

### Termination Instructions for PIC 110477 QMA 90° Plug connector

*for PIC S67163 Coax Cable*

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool M22520 / 5- 59 Die Set cav. A (.255" hex) Tip Chamfer Tool; Huber & Suhner type # 74-Z-0-0-164, w/ # 11 SMA tip ( <i>Recommended</i> )

- 1 Install ATUM 12/3 Dual Wall Shrink Tube x 1.5" Lg. on cable. Install the crimp ferrule onto the cable. Make Cut A @ .310" from cable end, through the jacket (Fig. 1). Remove the jacket, remove exposed wire braids, foil, and strip braids. Do Not cut into, damage, or disturb the cable dielectric.
- 2 Make Cut B @ .590" from the cable end, through the jacket only (Fig. 1). Do Not nick or cut into the wire braids. Slit lengthwise if needed, and remove the jacket.
- 3 Make Cut C @ .120" from the cable end, through the dielectric (Fig 1). Do Not nick or cut into the center conductor. Remove the dielectric. Verify that the exposed exposed center conductor is straight; it can be straightened if necessary (use caution to avoid any damage or alteration to smooth center conductor surface).
- 4 Using Tip Trimming Tool (or a small file), shape the leading end of the exposed center conductor into a chamfer as shown (Fig 2). Inspect for burrs at the edges of the chamfered section and smooth as needed, using a small file. Inspect the dielectric for debris and clean as needed, using compressed air.
- 5 Flare the wire braids away from the cable. Slit the foil lengthwise in three or four places around the cable, and flare the foil out to expose the strip braid. Carefully flare out the strip braid away from the dielectric, all the way down to the bottom (@ Cut B). Avoid disturbing or damaging the dielectric. The dielectric must be exposed for the full length of the Strip Dimension (to Cut B).
- 6 Inspect and clean the dielectric as needed, prior to installing the connector body onto the cable. Inspect and clean Connector Body entry as needed.
- 7 Install the connector body over the dielectric and under the flared shields, until the cable center conductor fits into the connector's internal captive center contact. Push the connector on until the cable is fully seated into the connector. Avoid disturbing or deforming the dielectric.
- 8 Smooth all braids down over the rear of the connector body, covering the knurl. Trim off any excess braids past the knurled rear body, before the shoulder.
- 9 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.
- 10 Verify that the connector is fully seated onto the cable. Crimp the ferrule with the M22520 / 5 -01 hex crimp tool, using the M22520 / 5 - 59 hex crimp die set, cavity A (.255" hex).
- 11 Shrink the ATUM Dual Wall Shrink tube, starting at the cube section of the connector body, covering the rear of the connector body, and onto the cable (Fig 3).

Dimensions in Inches  
Figure 1 NOT TO SCALE

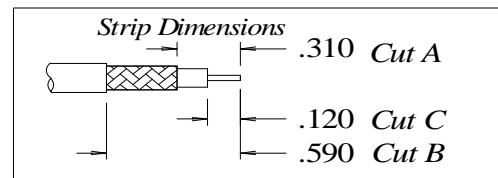


Figure 2

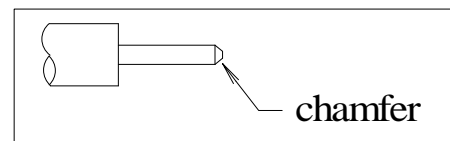


Figure 3



Note : Connector Length added to cable = + .415" nominal to end of cube body  
 Connector Length added to cable = + .240" nominal to centerline of connector interface  
 Cable OAL: measurement to end of block - .175" = dimension to centerline