

PIC Wire & Cable

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Termination Instructions

T-110978

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Uncontrolled if Printed

Termination Instructions for PIC P/N 110978 - QMA Bulkhead Jack (for S31601)

Recommended Hand Tools : X-acto Knife, Sharp Razor, Cuticle Scissors or Wire Cutters, Tweezers, Heat Gun, Soldering Equipment

Required Tooling : M22520/ 5-01 Hex Crimp Tool, w/
M22520/ 5-37 Hex Crimp Die Set, cavity B (.151" hex)

- 1) Cut cable end squarely, re-form to concentric shape. Install ATUM 8/2 shrink tube and crimp ferrule onto the cable as shown (Fig. 1). Make Cut A @ .590" 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, maintaining braid weave as intact as possible (Fig. 2b).
- 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 @ .130" from the cable end, through the dielectric (Fig. 3). Do Not nick or cut into the small, stranded center conductor. Remove dielectric, verify center conductor integrity. Lightly tin the center conductor (Fig. 3).
- 5) Install center contact onto the cable center conductor, until contact is fully seated on the center conductor (Fig. 4). Solder the center contact onto the center conductor (Fig. 4).
- 6) Inspect and clean connector body as needed. Install the connector body over the dielectric and under the shields until the center contact is fully seated. Verify that the center contact is captivated.
- 7) Smooth all braids down over the rear of the connector body covering the knurl, maintain braid weave as much as possible (Fig. 5). Trim off stray braids at the the end of the knurl (Fig. 5).
- 8) Position crimp ferrule over braids, up to hex flange shoulder. Secure the body while locating ferrule, to avoid shifting the center contact. Trim any stray braids prior to seating the ferrule against the connector body.
- 9) Verify center contact position prior to crimping. Crimp ferrule with M22520/5 - 01 hex crimp tool and M22520/5-37 crimp die set, cavity B (.151" hex).
- 10) Shrink the ATUM dual-wall shrink tubing over the connector body and cable as shown (Fig. 6).

Figure 1

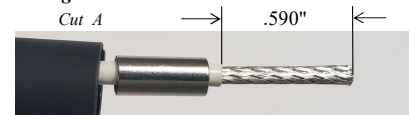


Figure 2a
flare braid ends out

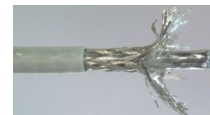


Figure 2b
fold braids back

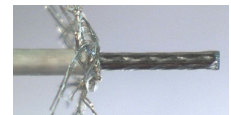


Figure 3 trim off foil

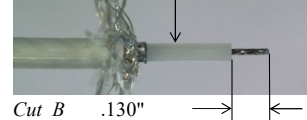


Figure 4

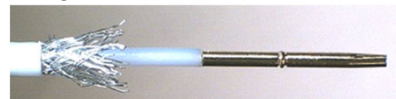
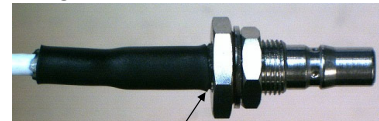


Figure 5



Figure 6



Note : Connector Length added to cable = + .375" nominal to end of connector body

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