


PIC Wire & Cable

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Termination Instructions

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Termination Instructions

For V75268 / V76261 / V73263 Coax (L7626TX Triax - inner coax only)

Note: If using PIC weather-proofing ferrule, crimp w/190818 die set. If using Optional Ferrule, use M22520/5-41 die set. Only PIC ferrule will completely weatherproof connector.

Recommended Hand Tools : X-acto knife, Sharp Razor, Cuticle Scissors										
Connector P/N	Connector Type	M22520/ 2-01 Contact Crimp Tool			M22520/ 5-01 Ferrule Hex Crimp Tool			Strip Dimensions		
		Crimp Tool Positioner			Hex Crimp Die Set (See Note above)					
		PIC P/N	Daniels P/N	Dial #	Die Set P/N	Hex Size	A	B	C	
110235	D-Sub Sz 8 Plug	110201	K1300	5	PIC P/N 110283 (M22520/ 5-37) cav. B	.151	.460	.260	.110	
110236	D-Sub Sz 8 Socket	110204	K817-3	5	PIC P/N 110283 (M22520/ 5-37) cav. B	.151	.520	.270	.110	
110237	Coax Sz 9 Socket	110245	K908	5	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
110249	BNC 90° Plug	110205	K224	7	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.594	.250	.156	
110285	75-ohm Screw-On Female Plug	110377 (1)	K1452 (1)	3 (1)	PIC P/N 110376 (Daniels Y187)	.156	.465	.180	.085	
110677	F Str Plug	NA	K850	5	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.480	.135	.090	
190703	ARINC Sz 5 Socket	110256	K1447	6	190818 or M22520/5-41, cav B	.186 or .178	.690	.375	.190	
190708	TNC Str Plug	110204	K817-3	6	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
190712	BNC Str Plug	110204	K817-3	6	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
190714	SMA Str Plug	110204	K817-3	6	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
190721	TNC Bulkhead Jack	110202	K1301	5	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
190727	BNC Str Jack	110201	K1300	5	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
190728	BNC Blkhd Jack	110202	K1301	5	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
190729	ARINC Sz 8 Socket	110257	K1448	6	190818 or M22520/5-41, cav B	.186 or .178	.690	.375	.190	
190730	ARINC Sz 16 Socket	110300	K1598	5	PIC P/N 110283 (M22520/ 5-37) cav. B	.151	.513	.250	.156	
190732	ARINC Sz 8 Socket (75 ohm)	110257	K1448	6	190818 or M22520/5-41, cav B	.186 or .178	.690	.375	.190	
190733	ARINC Sz 5 Socket (75 ohm)	110256	K1447	6	190818 or M22520/5-41, cav B	.186 or .178	.690	.375	.190	
190734	M39029 Sz 16 Socket	110300	K1598	5	PIC P/N 110283 (M22520/ 5-37) cav. B	.151	.390	.200	.156	
190735	M39029 Sz 16 Pin	110323	K1599	5	PIC P/N 110283 (M22520/ 5-37) cav. B	.151	.390	.200	.156	
190736	SMB 75-Ohm Socket	110337	K1626	3	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.513	.250	.156	
190738 *	M39029 Size 8 Coax Pin	110369	K1667	5	190818 or M22520/5-41, cav B	.186 or .178	.690	.375	.190	
190739 *	M39029 Size 8 Coax Skt	110407	K1682	5	190818 or M22520/5-41, cav B	.186 or .178	.690	.375	.190	
190740 *	M39029 Size 8 Pin (75-ohm)	110547	K1760	3	PIC P/N 110376 (Daniels Y187)	.156	.540	.250	.155	
190741 *	M39029 Size 8 Skt (75-ohm)	110546	K1759	3	PIC P/N 110376 (Daniels Y187)	.156	.525	.210	.140	
190745	Mini-BNC Str Plug	110918	K1969	8	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.490	.210	.135	
190748	SMZ 75 Ohm Straight Plug	110547	K1760	3	PIC P/N 110376 (Daniels Y187)	.156	.550	.245	.150	
190763	D-Sub Size 8 Pin (75-ohm)	110753	K1886	4	PIC P/N 110376 (Daniels Y187)	.156	.450	.210	.140	
190764	D-Sub Size 8 Skt (75-ohm)	110754	K1887	4	PIC P/N 110376 (Daniels Y187)	.156	.450	.210	.140	
190768	75-ohm Screw-On Female 90° Plug	110918	K1969	8	PIC P/N 110333 (M22520/ 5-41) cav. B	.178	.530	.230	.190	

* Add -01 suffix for Contact with Environmental Seal included

(1) Note: Alternate Daniels Tool P/N MH835 can be used w/PIC P/N 110680 (Daniels P/N K1853) Positioner, dial setting #4.

