

<b>PIC Wire &amp; Cable</b> <i>A Division of the Angelus Corporation</i> (262)-246-0500 Fax (262)-246-0450 PO Box 330 Sussex, WI 53089		<b>Termination Instructions</b>	<b>T-110459</b>
		Approved <i>TVH</i>	Date : 04/08/11
		Distribution : USER	Rev. 0
		Uncontrolled Document	
<b>Termination Instructions for PIC 110459 TRB Straight Plug</b> <i>for PIC P/N L7626TX (75-ohm) Triax Cable</i>			
<b>Required Supplies :</b>	(1 pc.) Tyco # ATUM 16/4 x 1.5" Lg., Loctite 271 Threadlocker		
<b>Required Tooling :</b>	Soldering Equipment, 7/16" wrenches		
<b>Recommended Hand Tools :</b>	X-acto Knife, Sharp Razor, Wire Cutters		
<b>Connector Components</b>			
<i>Drawings Not To Scale</i>			
1.) Install Label, Clear Shrink (if applicable), and ATUM 16/4 x 1.5" Lg. dual wall shrink tube. Install Clamp Nut (threads towards end of cable). Round off the end of cable, to aid in the installation of connector components.	<p>Figure 1 Cut A .375"</p>		
2.) Make Cut A @ .375" from the cable end, through the Outer Jacket (Fig. 1). Remove jacket, flare Braids, and trim off braids @ Cut A (Fig. 1).	<p>Figure 2 Trim off braids even with outer diameter</p>		
3.) Make Cut B @ .825" from the cable end, through the outer jacket (Fig. 1). Do Not nick or cut into the braids. Remove jacket, flare the braid ends out, just enough to install the Outer Braid Clamp.	<p>Figure 3 Cut C (even with front surface of braid clamp)</p>		
4.) Install outer braid clamp onto the cable, under the outer braids, until seated firmly against the bottom of the braids (where braids exit the jacket) (Fig. 2). Trim off stray braids that extend beyond the end of the clamp (Fig. 2).	<p>Figures 4a and 4 b make pigtails, remove foil</p>		
5.) Make Cut C, scoring the Inner Jacket even with the front surface of the braid clamp (Fig. 3). Do not nick or cut into braids. Remove the inner jacket.	<p>Figure 5 pigtails through insulator slots</p>		
6.) Comb out the exposed Inner Braids and separate the strands, to make two pigtails, @ 180° apart from each other (Fig. 4a). Score and trim off the Foil layer just above the pigtails (Fig. 4a).	<p>Figure 6 solder the center contact</p>		
7.) Make Cut D @ .130" from the end of the cable, through the Dielectric, down to the Center Conductor (Fig. 4b). Do not nick or cut into the small stranded center conductor. Remove the dielectric (Fig. 4b). Tin the exposed center conductor.	<p>Figure 7 solder pigtails to intermediate contact</p>		
8.) Verify no stray braids or strands between the pigtails and the braids clamp, particularly in the area between the inner jacket and braid clamp. Install the Rear Insulator, over the conductor and dielectric, until fully seated in the braid clamp as shown (Fig. 5). The center conductor should extend through the hole in the front of the insulator, and the pigtails should fit through the slots in each side of the insulator.	<p>Figure 8 groove for pigtails</p>		
9.) Tin the Center Contact, and solder onto the center conductor, ensuring that all components fit snug onto the cable as shown (Fig. 6). Since the contact entry hole is larger than the center conductor, add enough solder to fill the cavity. Verify the contact is soldered securely onto the conductor.	<p>Figure 9 Start ATUM over front flats</p>		
10.) Verify no stray braids or strands are between the pigtails and the braid clamp, and that the braid clamp is insulated from the pigtails and/or inner shield. Install the Front Insulator over the center contact, with the small step towards the cable end.			
11.) Install the Intermediate Contact over the insulators & center contact, until fully seated onto the insulators as shown (Fig. 6). Route pigtails through the insulator slots, and exit from the intermediate contact slots (Fig. 6). Pigtails should be wrapped around the intermediate contact and soldered to the contact in the groove on the contact (Fig. 6). No solder or wires should extend beyond the edges of the groove, so that the connector body will fit with no obstructions; trim off excess solder or strands as needed.			
12.) Position the clamp nut up to the braid clamp, trim off any stray braids that extend beyond the clamp nut / braid clamp, to facilitate fit of the connector body. Install the Connector Body onto the cable, until the center contact is nearly flush with the end of connector. Push the clamp nut into place in the back end of the connector body, add a small drop of Loctite 271 to threads, and tighten the clamp nut into the connector with wrenches, until snug.			
13.) Shrink ATUM 16/4 over connector body and cable, starting approximately in the middle of the front flats of the connector, and onto cable (Fig 7). Test as required.			
Note : Connector Length added to cable = .385" nominal			
<i>PIC Wire &amp; Cable Termination Instruction sheets are non-controlled documents. Please contact PIC Wire and Cable or visit the PIC website (www.picwire.com) to ensure the latest revision of the drawing is being viewed.</i>			