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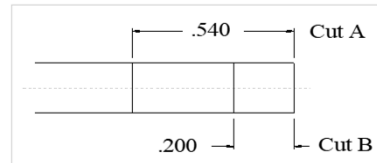
Termination Instructions for PIC P/N 110123, ARINC Size 5 Socket Contact

(Radiall Jerrick P/N 620 021)

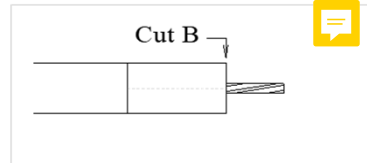
for PIC S44191 / S44193 / S46191 and RG142 / RG400 Coaxial Cables

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Cuticle Scissors
Required Tooling :	M22520/ 5-01 Hex Crimp Tool M22520/5-05 Hex Crimp Die Set (cav. A)
Optional Tooling : (if crimping Center Contact)	M22520/ 2-01 Contact Crimp Tool Daniels K345 Positioner

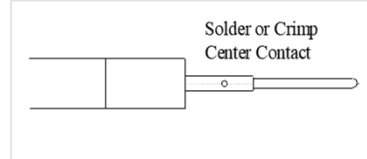
Step 1 Dimensions in Inches (Not to Scale)



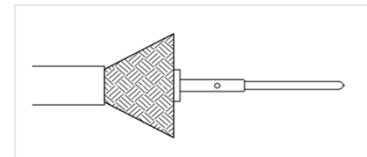
Step 2



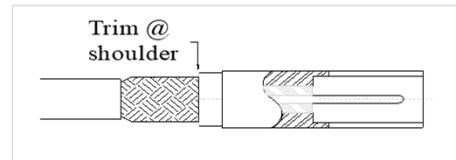
Step 3



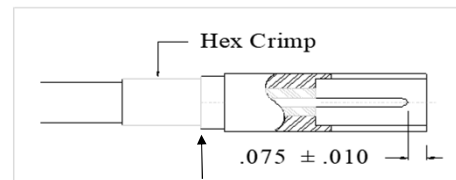
Step 5



Steps 6 and 7

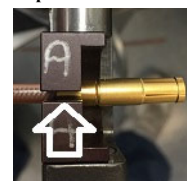


Step 9a



Do Not crimp onto contact body to avoid damage

Step 9b



Step 9c



- 1) Cut the cable end square. Install the crimp ferrule over the jacket. SCORE the jacket at Cut A (.540 from the cable end) and at Cut B (.200" from the cable end), without cutting into cable shielding.
- 2) Complete Cut B, through braids and dielectric, down to Center Conductor. DO NOT nick or cut into the Center Conductor. Remove the jacket, braids, and dielectric; use caution to keep the stranded Center Conductor intact (for S44191 / S46191 and RG400).
- 3) Install Center Contact onto the cable Center Conductor, until the Contact is fully seated against the Dielectric. Solder or crimp the Center Contact to the Center Conductor. If crimping the Center Contact, use an M22520/2-01 Contact Crimp Tool with the Dial setting @ 8, and a Daniels K345 Positioner. Inspection hole should show Center Conductor / Solder (if soldered).
- 4) Complete Cut A, through the Jacket. DO NOT nick or cut into the Braids. Slit lengthwise and remove the Jacket.
- 5) Flare out the Braids, less than 45° (*X-acto knife*). Clean Dielectric and Center Contact as needed. Dry compressed air may be used if necessary (carefully). Inspect and clean Connector Body as needed.
- 6) Install the Contact Body over the Dielectric and under the shields, until the Center Contact is fully seated.
- 7) Smooth all braids down over the rear of the contact body, covering the knurl. Trim off braids at the shoulder (*Cuticle Scissors*).
- 8) Position the crimp Ferrule on the contact body. Secure the body while positioning the ferrule, to avoid shifting the Center Contact. Trim any stray braids at the shoulder prior to seating the ferrule against the contact body.
- 9) Verify Center Contact position prior to crimping (.075 ± .010" from the end of the contact body), Step 9a. Crimp the ferrule with M22520/5-01 Crimp Tool and M22520/5-05 Crimp Die Set, cavity A (.213 hex), Step 9b. Start at the center of the ferrule, crimping towards cable end. Perform a second crimp on the contact body side of the ferrule, making sure not to position the die set over contact body, Step 9c.