- If using L76 Triaxial cable, first trim off outer jacket and braid to desired length to expose inner coax to be terminated. Cut the coax cable end square. Install Environmental Seal if included, rubber end first. Install ATUM if applicable. Install selected Crimp Ferrule (if applicable) onto cable. When using PIC ferrule with weatherseal, install sealed end onto cable first. See fig. 7 for ferrules. Using dimensions from the chart above, SCORE the jacket at Cut A & Cut B, without cutting into cable shielding. Complete Cut B, removing the jacket & trimming off all braids. (See Fig 1).
- Cut through Dielectric at Cut C, down to Center Conductor. DO NOT nick or cut into the Center Conductor. Remove the dielectric; use caution to keep the small, stranded center conductor intact (Fig 2).
- Install Center Contact onto the cable center conductor, until the contact is fully seated against dielectric. Solder or crimp the center contact to the cable center conductor (Fig 3). Refer to above chart for Positioner and Dial Setting. The inspection hole should show the center conductor / solder (if soldered).
- Complete Cut A, through the Jacket. DO NOT nick or cut into the Braids. Slit lengthwise and remove the Jacket (Fig 3).
- Flare out the Braids, approximately 45° (Fig 4). For **V76261** and **L7626TX**, flare out foil until it can be slit lengthwise from the inside, and then flare foil same as the braids. For **V73263**, unwrap the Spiral Shield layer all the way down to the bottom (of Cut A) without twisting it. The spiral strip can be positioned straight out along the inside of the flared braids. Trim off excess beyond the braids. Clean the dielectric and contact as needed, using dry compressed air if needed. 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. Verify that the center contacts are captivated, where applicable (190708, 190712, 190727, 190728, 110249, 110285, 190736), otherwise fully seated.
- Smooth all braids down over the rear of the connector body (and foil, or spiral strip, as applicable), covering the knurl. Trim off braids (and foil or spiral strip) at the shoulder. For connectors with an O-Ring on the connector body shoulder, (190703, 190729, 190732, 190733), trim off braids just short of the O-Ring; braids should not cover the O-Ring.
- Position crimp ferrule on the connector body. Secure the body while positioning the ferrule, to avoid shifting the center contact. Trim any stray braids at the shoulder (or O-Ring) prior to seating the ferrule against the connector body.
- Verify Center Contact position prior to crimping. Crimp the ferrule with the M22520/5-01 Crimp Tool and Crimp Die Set as specified in chart above. Note : If crimping the optional crimp ferrule, crimp only the smaller diameter area of the ferrule, not the larger bell area on the front end of the ferrule. See figures 7a & b.
- Apply Dual Wall Heat Shrink tubing if applicable. Position the Environmental seal up over the connector as far as possible, if applicable.

NOT TO SCALE

Figure 1

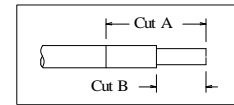


Figure 2

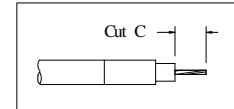


Figure 3

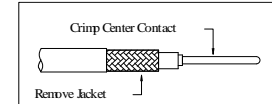


Figure 4

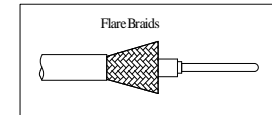


Figure 5

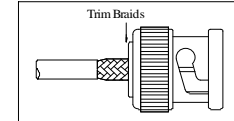
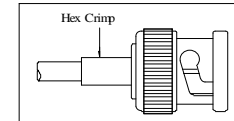
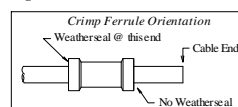


Figure 6



Figures 7a



Figures 7b

