PIC Wire & Cable			Termination Instructions		T-190866
A Division of the Angelus Corporation			Approved :	mer	Date : 06/02/15 Rev. 1 (06/10/15)
	Ph (262) 246-0500 Fax (262) 246-0450 www.picwire.com PO Box 330 Sussex, WI 53089			Distribution : USER	
		ation Instructions for PIC P/N 190866 - M3			Uncontrolled if Print
	1 ermina	(for \$83204 / \$86208 / \$88207 Coax Cal		2 Pin Contact	
	Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters			
		M22520 / 5- 01 Hex Crimp Tool			
		M22520 / 5 - 41 Hex Crimp Die Set			
	Required Cable Tools :	Soldering equipment, OR			
		M22520 / 2 - 01 Center Contact Crimp Tool			
		PIC Positioner P/N 110901 (Daniels P/N K194	47) if used		
				Dimensions in Inc	ches - NOT to Scale
1)	Install the crimp ferrule onto the cable.	Make Cut A @ .250" from cable end, through	Figure 1	Cut A	> .250" ≼
, 		e (Fig. 1). Do not cut into dielectric. Remove	0	<i>Cut B</i> .500" →	
	jacket, braids, (and foil). Clean any debris off of the exposed dielectric.			(en sur particular and a surger and a surger a s	
	· · · · ·	-			
)	Make Cut B @ .500" from the cable en	d, through the jacket only (Fig. 1). Do Not nick		and the second se	
	or cut into the wire braids. Leave this section of jacket on.				
				Cut C .150"	\longrightarrow
)	Make Cut C @ .150" from the cable end, through the dielectric (Fig 1). Do Not nick or				
	cut into the center conductor. Remove dielectric, verify center conductor integrity.		Figure 2	inspection hole	
)	Verify proper fit of the center contact onto the center conductor. Solder or crimp the center contact onto cable center conductor (Fig. 2). If crimping, use M22520/2-01 crimp tool, with dial setting @ # 7. Use PIC # 110901 positioner (Daniels # K1947), or crimp between inspection hole and end of contact (Fig. 2).				
					and the second second
				Crimp w/ M22520/2-01 tool	
5	Domous isolat at Cut P. Flore the wire	braids away from the cable. Slit the fail shield	Figure 3	Flare braids	
5)	Remove jacket at Cut B. Flare the wire braids away from the cable. Slit the foil shield lengthwise in three places around the cable and flare out foil (S83204). Flare out the inner strip braids to expose the dielectric all the way down to the bottom (Fig. 3). The dielectric must be exposed for the full length of the strip dimension (to Cut B).			Flate braids	
				L. L	
				Contraction of the second	
	The dielectric must be exposed for the r	tun length of the surp unitension (to cut <i>D</i>).			
6)	Inspect and clean dielectric and center of	contact as needed, using clean, dry compressed			
	air if necessary (carefully). Inspect and				
		-	Figure 4	Lay braids flat, trim behi	nd shoulder
)	Install the connector body over the diele	ectric and under the shields, until the center		K	
	contact is fully seated. Avoid disturbing			and all a second	The second se
					-
6)		f the connector body, covering the knurl. Trim			
	off any excess braids past the knurled r	ear body, trim behind the shoulder (Fig. 4).			
		~	Figure 5		-
)		s. Secure the body while positioning the		1 A CONT	- Center contact
	•	luctor. Trim any stray braids at the shoulder		- A B	
	prior to seating the ferrule against the c	onnector body.			
0)	Verify that the connector is fully seated	onto the cable. Confirm the center contact			
5)	position; the end of the center contact s				
	connector body (Fig. 5). Crimp the ferr		Figure 6	Hex crimp	
	M22520 / 5 - 41 hex die set, cavity B,	-		<u> </u>	
	$W_{22}S_{20}/S = 41$ nex die set, cavity B, 1170 nex (Fig. 0).			5.6 C	in the second se
				BO	No. of Concession, Name
	Note: Connector Length added to cable	= + 1.05" nominal			

PIC Wire & Cable Termination Instruction sheets are non-controlled documents if printed. Please contact PIC Wire and Cable or visit the PIC website (www.picwire.com) to ensure the latest revision of the instruction is being used.