A Division of the Angelus Corporation Ph (262)-246-0500 Fax (262) 246-0450 www.picwire.com PO Box 330 Sussex, WI 53089 Termination Instructions for PIC 1505XX Series (for UH67163 Ultralight Coax Cable)	Approved : MCCT Distribution : USER	Date: 08/12/15 Rev: 1 (10/29/18) Uncontrolled if Printed
PO Box 330 Sussex, WI 53089 Termination Instructions for PIC 1505XX Series		
Termination Instructions for PIC 1505XX Series		Uncontrolled if Printed
	s Connectors	
Recommended Hand Tools : X-acto Knife, Sharp Razor, Cuticle Scissors or Wire Cutters, T	Tweezers, Heat Gun, Soldering Equipment	
Required Tooling : M22520/ 5-01 Hex Crimp Tool, w/ M22520/ 5-41 Hex Crimp Die Set, ca	avity A (.290" hex)	
Note : When stripping Aluminum conductors (and all conductors as a standard practice) take extra care to avoid nicking or cutting into center conductor or braids during cable strip For best results, the use of automatic or laser stripping equipment is recommended.		nches (Not To Scale)
ATUM 12/3 dual-wall shrink tubing and crimp ferrule onto cable (Fig. 1). Make Cut A @ .260" from	tall the n the end	4 .260" -> +
Make Cut B @ .830" from the end of the cable, scoring the cable jacket. Use caution: Do Not nick of nto aluminum wire braid shields (Fig. 1). Do not remove jacket yet, leave in place (Fig. 1).		210"
Make Cut C @ .210" from the end of the cable, through the dielectric, down to the center conductor Fig. 1). Do Not nick or cut into the center conductor. Remove dielectric from Cut C (Fig. 1). mportant Note : Be sure to remove the clear film over the center conductor before installing contact	et.	
nstall center contact onto the cable center conductor, until contact is fully seated on the center onductor (Fig. 2). Conductor should be visible in inspection hole. Solder the center contact onto onto the center conductor (Fig. 2). Center contact must be soldered, not crimped.	Figure 3	flare braids minimally
weezers may be used to grip and unwind helical strip. The helical strip can be positioned straight all	. 3), ong	r unwrap inner shi
nspect and clean connector body as needed. Install the connector body over the dielectric and under he shields until the center contact is fully seated (Fig. 4). Verify that the center contact is captivated.		
Smooth all braids and helical strip down over the rear of the connector body covering the knurl, naintain braid weave as much as possible (Fig. 4). Trim off stray braids at the shoulder (Fig. 4).	Lay braids flat, trin	n off braids at shoulder
Position crimp ferrule over braids, up to connector body shoulder (Fig. 5). Secure the body while ocating ferrule, to avoid shifting the center contact. Trim any stray braids at the shoulder prior to eating the ferrule against the connector body.	Figure 5	
Verify center contact position prior to crimping. Crimp ferrule with M22520/5 - 01 hex crimp tool at M22520/5-41 crimp die set, cavity A (.290" hex). Apply secondary crimp (aligned with the first) to chieve a crimp over the full length of the ferrule (Fig. 5).	→ crimp full length of	← ferrule
Shrink the ATUM dual-wall shrink tubing (Fig 6) over the connector body and cable, start behind he coupling nut \sim .100" to ensure no interference with coupling nut function (Fig. 6).	Figure 6	Shrink ATUM
	traighten the end of cable, and re-shape the cut end to concentric, to assist in accurate stripping. Ins TUM 12/3 dual-wall shrink tubing and crimp ferrule onto cable (Fig. 1). Make Cut A @ .260° fror fhe cable, through cable jacket and all cable shields, down to the dielectric (Fig. 1). Avoid cutting ielectric. Remove jacket and shields from Cut A (Fig. 1). Aake Cut B @ .830° from the end of the cable, scoring the cable jacket. Use caution: Do Not nick o ato aluminum wire braid shields (Fig. 1). Do not remove jacket yet, leave in place (Fig. 1). Aake Cut C @ .210° from the end of the cable, through the dielectric, down to the center conductor Fig. 1). Do Not nick or cut into the center conductor. Remove dielectric from Cut C (Fig. 1). mportant Note : Be sure to remove the clear film over the center conductor before installing contact nstall center contact onto the cable center conductor, until contact is fully seated on the center onductor (Fig. 2). Conductor should be visible in inspection hole. Solder the center contact onto nto the center conductor (Fig. 2). Center contact must be soldered, not crimped. Remove the cable jacket at Cut B. Flare braids slightly (Fig. 3), maintaining braid weave as much as easible. Unwrap helical inner shield all the way down to the bottom (Cut B) without twising it (Fig weezers may be used to grip and unwind helical strip. The helical strip can be positioned straight all the inside of the flared braids (Fig. 3). The dielectric must be exposed for the full strip length (to Cut lean dielectric and center contact as needed. Install the connector body over the dielectric and under he shields until the center contact is fully seated (Fig. 4). Verify that the center contact is captivated instain braid weave as much as possible (Fig. 4). Trim off stray braids at the shoulder (Fig. 4). to stitut and helical strip down over the rear of the connector body covering the knurl, anitatin braid weave as much as possible (Fig. 4). Trim off stray braids at the shoulder pr	traighten the end of cable, and re-shape the cut end to concentric, to assist in accurate stripping. Install the TJUM 12/3 dual-wall shirink tubing and crimp ferrule onto cable (Fig. 1). Make Cut A (2.00° from the end of the cable, shortly, down to the dielectric (Fig. 1). Avoid cutting into the ielectric. Remove jacket and all cable shickly, down to the dielectric (Fig. 1). Avoid cutting into the ielectric (Pig. 1). The dielectric (Pig. 1). The dielectric from Cut C (\mathcal{G}_{12} (\mathcal{G}_{12} (\mathcal{G}_{12}) and the cable cable cable in conductor (Fig. 1). Do not remove jacket yet, leave in place (Fig. 1). The dielectric from Cut C (Fig. 1). The dielectric from Cut C (Fig. 1). The dielectric from Cut C (Fig. 1). The dielectric is used to remove the cable cable in inspection hole. Solder the center conductor fig. 3). The dielectric must be soldered, not crimped. The dielectric and unwind helical strip. The helical strip and be positioned string the leave is isurbing flared shields. The dielectric must be exposed for the full strip length (to Cut B). The dielectric must be exposed for the full strip length (to Cut B). The dielectric must be exposed for the full strip length (to Cut B). The dielectric and center conduct is fully seated (Fig. 4). Verify that the center contact is captivated. The analysis of the sposible (Fig. 4). Thirm off stray braids at the shoulder (Fig. 4). The dielectric must prove the dielectric and under heids withing the center contact. Trim any stray braids at the shoulder prior to cating the ferrule against the connector body. Wile cating the ferrule against the connector body. Wile fig. 5). Secure the body while first, the full length of the ferrule (Fig. 5). The dielectric (Fig. 5). The dielectric contact. Trim any stray braids at the shoulder prior to cating the ferrule against the connector body. Wile cating the first the connector body. Wile cating the fremule against the connector body. The many stray braids at the shoulder prior to cating the ferrule (Fig. 5). The dielectric (Fig. 5

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