

PIC Wire & Cable

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Termination Instructions

T-1909XX

Approved: *MCT*

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Uncontrolled If Printed

Termination Instructions for PIC 1909XX Series Connectors

Recommended Hand Tools : X-acto knife, Sharp Razor, Cuticle Scissors, Soldering Iron (Optional)

Required Tooling :

Connector P/N	Connector Type	Crimp Tool Dial #	M22520/1-01 Contact Crimp Tool			M22520/ 5-01 Hex Crimp Tool		Strip Dimensions		
			PIC P/N	Daniels P/N	Color Code	Die Set	Hex Size	A	B	C
190908	TNC Straight Plug	3	110656	TH729	Green	/ 5-59, cav. A	.255	.640	.200	.140
190909	TNC 90° Plug	5	110656	TH729	Red	/ 5-59, cav. A	.255	.620	.290	.190
190912	BNC Straight Plug	3	110656	TH729	Green	/ 5-59, cav. A	.255	.640	.200	.140
190913	BNC 90° Plug	5	110656	TH729	Red	/ 5-59, cav. A	.255	.620	.290	.190
190921	TNC Bulkhead Jack	5	110656	TH729	Blue	/ 5-59, cav. A	.255	.620	.290	.190
190928	BNC Bulkhead Jack	3	110656	TH729	Green	/ 5-59, cav. A	.255	.640	.200	.140
190932 *	ARINC Size 8 Socket, 75 Ohm	4	110657	TP1681	N/A	/ 5-45, cav. A	.231	.460	.200	.140
190937 *	ARINC Size 8 Pin, 75 Ohm	4	110657	TP1681	N/A	/ 5-45, cav. A	.231	.460	.200	.140
190940 *	M39029 Size 8 Pin, 75 Ohm	4	110657	TP1681	N/A	/ 5-45, cav. A	.231	.430	.180	.120
190941 *	M39029 Size 8 Socket, 75 Ohm	4	110657	TP1681	N/A	/ 5-45, cav. A	.231	.430	.180	.120
190944	SMC-Type 75-ohm Female Plug	5	110656	TH729	Red	/ 5-59, cav. A	.255	.590	.260	.210
190945	Mini-BNC Straight Plug	5	110656	TH729	Red	/ 5-59, cav. A	.255	.620	.290	.190
190946	Mini-BNC 90° Plug	5	110656	TH729	Red	/ 5-59, cav. A	.255	.620	.290	.190

* -01 = w/ Environmental Seal

- 1) Cut the cable end square. Install the shrink tube, (environmental seal if applicable), and crimp ferrule over the jacket. Using dimensions from the chart above, SCORE the jacket at Cut A and Cut B, without cutting into cable shielding. Complete Cut B, remove the jacket at Cut B. Trim off all wire braids and foil at Cut B (Figure 1).
- 2) Cut through dielectric at Cut C, down to center conductor (Figure 2). DO NOT nick or cut into the center conductor. Remove the dielectric; use caution to keep the small, stranded center conductor intact.
- 3) Install center contact onto the cable center conductor, until the contact is fully seated on the wire, taking care to ensure all strands are installed intact into the center contact. Solder or crimp the center contact to the center conductor (Figure 3). Refer to above chart for the specified tooling. Inspection hole should show center conductor / Solder (if soldered).
- 4) Complete Cut A, through the Jacket. DO NOT nick or cut into the braids. Slit lengthwise and remove the jacket.
- 5) Flare out the braids, less than 45°. Slit the foil lengthwise and flare outwards, and then flare braids/foil to about 45° (Figure 4). Clean dielectric and center contact as needed. Dry, low-pressure compressed air may be used if necessary (carefully). Inspect and clean Connector Body as needed.
- 6) 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 (as applicable).
- 7) Smooth all braids and foil down over the rear of the connector body covering the knurl. Trim off stray braids and foil at the shoulder.
- 8) Position Crimp Ferrule over braids on the connector body. Secure the body while positioning the ferrule, to avoid shifting the center contact. Trim any stray braids at the shoulder prior to seating the ferrule against the connector body.
- 9) Verify center contact position prior to crimping. Crimp the ferrule with M22520/5 - 01 Crimp Tool and Crimp Die Set as specified in chart above (Figure 5).
- 10) Apply Dual Wall Heat Shrink tubing (Fig 5), or pull the environmental seal up to location over the connector (if applicable).

NOT TO SCALE

Figure 1

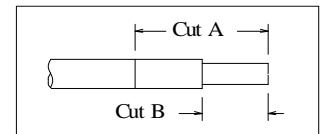


Figure 2

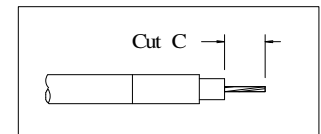


Figure 3

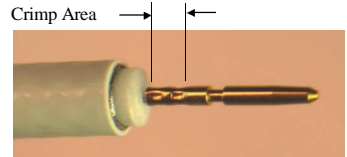


Figure 4

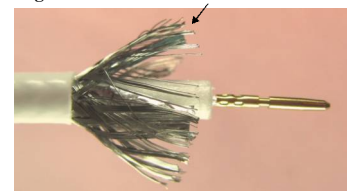


Figure 5

