

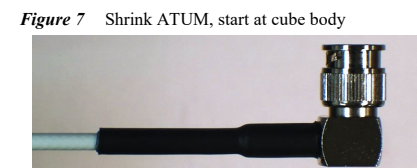
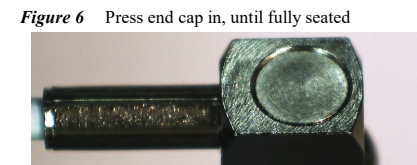
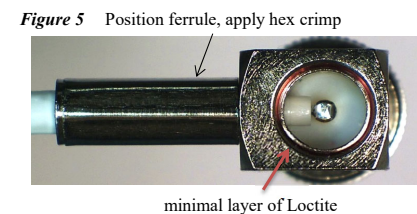
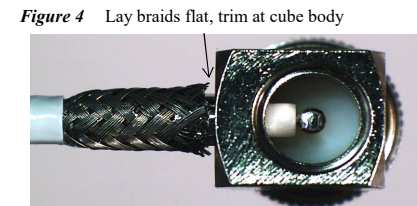
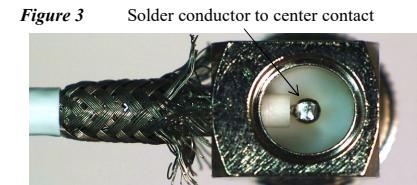
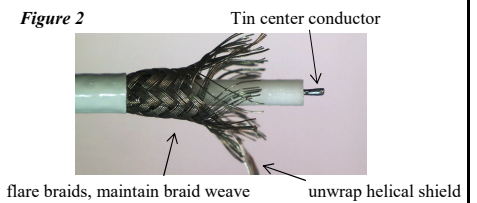
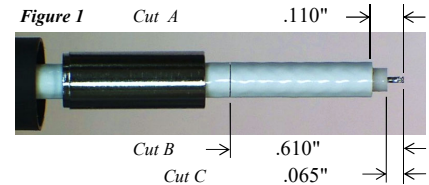
Termination Instructions for PIC P/N 111069 - Mini-BNC 90° Plug Connector

for V73263 / V76261 / V75268 Coax Cables

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	Fixture F-40 (Ø .250" punch) w/ Arbor Press or equivalent Soldering Iron w/ fine tip OR American Beauty # 105A3 Resistance soldering tweezers Heat Gun Loctite # 271 M22520/5-01 Hex Crimp tool w/Daniels Hex Crimp Die Set Y248 (.186" hex) or equivalent

Dimensions in Inches (NOT to Scale)

- 1) Install ATUM 8/2 × 1.5" dual wall shrink tube onto cable (Fig. 1). Install the crimp ferrule, with small OD step inward (Fig. 1).
- 2) Make sure end of cable is cut square. Make Cut A @ .110" from cable end, through the jacket and shields, down to the dielectric (Fig. 1). Avoid cutting into the dielectric. Remove the jacket and braids to expose the dielectric.
- 3) Make Cut B @ .610" from cable end, scoring the jacket (Fig. 1). Do Not nick or cut into the wire braids.
- 4) Make Cut C @ .065" from cable end, through the dielectric (Fig. 1). Do Not nick or cut into the small, stranded center conductor. Remove the dielectric.
- 5) Tin the center conductor (Fig. 2). Flare the wire braids out as shown, while maintaining wire braid weave as intact as possible (Fig. 2). Unwrap the helical shield (V73263) and flare with wire braids, or slit and flare foil shield (V76261) as applicable (Fig. 2). Shields must be flared enough to accommodate installation of the connector body.
- 6) Install the connector body onto the cable, until the center conductor is positioned to fill the length of the center contact slot. Solder the conductor to the center contact (Fig. 3). The solder must be well bonded to the contact and the conductor, without excess solder on the sides of the contact, with a minor solder bead (Fig. 3). Inspect and clean solder joint and connector body cavity as needed with isopropyl alcohol and clean using dry compressed air if needed.
- 7) Lay all braids flat on the rear body of the connector and trim off excess braids at the cube body shoulder (Fig. 4).
- 8) Position the crimp ferrule over the braids, up to the cube body shoulder. Secure body while positioning ferrule to avoid undue stress on the solder junction. Trim off any stray braids and ensure the ferrule is seated against the cube body. Crimp the ferrule using M22520/5-01 hex crimp hand tool (or equivalent) w/ Daniels Y248 hex crimp die set (.186" hex) as shown (Fig. 5).
- 9) Inspect internal connector cavity for any stray braids or debris, clean as needed. Apply a minimal layer of Loctite 271 to interior edge of end cap counterbore (Fig. 5) and clean off any excess Loctite.
- 10) Install the end cap into the counterbore. Using the arbor press with tool F-40 & Ø.250" punch (centered over the end cap), press end cap into position until firmly and squarely seated (Fig. 6). Avoid using excess pressure to ensure functional integrity of the Mini-BNC coupling nut. With end cap installed, clean off any excess Loctite.
- 11) Verify that the Mini-BNC coupling nut travels freely, to allow the connector to engage and disengage mating connectors.
- 12) Locate the ATUM shrink tube up to the cube body on the connector, use the heat gun to shrink into place (Fig. 7).



Note : Length (conn) adds to cable assy = + .150" nom. to end of conn. body
 Length (conn) adds to cable assy = - .030" nom. to centerline of conn. interface