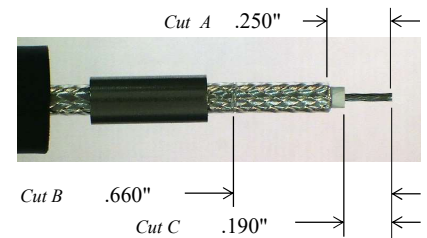
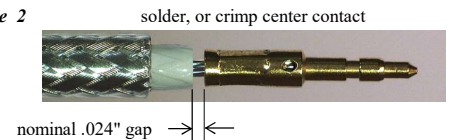
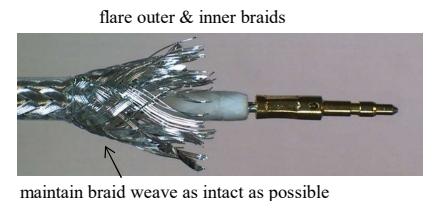
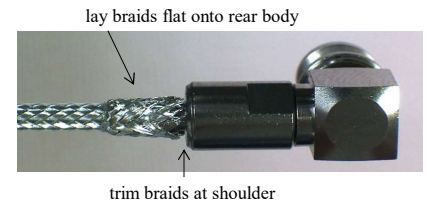
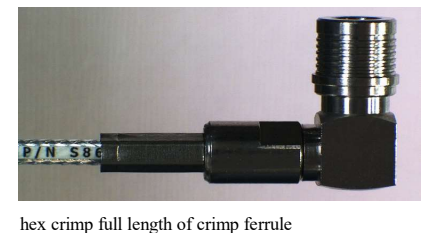


Termination Instructions for PIC P/N 110567, QMA 90° Plug Connector*(for S86208 / S88207 / S83204 Coax Cables)*

Recommended Hand Tools :	Sharp Razor, Wire Cutters, Small Needlenose Pliers, X-acto Knife
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool M22520 / 5- 09 Die Set, .068" hex for center contact / .178" hex for ferrule Soldering Equipment (optional), Heat Gun

- 1) Install ATUM and crimp ferrule unto cable. Make Cut A @ .250" from cable end, through the jacket (Fig. 1). Remove the jacket, remove exposed wire braids, foil, and/or strip braids (as applicable). Avoid cutting into the cable dielectric.
- 2) Make Cut B @ .660" from cable end, scoring the jacket (Fig. 1). Do Not nick or cut into the wire braids. Leave jacket in place.
- 3) Make Cut C @ .190" from the cable end, through the dielectric (Fig 1). Do Not nick or cut into the center conductor. Remove the dielectric. Verify conductor integrity, and exposed center conductor stranding is intact (as applicable).
- 4) If crimping the center contact, install the contact onto the cable center conductor. There should be a nominal .024" gap between the center contact and dielectric (Fig. 2). Crimp the contact using the M22520/5-01 hex crimp tool, with M22520/5-09 hex die set, cavity B .068" hex, crimping between inspection hole and end of contact (Fig. 2).
- 5) If soldering, install the center contact to verify correct fit. Remove the contact and tin the cable center conductor. Tin the center contact hole, and solder onto the cable center conductor. Clean contact and cable dielectric as needed, using clean, dry compressed air.
- 6) Remove the jacket at Cut B. Flare all braids out, exposing the dielectric down to Cut B (Fig. 3). Maintain braid weave as intact as possible (Fig. 3). Slit the foil (S83204) lengthwise in 2 - 3 places around the cable, and flare the foil out with braids (Fig 3).
- 7) Inspect and clean dielectric as needed, prior to installing the connector body onto the cable. Inspect and clean connector body entry as needed.
- 8) Install the connector body over dielectric and under flared shields, until center contact is fully seated and captivated. Verify that the center contact is captivated.
- 9) Smooth all braids down over the rear of connector body, covering the knurl (Fig. 4). Trim off any excess braids past the knurled rear body, at the shoulder (Fig. 4).
- 10) Pull the crimp ferrule up over braids, up to shoulder. Secure the body while locating the ferrule, to avoid shifting the center contact. Trim any stray braids at the shoulder prior to seating the ferrule against the connector body.
- 11) Verify the connector is fully seated onto the cable. Crimp the ferrule using M22520/5-01 hex crimp tool, with M22520/5-09 hex die set, cavity A .178" hex (Fig. 5). Secondary crimp is needed to crimp the full length of the crimp ferrule (Fig. 5).
- 12) Shrink the ATUM 12/3 dual wall shrink tube over the connector and onto cable, as shown (Fig. 6), starting at cube body.

Dimensions in Inches (NOT to Scale)

Figure 1**Figure 2****Figure 3****Figure 4****Figure 5****Figure 6**

Note: Connector Length added to cable = + .400" nominal (to centerline of connector interface)
 Connector Length added to cable = + .580" nominal (to outer end of cube body)