Termination Instructions for PIC 110576 QMA Straight Plug connector
for PIC S44191 / S44193 / S46191, and RG142 / RG400 Coax Cable

Recommended Hand Tools:  X-acto Knife, Sharp Razor, Wire Cutters

Required Cable Tools:  M22520 / 5-01 Hex Crimp Tool
                       M22520 / 5-11 Die Set, cavity A (.213” hex)

1. Install ATUM 12/3 x 2.0” Lg. Dual Wall Shrink Tube x 2.0” Lg. on cable. Install the
   crimp ferrule onto the cable. Make Cut A @ .230” 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 @ .575” from the cable end, through the jacket only (Fig. 1). Do Not nick
   or cut into the wire braids.

3. Make Cut C @ .150” 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
   until it is fully seated against the dielectric. Crimp the larger diameter section (Ø .085”)
   of the contact (Fig. 2) using the M22520 / 5-01 Crimp Tool, and the M22520 / 5 -11
   die set, using cavity B (.068” hex).
   If soldering, tin the cable center conductor. Tin the center contact, and solder it onto
   the cable center conductor, seated flush against the cable dielectric. Clean the contact
   and cable dielectric as needed, using Isopropanol and clean, dry compressed air.

5. Slit the jacket lengthwise from Cut B, and remove the jacket. Flare the wire braids
   away from the cable. Slit the foil lengthwise in three or four places around the cable
   cable, and flare the foil out to expose the strip braid (disregard for RG142, RG400
   cables). Flare out the strip braid away from the dielectric, all the way down to the
   bottom (@ Cut B).

6. Inspect and clean the dielectric as needed, prior to installing the connector body
   onto the cable. Inspect and clean Connector Body entry as needed.

7. 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.

8. 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.

9. 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.

10. 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 -11 hex crimp die set,
    cavity A (.213” hex).

11. Shrink the ATUM Dual Wall Shrink tube, starting approximately .125” behind the QMA
    Coupling Nut, covering the rear of the connector body, and onto the cable (Fig 3).
    Verify after shrinking, that the shrink tubing does not interfere with the full travel
    of the QMA coupling nut.

   Note: Connector Length added to cable = .600” nominal