

PIC Wire & Cable

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Termination Instructions

T-111122

Approved :

PFT

Date : 11/01/2019

Rev. 0

Distribution : USER

Uncontrolled if Printed

Termination Instructions for PIC P/N 111122, ARINC 600 Size 5 Socket

(for S67163)

Required Tooling : X-acto Knife, Sharp Razor, Wire Cutters
M22520/ 5-01 Hex Crimp Tool, w/ M22520/ 5-41 Hex Crimp Die Set, Cavity A (.290" hex)
Heat Gun

- 1) Cut cable end squarely, and re-shape the cut end to concentric. Install the 1.5" piece of ATUM 8/2 dual wall black shrink tubing provided onto the cable (**Fig. 1**). Install the crimp sleeve onto the cable, thick end first (**Fig. 1**).
- 2) Make cut A @ 0.200" from cable end, through the jacket, shields, and dielectric (**Fig. 2**). Do not nick or cut into the center conductor. Make cut B @ 0.250" from cut A, through the jacket (**Fig. 2**). Do not cut into the braids.
- 3) Flare the wire braids and install the bushing onto the cable, over the foil shield (**Fig. 3**).
- 4) Push the bushing onto the cable as far as it will go, and slide the inner ferrule over the top of it, trapping the wire braids (**Fig. 4**).
- 5) Install the dielectric washer over the center contact (**Fig. 5**). Install and solder the center contact onto the center conductor (**Fig. 5**).
- 6) Install the main connector body over the soldered center contact (**Fig. 6**).
- 7) Crimp the main body in M22520/ 5-41 Hex Crimp Die Set, Cavity A (.290" hex), leaving out 0.08" of the rear section as shown (**Fig. 7**).
- 8) Remove the black integral extraction sleeve. Shrink the ATUM 8/2 x 1.5" so that it covers the crimp flats (**Fig. 9**). Reinstall the integral extraction sleeve (**Fig. 9**).

Dimensions in Inches (NOT to Scale)

Figure 1



Figure 2



Figure 3

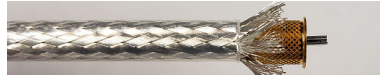


Figure 4



Figure 5



Figure 6



Figure 7



Figure 8

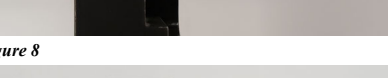


Figure 9

