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Termination Instructions	T-190XXXA
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	Rev. 0
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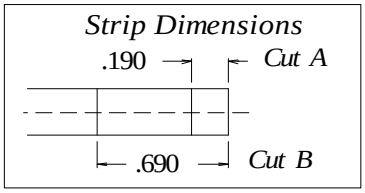
Termination Instructions for PIC 190XXXA Series Coaxial Connectors

Recommended Hand Tools	X-acto Knife, Cuticle Scissors, Cable Cutter, Razor	
Required Tooling	M22520/5-01 Hex Crimp Tool	
	Connector Series	*Die Set*
	1901XXA	190118
	1903XXA	190318
	1904XXA	190418
	1905XXA	190518A
	1906XXA	190618



Dimensions in Inches

1 Cut the cable end square. Install the crimp ferrule over the jacket, small end first (if applicable). *SCORE* the outer jacket at Cut A and Cut B, using the Strip Dimensions shown, without cutting into cable shielding.

2 Complete Cut A, through shields and dielectric, down to Center Conductor. DO NOT nick or cut into the Center Conductor. Remove Jacket, Shields and Dielectric. Clean the face of the exposed dielectric of debris or stray braids.

3 Install Center Contact onto the cable Center Conductor, until end of Contact is flush with Dielectric. Do Not force the Center Contact into the dielectric. Solder or Crimp the Center Contact to the Center Conductor. Refer to above chart for correct Crimp Die Set; for 190118, 190318, 190618, and 190418 dies, use the .098 hex. For 190518A die set, use the .095 square crimp cavity. Inspection hole should show Center Conductor / Solder (if soldered).

4 Complete Cut B, through the Jacket. DO NOT nick or cut into the Shield or Braids. Slit lengthwise and remove the Jacket.

5 Flare out the Wire Braids, less than 45°. Score the Inner Shield (Spiral Shield) lengthwise *(with X-acto knife)* , until the spiral begins to unwrap. Once the end has shifted out past the end of the dielectric, begin to unwind the spiral from the end. Unwind the spiral shield without twisting, down to Cut B, leaving it positioned straight out, with the flared Wire Braids.
Avoid disturbing the dielectric. The dielectric must be exposed for full length of the Strip Dimension.

6 Clean Dielectric and Center Contact as needed. Dry compressed air may be used if necessary (carefully). Inspect and clean Connector Body as needed.

7 Install the Connector Body over the Dielectric and under the shields, until the Center Contact captivation groove is engaged. Avoid disturbing or deforming the Dielectric. *For 90° Connectors* , use caution to avoid damage to female Center Contact. Rotating the connector back and forth while installing the body can help ensure the Center Contact is centered in the connector. Push until the Center Contact captivation groove is engaged. Verify captivation with a light tug.

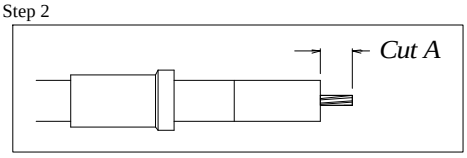
8 Smooth Wire Braids down over the rear of the connector body, covering the knurl. The Spiral Shield should lay flat under the Wire Braids. Trim off braids and spiral at the shoulder *(Cuticle Scissors)* .

9 Pull the Crimp Ferrule up onto the connector body. Secure the body while positioning the ferrule, to avoid shifting the captivated Center Contact. Trim any stray braids at the shoulder prior to seating the ferrule against the connector body.

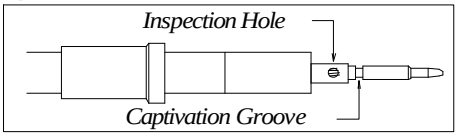
10 Verify Center Contact position; visually on straight connectors, and by verifying captivation on 90° connectors. Crimp ferrule with M22520/5-01 Crimp Tool and Crimp Die Set as specified in chart above.

11 Apply Dual Wall Heat Shrink tubing supplied.

Step 2



Step 3



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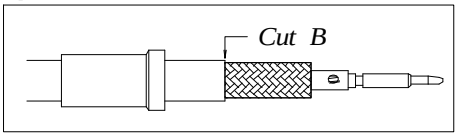
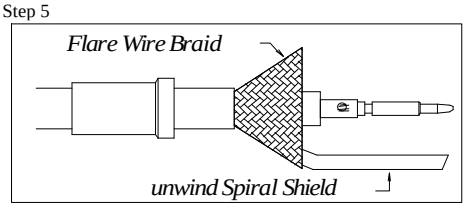
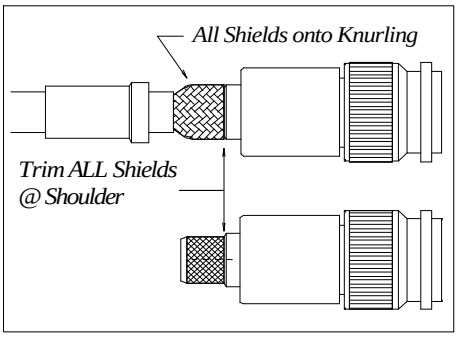


Step 5



Step 8



Step 10