

Termination Instructions for PIC P/N 150120 Avionics Coaxial Socket Contact
(for UH44193 Coax Cable)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool M22520/5-11 Hex Crimp Die Set, Cavity A (.213" hex) Soldering equipment, <i>OR</i> M22520 / 2 - 01 Center Contact Crimp Tool and PIC Positioner P/N 110254 (Daniels P/N K426) Heat Gun

Note : When stripping Aluminum conductors (and all conductors as a standard practice) take extra care to avoid nicking or cutting into center conductor or braids during cable stripping. For best results, the use of automatic or laser stripping equipment is recommended.

- Cut cable end squarely, and re-shape the cut end to concentric. Install the 1" piece of ATUM 8/2 dual wall black shrink tubing provided and crimp ferrule onto the cable (Fig. 1). Make cut A @ 0.550" from cable end, scoring the jacket only (Fig. 1). Do Not nick or cut into wire braids. Remove jacket (Fig. 1).
- Flare the braid ends out, keeping at least half the braid weave intact (Fig. 2). Unwrap the exposed helical shield until even with flared braids (Fig. 2), to make space for Cut B.
- Make Cut B @ .170" from the cable end, through the dielectric (Fig 3). Do Not nick or cut into the center conductor. Remove dielectric, verify center conductor integrity.
- Remove layer of plastic covering the silver-plated copper-clad center conductor (Fig. 4). For safe removal, it can be scraped off with opposing fingernails to avoid damage to plating (Fig. 4) until completely removed.
- Install center contact onto the cable center conductor, until contact is fully seated on the center conductor (Fig. 5). Conductor should be visible in inspection hole. Solder or crimp the center contact onto the center conductor. If crimping, use M22520/2-01 crimp tool with the dial setting @ # 8, using PIC # 110254 positioner (Daniels # K426).
- Flare open the remaining braids down to the jacket (Fig. 6), maintaining braid weave as intact as possible. Unwrap helical shield to expose dielectric down to jacket (Fig. 6), to allow fitting of connector body.
- Inspect and clean dielectric and center contact as needed, using clean, dry compressed air if necessary (carefully). 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 (Fig. 7) and snaps into captivation. Avoid disturbing or deforming the dielectric.
- Smooth all braids firmly down over the rear of the connector body, covering the knurled sections (Fig. 7). Trim off any excess braids and helical shield past the knurled rear body, trimming behind the shoulder (Fig. 7)
- Pull the crimp ferrule up over the braids. Secure the body while positioning the ferrule, to avoid shifting the center conductor. Trim any stray braids at the shoulder prior to seating the ferrule against the connector body (ex. Fig. 8).
- Verify the connector is fully seated onto the cable. Crimp the ferrule with M22520/5-01 crimp tool with M22520/5-11 hex die set, cavity A, .213" hex (Fig. 8). Use caution to avoid crimping the connector body next to the ferrule (Fig. 8)
- Shrink the ATUM dual-wall shrink tubing (Fig. 9) over the connector body and cable, starting 0.150" (half way) up the ferrule (Fig. 9).

Note: Connector Length added to cable = + .475" nominal

Dimensions in Inches - NOT to Scale

Figure 1

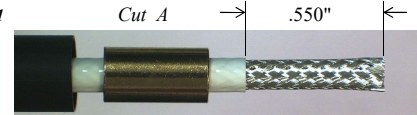


Figure 2

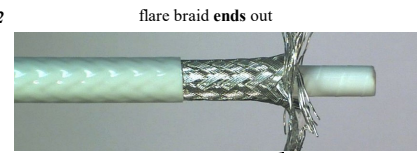


Figure 3

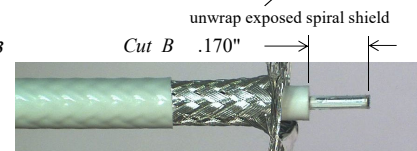


Figure 4

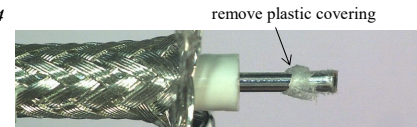


Figure 5

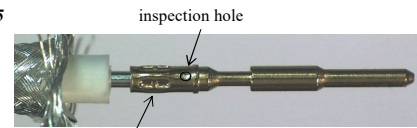


Figure 6

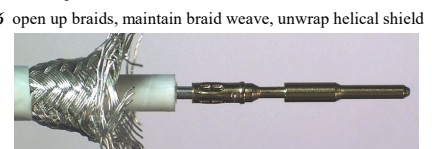


Figure 7

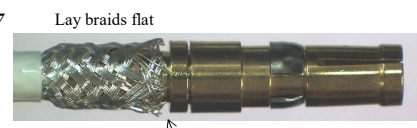


Figure 8

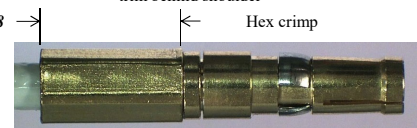


Figure 9

