

A Division of the Angelus Corporation
 PH (262) 246-0500 Fax (262) 246-0450 www.picwire.com
 PO Box 330 Sussex, WI 53089

Approved: PFT
 Distribution : USER

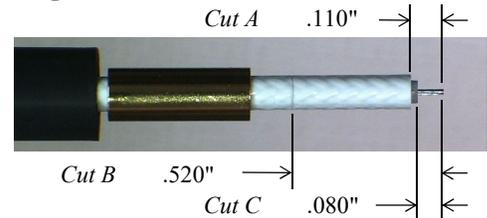
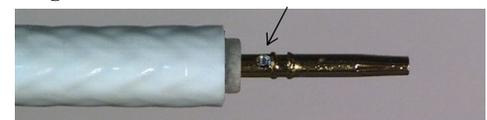
Date : 11/13/19
 Rev. 0
 Uncontrolled if Printed

Termination Instructions for PIC 110863 SMZ Straight Female Plug connector
(for PIC V76261, V73263, V75268 Coax Cable)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Small Needlenose Pliers
Required Cable Tools :	M22520 / 5-01 Hex Crimp Tool M22520/ 5-41, cav. B (.178" hex) Soldering equipment, Heat Gun

- 1) Cut cable end squarely, round off to concentric shape. Install ATUM 8/2 dual-wall shrink tube x 1.5" onto the cable. Install the crimp ferrule onto the cable. Make Cut A @ .110" from cable end, through the jacket, wire braids, and foil (Fig. 1). Do not cut into dielectric. Remove jacket, wire braids, and foil.
- 2) Make Cut B @ .520" from the cable end, scoring the jacket only (Fig. 1). Do Not nick or cut into the wire braids. Leave the jacket on.
- 3) Make Cut C @ .080" from the cable end, through the dielectric (Fig 1). Do Not nick or cut into the center conductor. Remove the dielectric, verify center conductor integrity.
- 4) Verify proper fit of the center contact onto the stranded center conductor, with all strands intact. Solder the center contact onto cable center conductor (Fig. 2).
- 5) Remove jacket at Cut B. For **V76261**, flare the wire braids away from the cable, leaving foil intact (Fig. 3). For **V75268**, flare all braids out. For both, clean exposed dielectric and contact with clean, dry compressed air as needed. For **V73263**, unwrap the Spiral Shield layer all the way down to the bottom (of Cut B) without twisting it. The spiral strip can be positioned straight out along the inside of the flared braids. Dielectric must be exposed for the full length of the strip length (to 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 snaps into the connector's internal captivation.
- 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, trim even with the shoulder (Fig. 4).
- 9) Pull the crimp ferrule up over the braids. Secure the body while positioning the ferrule, to avoid shifting the center conductor. 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/ 5-41, cav. B hex crimp die set, cavity B (.178" hex). Crimp the entire length of the ferrule.
- 11) Shrink the ATUM 8/2 dual wall shrink tube, starting at the shoulder (Fig. 5), covering the crimp ferrule, and onto the cable (Fig 5).

Dimensions in Inches (Not To Scale)

Figure 1**Figure 2****Figure 3****Figure 4****Figure 5**

Note: Connector Length added to cable = .260" nominal