

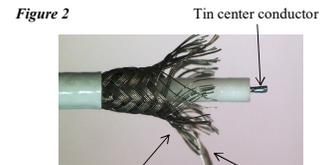
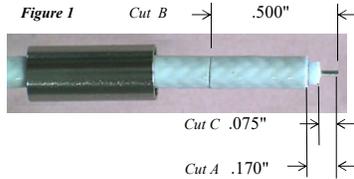
Termination Instructions for PIC P/N 111163 HD-BNC 90° Plug Connector

for V73263 / V76261 / V75268 Coax Cables

Recommended Hand Tools	X-acto Knife, Sharp Razor, Wire Cutters
Required Tooling	Fixture F-40 (Ø .155" punch) w/ Arbor Press or equivalent, Heat Gun, Soldering Iron w/ fine tip OR American Beauty # 105A3 Resistance soldering tweezers, Loctite # 271 M22520/5-01 Hex Crimp tool w/ M22520/5-05 (.178" hex) or equivalent

- 1) Install labeling (if applicable), then install ATUM 8/2 Dual Wall Shrink Tube x 1.0" onto the cable. Install the crimp ferrule onto the cable. Make Cut A @ .170" from cable end, through to the dielectric (Fig. 1). Do not cut into dielectric. Remove jacket, wire braids and shield.
- 2) Make Cut B @ .500" from the cable end, through the jacket only (Fig 1). Do Not nick or cut into the wire braids. Leave the jacket on.
- 3) Make Cut C @ .075" 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) 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.
- 5) Inspect and clean the dielectric as needed, prior to installing the connector body onto the cable. Inspect and clean Connector Body entry as needed. Install the connector body over the dielectric and under the flared shields, until the cable center conductor fits into the slot of the internal center contact and the cable dielectric is right next to the internal center contact. The cable center conductor must not extend past the diameter of the internal center contact. Trim cable center conductor as necessary if cable center conductor protrudes past internal center contact.
- 6) Once connector body is in position, 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/ M22520/5-05 hex crimp die set (.178" 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.155" 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 HD-BNC coupling nut. With end cap installed, clean off any excess Loctite.
- 11) Verify that the HD-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).

Dimensions in Inches (NOT to Scale)



tin center conductor
 flare braids, maintain braid weave
 unwrap helical shield

Figure 3 Solder conductor to center contact

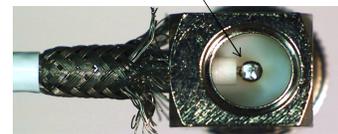


Figure 4 Lay braids flat, trim at cube body

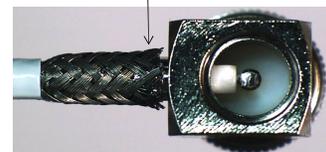
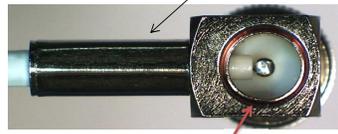


Figure 5 Position ferrule, apply hex crimp



minimal layer of Loctite

Figure 6 Press end cap in, until fully seated



Figure 7 Shrink ATUM, start at cube body



Note : Length (conn) adds to cable assy = + .095" nom. to end of conn. body