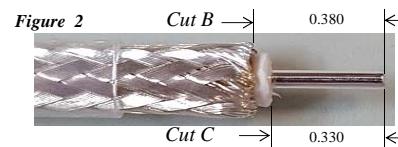
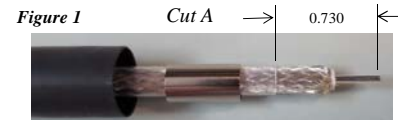


**Termination Instructions for PIC P/N 111079, ARINC 600 Size 8 Socket Contact**  
 (for S67163 Coax Cable)

<b>Recommended Hand Tools :</b>	Sharp Razor, Wire Cutters, Cuticle Scissors, Digital Calipers w/ depth gauge
<b>Required Cable Tools :</b>	Soldering Iron, Hex Crimp Tool M22520/5-01, Hex Crimp Die Set M22520/5-13, Heat Gun

- 1) Make sure end of cable is cut square. Install heat shrink and ferrule over the cable before Cutting (Fig. 1).
- 2) Make Cut A @ .730" from the cable end, through the outer jacket (Fig. 1). Do not nick or cut into the wire braids (Fig. 1).
- 3) Make Cut B @ .380" from the cable end, through the outer braid, foil shield, and strip braid (Fig. 2). Do not nick or cut into the dielectric. Note: If hand stripping, skip this step. Braids/shield can be trimmed during step 7.
- 4) Make Cut C .330" from the cable end, through the dielectric (Fig 2.). Do not nick or cut into the center conductor.
- 5) Slide the center contact onto the center conductor of the cable, ensuring it seats against the cable dielectric. Solder the center contact onto the cable center conductor (Fig. 3).
- 6) Flare out the outer braid to expose the (gold) foil shield. Slit the foil lengthwise in three or 4 places and flare back the same as the outer braid. Carefully flare out the Strip Braid away from the dielectric, away from the dielectric using tweezers or an *X-acto knife* (Fig 4).
- 7) Install the contact body over the center contact and dielectric until it is fully seated (Fig. 5). Fold the strip braid, foil shield, and wire braid (one at a time) over the contact body crimp area. Trim the braids as necessary up to the shoulder of the crimp ferrule area (Fig. 5).
- 8) Smooth down the braids/foil. Slide the crimp ferrule over the braids, up to the contact shoulder. (Fig 6.). Trim any stray braids at the shoulder of the contact body.
- 9) Verify that the contact body is fully seated onto the cable. Crimp the ferrule using the M22520 / 5-01 Hex Crimp tool with M22520 / 5-13 die set, cavity A - .255" hex (Fig. 7).
- 10) Remove the extraction sleeve (Fig. 7) before heating the heat shrink tube. Starting at the contact shoulder, heat the ATUM 12/3 dual wall heat shrink, covering the ferrule and cable (Fig. 8). Re-install the extraction sleeve.

Dimensions in Inches (NOT to Scale)



**Figure 3** Solder center contact



**Figure 4** Fold back outer braid, foil shield and strip braid



**Figure 5** Install contact body & trim braids to shoulder



**Figure 6** Slide ferrule flush with connector body



**Figure 7**



**Figure 8** Apply heat shrink



Note : Connector Length added to cable = + 1.20" nom.