

# PIC Wire & Cable


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## Termination Instructions

Approved 

Distribution : USER

## T-110581

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### Termination Instructions for PIC 110581 QMA 90° Plug connector

for PIC S67163 Coax Cable

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool M22520 / 5- 13 Die Set, cavity A (.255" hex) & cavity B (.068" hex)

- 1 Install ATUM 12/3 Dual Wall Shrink Tube x 1.5" Lg. on cable. Install the crimp ferrule onto the cable. Make Cut A @ .300" 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. Leave jacket in place.
- 3 Make Cut C @ .180" 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. Crimp the section of the center contact as shown (Fig. 2) using the M22520 / 5 - 01 Crimp Tool, with the M22520 / 5 - 13 die set, using cavity B (.068" hex). The .020" nominal gap between the contact and the cable dielectric is normal.  
If soldering, tin the cable center conductor. Tin the center contact, and solder it onto the cable center conductor, seated on the cable center conductor. Clean the contact and cable dielectric as needed, using 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. 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 - 13 hex crimp die set, cavity A (.255" hex).
- 11 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).

Note: Connector Length added to cable = + .450" nominal (to centerline of connector interface)  
Connector Length added to cable = + .625" nominal (to outer end of cube body)

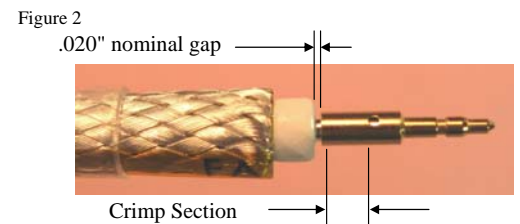
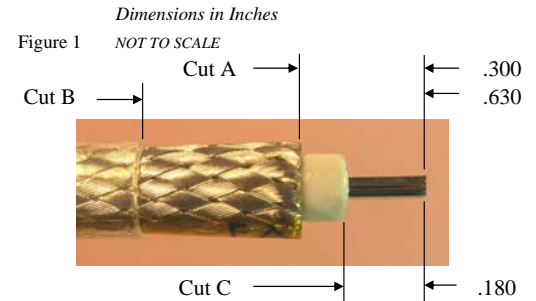


Figure 3

