

PIC Wire & Cable <i>A Division of the Angelus Corporation</i> (262)-246-0500 Fax (262)-246-0450 PO Box 330 Sussex, WI 53089	Termination Instructions	T-110567
	Approved <i>TVH</i>	Date 09/19/11
	Distribution : USER	Rev. 0

Termination Instructions for PIC 110567 QMA 90° Plug connector
for PIC S83204 Coax Cable

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool M22520 / 5- 09 Die Set, .068" hex for center contact / .178" hex for ferrule

- 1 Install ATUM and crimp ferrule unto cable. Make Cut A @ .310" from cable end, through the jacket (Fig. 1). Remove the jacket, remove exposed wire braids, foil, and strip braids. Do Not cut into the cable dielectric.
- 2 Make Cut B @ .630" from the cable end, through the jacket only (Fig. 1). Do Not nick or cut into the wire braids. Remove jacket.
- 3 Make Cut C @ .190" from the cable end, through the dielectric (Fig 1). Do Not nick or cut into the center conductor. Remove the dielectric. Verify that the exposed exposed center conductor is straight.
- 4 If crimping the Center Contact, install the contact onto the cable center conductor. There should be a .024" nominal gap between the center contact and the dielectric. Crimp the contact (Fig. 2) using the M22520 / 5 - 01 Crimp Tool, and the M22520 / 5 - 09 die set, using cavity B (.068" hex) .
- 5 If soldering, tin the cable center conductor. Tin the center contact, and solder it onto the cable center conductor. Clean the contact and cable dielectric as needed, using Isopropanol and clean, dry compressed air.
- 6 Flare the wire braids away from the cable. Slit the foil lengthwise in two or three places around the cable, and flare the foil out, all the way down to the bottom (@ Cut B).
- 7 Inspect and clean the dielectric as needed, prior to installing the connector body onto the cable. Inspect and clean Connector Body entry as needed.
- 8 Install the connector body over the dielectric and under the flared shields, until the center contact is fully seated. Verify that the center contact is captivated inside the connector.
- 9 Smooth all braids down over the rear of the connector body, covering the knurl. Trim off any excess braids past the knurled rear body, before the shoulder.
- 10 Pull the crimp ferrule up over the braids. 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.
- 11 Verify that the connector is fully seated onto the cable. Crimp the ferrule with the M22520 / 5 -01 hex crimp tool, using the M22520 / 5 - 09 hex crimp die set, cavity A (.178" hex).
- 12 Shrink the ATUM Dual Wall Shrink tube, starting at the cube section of the connector body, covering the rear of the connector body, and onto the cable (Fig 3).

Dimensions in Inches

Figure 1 *NOT TO SCALE*

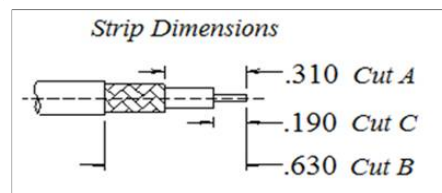


Figure 2

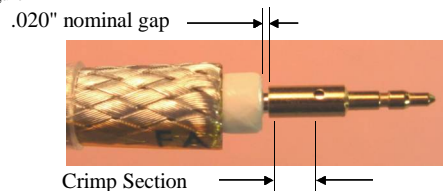


Figure 3

