

PIC Wire & Cable	Termination Instructions	T-190752
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Termination Instructions for PIC 190752 MCX 90° Plug connector
for V73263, V75268, and V76261

Recommended Hand Tools	X-acto Knife, Sharp Razor, Wire Cutters, fine point tweezers, pick
Required Tooling	Arbor press fixture with F-40 die OR an equivalent pressing tool and die (0.25"), Heat Gun, Soldering Iron w/ fine tip OR American Beauty # 105A3 Resistance soldering tweezers, Loctite # 271 M22520/5-01 Hex Crimp tool w/ M22520/5-41 (.178" hex) or equivalent

- 1 Cut the cable end square. Install the crimp ferrule onto cable. Make Cut B through the outer jacket, and all shields. Do not nick or cut into the dielectric. Make Cut A through the Outer jacket. Do not nick, or cut into the braids. (Fig 1)
- 2 Make Cut C through the dielectric. Do not nick or cut into the center conductor. Remove the dielectric at Cut C and immediately tin the center conductor by using a soldering iron. Do not use excessive amount of solder, as it can cause interference during step 4.
- 3 Flare out braids, approximately 45° maintaining braid weave as intact as possible. Unwrap the helical shield (V73263) and flare with wire braids, or slit and flare foil shield (V76261) as applicable (Fig. 2). Shields must be flared enough to accommodate installation of the connector body.
- 4 Clean the dielectric as needed, using dry compressed air if needed. Inspect and clean Connector Body as needed. Gently insert the connector over the dielectric, and under the shield(s), ensuring that the center conductor fits in the slot of the connector contact (Fig 3). If needed tweezers or a pick can be used to gently guide the center conductor into place. If center conductor extends past the center contact, remove cable and trim until center contact and center conductor are flush.
- 5 Solder the cable center conductor to the connector's center contact. Do not use an excessive amount of solder (Fig 4). Inspect connection to ensure that the solder does not extrude too far toward the opening. It is imperative that no contact occurs between the solder and the cap placed in step 9, as this will cause a short.
- 6 Smooth shields down flat over the rear of the connector body. Position crimp ferrule on the connector body. Secure the connector body while positioning the ferrule to avoid undue stress on the soldered joint. Trim any stray braids/foil at the shoulder prior to seating the ferrule against the connector cube (Fig 5).
- 7 Using M22520/5-01 Crimp Tool and M22520/5-41 Hex Die Set, Cavity B .178 hex, Position the Die such that the Hex flat is parallel to the connector cube (Fig 6). Verify integrity of soldered joint prior to crimping, then crimp the ferrule.
- 8 Inspect internal connector cavity for any stray braids or debris, clean as needed. Apply a minimal layer of Loctite 271 to interior edge of end cap counterbore (Fig. 7) and clean off any excess Loctite.
- 9 Install the end cap into the counterbore. Using the arbor press with die F-40 or an equivalent set up (centered over the end cap), press end cap into position until firmly and squarely seated (Fig. 8). Avoid using excess pressure to ensure functional integrity of the connector. Clean off any excess loctite.

