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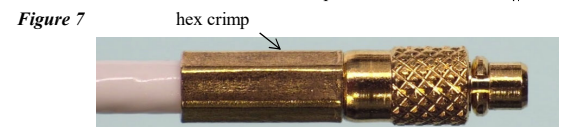
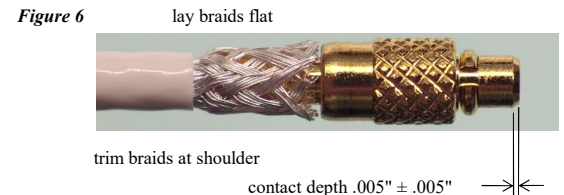
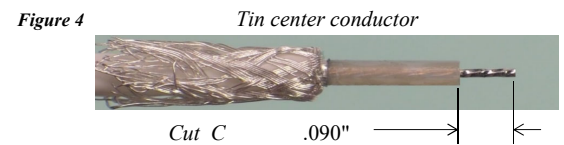
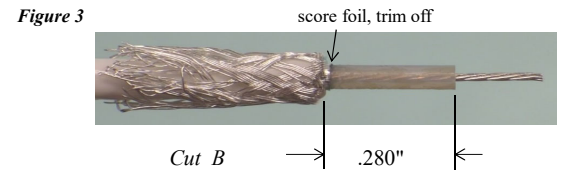
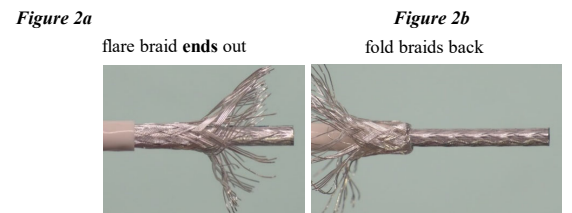
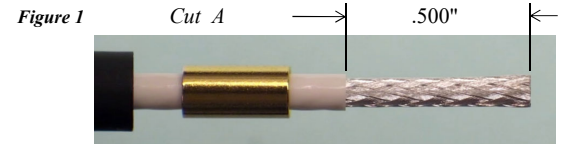
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### Termination Instructions for PIC P/N 111154 - MMCX Straight Plug (for S31601 Coax Cable)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Needlenose Pliers
Required Cable Tools :	Soldering equipment M22520/5 - 01 Hex Crimp Tool M22520/5 - 08 Hex Crimp Die Set, .128" hex Heat Gun

- 1) Cut cable end squarely, re-form to concentric shape. Install crimp ferrule onto the cable as shown (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). Fold all braids back to expose foil at Cut C (Fig. 2b), maintaining braid weave as intact as possible.
- 3) Score foil around the circumference of the cable just past the flared braids and lengthwise to the end of the cable. Use caution to avoid nicking or cutting any braids. Do not cut into the dielectric. Remove foil to expose the dielectric (Fig. 3). Apply heat with heatgun as necessary to weaken the bond of the foil to the dielectric. Do not exceed 500° F, and apply heat for 10 seconds maximum. Inspect the dielectric to ensure all foil was removed. There may be a blue residue left on the surface of the dielectric.
- 4) Make Cut B @ .280" from the folded braids, through the dielectric (Fig 3). Do Not nick or cut into the small, stranded center conductor. Remove dielectric, verify center conductor integrity, and ensure wire strands of center conductor maintain their initial twist; if necessary, re-twist them together if they are frayed or unwound at the ends (Fig. 3).
- 5) Tin the center conductor. Make Cut C, trim off the tinned center conductor @ .090" from the end of the dielectric (Fig. 4).
- 6) Solder the center contact onto cable center conductor (Fig. 5).
- 7) Inspect and clean dielectric and center contact as needed, using clean, dry compressed air if necessary (carefully). Inspect and clean connector body as needed.
- 8) Install the connector body onto the dielectric and center contact, until the center contact is fully seated. Verify the front of center contact is flush with or slightly recessed from front of MMCX connector interface end (Fig. 6). Push braids forward, lay all braids down flat over the rear of the connector body, covering the knurl (Fig. 6), and trim braids at the shoulder (Fig. 6).
- 9) While securing connector body, pull crimp ferrule up over braids, up to the shoulder (Fig. 7), and trim off any stray braids. Confirm the correct center contact location (Fig. 6). Crimp the ferrule, using M/22520/5-01 hex crimp tool, with M22520/5-08 hex crimp die set (.128" hex) as shown (Fig. 7).
- 10) Locate and shrink the ATUM 4/1 × .750" dual wall shrink tube over the connector and cable, starting at the end of diamond knurl section (Fig. 8).

Dimensions in Inches - NOT to Scale



Note : Connector Length added to cable = + .035" nominal