and under the shields, until the center contact is fully seated (Fig. 5). Avoid disturbing or deforming the dielectric.
- 8) Smooth all braids firmly down over the rear of the connector body, covering the knurl. Trim off any excess braids past the knurled rear body, trim behind the shoulder (Fig. 5).
- 9) Pull the crimp ferrule up over the braids. Secure the body while positioning the ferrule, to avoid shifting the center conductor. Trim any stray braids at the shoulder prior to seating the ferrule against the connector body (ex. Fig. 6).
- 10) Verify that the connector is fully seated onto the cable. Confirm the center contact position; the end of the center contact should be .015" ± .008" from the front end of connector body (Fig. 6). Crimp the ferrule with M22520/5-01 crimp tool and Daniels # Y187 hex die set, .156" hex (Fig. 7).
Alternate crimp die: M22520 / 5 - 39 hex die set, cavity B, .160" hex (Fig. 7).



Note: Connector Length added to cable = + 1.37" nominal