

Termination Instructions for PIC P/N 110198, SMA Str Plug

(for S44191, S44193, S46191, RG400 & RG142 Coax Cable)

Recommended Hand Tools :	Sharp Razor, Wire Cutters, Cuticle Scissors, Digital Calipers w/ depth gauge
Required Cable Tools :	Soldering Iron, Hex Crimp Tool M22520/5-01, Hex Crimp Die Set M22520/5-05, Heat Gun

Dimensions in Inches (NOT to Scale)

- 1) Make sure end of cable is cut square. Install heat shrink and ferrule over the cable before any stripping (Fig. 1).
- 2) Make Cut A @ .600" from the cable end, through the outer jacket (Fig. 2). Do not nick or cut into the wire braids (Fig. 2).
- 3) Make Cut B @ .240" from the cable end, through the outer braid, foil shield, and strip braid (Fig. 2). Do not nick or cut into the dielectric. Note: If hand stripping, skip this step. Braids/foil shield can be trimmed during step 7.
- 4) Make Cut C .110" from the cable end, through the dielectric (Fig 2). Do not nick or cut into the center conductor.
- 5) Solder the center contact onto the center conductor, ensuring the pin seats against the dielectric (Fig. 3).
- 6) Flare out the outer braid to expose the (gold) foil shield. Slit the foil lengthwise in three or 4 places and flare back the same as the outer braid. Carefully flare out the Strip Braid away from the dielectric, away from the dielectric using tweezers or an *X-acto knife* (Fig 4).
- 7) Install the connector body onto the center contact and dielectric until it is fully seated (Fig. 5). Fold the strip braid, foil shield, and wire braid (one at a time) over the connector body, returning them as closely as possible to their original positions. Trim the braids/foil up to the shoulder area.
- 8) Smooth down the wire braids so that the ferrule can slide over them flush with the connector body shoulder (Fig 6). Trim any stray braids at the shoulder of the connector body.
- 9) Verify that the connector body is fully seated onto the cable. Crimp the ferrule using M22520 / 5-01 hex crimp tool with M22520 / 5-05 die set, cavity A, .213" hex (Fig. 7).
- 10) Starting at the connector shoulder, heat the ATUM 12/3 dual wall heat shrink, covering the shoulder, crimp ferrule, and onto the cable (Fig. 8).

Note : Connector Length added to cable = + 0.31" nominal

Figure 1



Figure 2

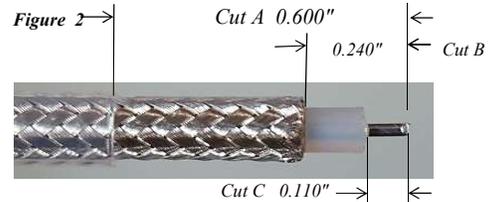


Figure 3 Solder center contact



Figure 4 Fold braids/Foil back



Figure 5 Install connector body & trim to shoulder

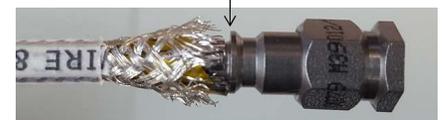


Figure 6 Ferrule flush with shoulder - trim stray braids



Figure 7 Crimp ferrule



Figure 8 Apply heat shrink

