

**Termination Instructions - PIC P/N UH25107 Cable w/PIC 1904XX Series Connectors**

Recommended Hand Tools : X-acto Knife, Sharp Razor, Cuticle Scissors or Wire Cutters, Scribe, Needlenose Pliers, Heat Gun, Soldering Equipment

Required Tooling : M22520/05-01 (HX4) Hex Crimp Tool, w/ PIC P/N 190418 Hex Crimp Die Set, or M22520/5-27 Hex Crimp Die Set

**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 stripping. For best results, the use of automatic or laser stripping equipment is recommended.**

- 1) Re-shape cut end of cable as required until thoroughly concentric to aid in accurate stripping. Install the black dual-wall shrink tubing and then the crimp ferrule onto cable, as shown (Fig. 1). Make Cut A @ 0.71" from end of the cable and remove the jacket. (Fig. 1).  
 Note: Use caution not to cut or nick into the aluminum wires of the outer braids as much as possible.
- 2) Flare all the wire braid ends out. Unwrap the inner helical shield down to the flared wire braids to allow access for the center conductor strip.
- 3) Make Cut B @ 0.19" from the end of the cable, through the dielectric, down to the center conductor (Fig. 2).  
 Note: Use caution not to cut or nick into the aluminum center conductor as much as possible.
- 4) Perform a fit check of the cable contact on the cable center conductor to verify fit. If there are any issues that impede the fit of the contact, use a needlenose pliers to carefully "round" the conductor. Install center contact onto the cable center conductor, until contact is fully seated against the cable dielectric. Conductor should be visible in inspection hole. Solder the center contact onto the center conductor. Center contact must be soldered, not crimped (Fig 3).
- 5) Maintaining braid weave as much as possible, flair braids and unwrap helical inner shield all the way down, close to the jacket without twisting it. A needlenose pliers may be used to carefully grip and unwind the helical strip. *Use caution, the helical strip edges are sharp; a needlenose pliers may help avoid finger cuts.* The helical strip can be positioned straight along the inside of the flared braids. The dielectric must be exposed for the full strip length of Cut A (Fig 3).
- 6) Install the connector body over the contact and dielectric, under the shields, until the center contact is fully seated by snapping into place (Fig. 4). Verify that the center contact is captivated.
- 7) Smooth all braids and helical strip down over the rear of the connector body covering the knurl, maintaining braid weave as much as possible (Fig. 4). Trim off stray braids at the shoulder.
- 8) Position crimp ferrule over braids, up to connector body shoulder (Fig. 5). Secure the body while locating ferrule, to avoid shifting the center contact. Trim any stray braids at the shoulder prior to final seating of the ferrule against the connector body. Avoid pulling ferrule backwards over the cable, which may undo braid weave.
- 9) Verify center contact position and ferrule seating, prior to crimping. Crimp ferrule with M22520/5-01 hex crimp tool and PIC P/N 190418 crimp die set (Fig. 5), or with M22520/5-27 crimp die set (crimp all of zone depicted in Fig. 5 by crimping 2X).
- 10) Shrink the ATUM dual-wall shrink tubing (Fig. 6) over the connector body and cable. Start shrink far enough behind the coupling nut to ensure no interference with coupling nut function.

Dimensions in Inches (Not To Scale)

