PIC **Wire & Cable**
A Division of the Angelus Corporation
Ph (262) 246-0500 Fax (262) 246-0450 www.picwire.com
PO Box 330 Sussex, WI 53089

Termination Instructions	T-190867
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Termination Instructions for PIC P/N 190867 - M39029 Size 12 Socket Contact

(for S83204 / S86208 / S88207 Coax Cable)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	M22520 / 5 - 01 Hex Crimp Tool M22520 / 5 - 41 Hex Crimp Die Set Soldering equipment, *OR* M22520 / 2 - 01 Center Contact Crimp Tool PIC Positioner P/N 110901 (Daniels P/N K1947) if used

1) Install the crimp ferrule onto the cable (Fig 1). Make Cut A @ .250" from cable end, through the jacket, braids, and foil (Fig. 1). Do not cut into dielectric. Remove jacket, braids, and foil (S83204).

2) Make Cut B @ .500" from the cable end, through the jacket only (Fig. 1). Do Not nick or cut into the wire braids. Leave this section of jacket on. Clean the exposed dielectric of debris or stray braids.

3) Make Cut C @ .150" from the cable end, through the dielectric (Fig 1). Do Not nick or cut into the center conductor. Remove dielectric, verify center conductor integrity.

4) Verify proper fit of the center contact onto the center conductor. Solder or crimp the center contact onto cable center conductor (Fig. 2). If crimping, use M22520/2-01 crimp tool, with dial setting @ # 7. Use PIC # 110901 positioner (Daniels # K1947), or crimp between inspection hole and end of contact (Fig. 2).

5) Remove jacket at Cut B. Flare the wire braids away from the cable. Slit the foil shield lengthwise in three places around the cable and flare out foil (S83204). Flare out the inner strip braids to expose the dielectric all the way down to the bottom (Fig. 3). The dielectric must be exposed for the full length of the strip dimension (to Cut B).

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. Avoid disturbing or deforming the dielectric.

8) Smooth all braids 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. 4).

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.

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 the connector body (Fig. 5). Crimp the ferrule with M22520/5-01 crimp tool and M22520 / 5 - 41 hex die set, cavity B, .178" hex (Fig. 5).

Dimensions in Inches - NOT to Scale

Figure 1

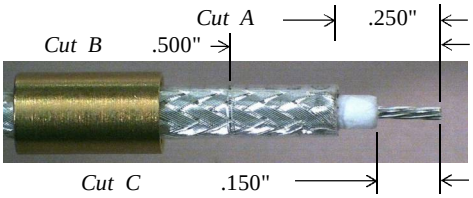

Figure 2

Figure 3

Figure 4

Figure 5

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