Termination Instructions

For V75268 / V76261 / 1972626 Contact (176263T inner - inner coaxes only)

Note: If using PIC weather-proofing ferrule, crimp w/190818 die set. If using Optional Ferrule, use M22520-41 die set. Only PIC ferrule will completely weatherproof connector.

### Connector P/N | Connector Type | M22520-01 Contact Crimp Tool | M22520-5-01 Ferrule Hex Crimp Tool
<table>
<thead>
<tr>
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<tbody>
<tr>
<td>110235</td>
<td>D-Sof 5-8 Plug</td>
<td>110201</td>
<td>PIC P/N 110283 (M22520-5-37) cav. B</td>
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<td>110236</td>
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<td>BNC 9-5 Plug</td>
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<td>PIC P/N 110333 (M22520-5-41) cav. B</td>
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<td>110285</td>
<td>75-ohm Screw-On Female Plug</td>
<td>110377 (1) K1452 (1)</td>
<td>PIC P/N 1110376 (Daniels Y187)</td>
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<td>110677</td>
<td>5 Pin Plug</td>
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<td>PIC P/N 1110333 (M22520-5-41) cav. B</td>
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**Recommended Hand Tools**

- Hex Crimp Die Set
- Hex Crimp Tool
- Hex Crimp Tool Positioner
- Crimp Tool Positioner
- SMA 75-Ohm Ferrule
- SMA 75-Ohm Shielded Ferrule
- M22520/5-01 Ferrule Hex Crimp Tool
- M39029 Size 8 Pin (75-ohm)
- M39029 Sz 16 Pin
- M39029 Sz 16 Socket
- M39029 Size 8 Coax Pin
- M39029 Size 8 Coax Skt

**Strip Dimensions**

<table>
<thead>
<tr>
<th>Hex Crimp Die Set (See Notes above)</th>
<th>Hex Size</th>
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<th>B</th>
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<tr>
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<tr>
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**Recommended Crimp Ferrules & ferrule orientation**

- SMA 75-Ohm Ferrule: Weatherseal, Weatherseal Cover
- Optional Crimp Ferrule: .503

**Material and Tool List**

- SMA 75-Ohm Shielded Ferrule
- SMA 75-Ohm Ferrule
- SMA 75-Ohm Screw-On Ferrule
- SMA 75-Ohm Shielded Ferrule
- SMA 75-Ohm Ferrule
- SMA 75-Ohm Screw-On Ferrule
- SMA 75-Ohm Ferrule

**References**

- Hex Crimp Tool: M39029 Size 8 Pin (75-ohm)
- Hex Crimp Tool Positioner: M39029 Sz 16 Pin
- Crimp Tool Positioner: M39029 Sz 16 Socket
- SMA 75-Ohm Ferrule: Weatherseal, Weatherseal Cover
- Optional Crimp Ferrule: .503

**Notes**

- Alternate Daniels Tool P/N MH335 can be used w/PIC P/N 110680 (Daniels P/N K1853) Positioner, dial setting #4.

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**Figure 1**

- Cut A
- Cut B

**Figure 2**

- Cut C

**Figure 3**

- Crimp Ferrule Contact
- Remove Jacket
- Flare Braids
- Trim Braids

**Figure 4**

- Hex Crimp
- Optional Crimp Ferrule .503

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**Table Notes**

- *Add -01 suffix for contact with Environmental Seal included.

**Revision History**

- Rev. 18 (06/19/17)

**Contact PIC Wire and Cable**

- Phone: (262) 246-0500
- Fax: (262) 246-0450
- Web: www.picwire.com

**Distribution**

- USER

**Revision Status**

- Uncontrolled if Printed

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**Termination Instructions**

1. If using L76 Triaxial cable, first trim off outer jacket and braid to desired length to expose inner coax to be terminated. Cut the coax cable end square. Install Environmental Seal if included, rubber end first. Install ATUM if applicable.

2. Cut through dielectric at Cut B, down to Center Conductor. DO NOT nick or cut into the Center Conductor. Remove the dielectric; use caution to keep the small, stranded center conductor intact (Fig 2).

3. Install Center Contact onto the cable center conductor, until the contact is fully seated against dielectric. Solder or crimp the center contact to the cable center conductor (Fig 3). Refer to above chart for Positioner and Dial Setting. The inspection hole should show the center conductor / solder (if soldered).

4. Complete Cut A, through the Jacket. DO NOT nick or cut into the Braids. Silt lengthwise and remove the Jacket (Fig 3).

5. Flare out the Braids, approximately 45° (Fig 4). For V76261 and L76265TX, flare out foil until it can be slit lengthwise from the inside, and then flare foil same as the braids. For V73263, unwrap the Spiral Shield layer all the way down to the bottom (of Cut A) without twisting it. The spiral strip can be positioned straight out along the inside of the flared braids. Trim off excess beyond the braids. Clean the dielectric and contact as needed, using dry compressed air if needed. Inspect and clean Connector Body as needed.

6. Install the connector body over the dielectric and under the shields, until the center contact is fully seated. Verify that the center contacts are captured, where applicable (190708, 190712, 190727, 190728, 110249, 110285, 110736), otherwise fully seated.

7. Smooth all braids down over the rear of the connector body (and foil, or spiral strip, as applicable), covering the knurl. Trim off braids (and foil or spiral strip) at the shoulder. For connectors with an O-Ring on the connector body shoulder, (190703, 190729, 190732, 190733), trim off braids just short of the O-Ring; braids should not cover the O-Ring.

8. Position crimp ferrule on the connector body. Secure the body while positioning the ferrule, to avoid shifting the center contact. Trim any stray braids at the shoulder (or O-Ring) prior to seating the ferrule against the connector body.

9. Verify Center Contact position prior to crimping. Crimp the ferrule with the M22520-5-01 Crimp Tool and Crimp Die Set as specified in chart above. Note: If crimping the optional crimp ferrule, crimp only the smaller diameter area of the ferrule, not the larger bell area on the front end of the ferrule. See figures 7a & b.

10. Apply Dual Wall Heat Shrink tubing if applicable. Position the Environmental seal up over the connector as far as possible, if applicable.