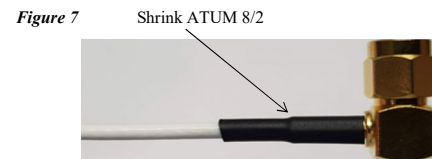
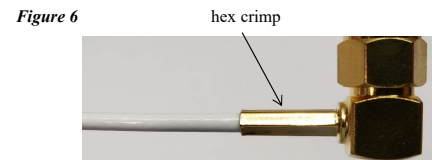
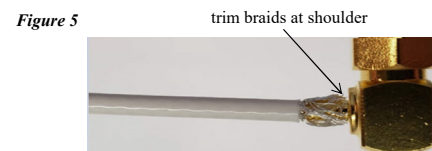
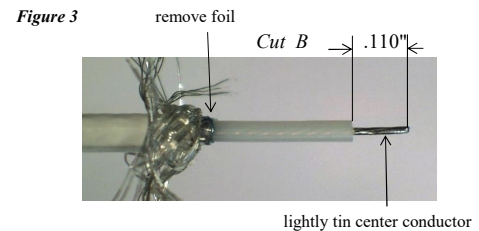
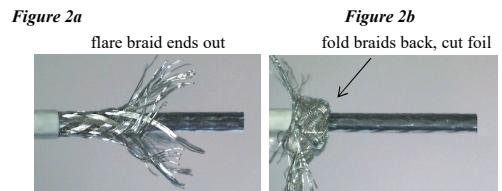
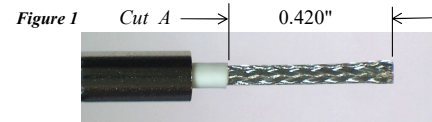


Termination Instructions for PIC P/N 111140- SMA 90° Plug
(for S31601 Coax Cable)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Cuticle Scissors
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool, w/ M22520 / 5 - 08 Hex Crimp Die Set (.128" hex) Soldering equipment, Heat Gun, Loctite # 271

Dimensions in Inches - NOT to Scale

- 1) Cut cable end squarely, re-form to concentric shape. Install ATUM 8/2 shrink tube and crimp ferrule onto the cable as shown (Fig. 1). Make Cut A @ .420" from cable end, scoring the jacket only (Fig. 1). Do not nick or cut into braids. Remove the jacket.
- 2) Flare the braid ends out, keeping at least half the braid weave intact (Fig. 2a). Fold all braids back to expose foil at Cut B (Fig. 2b), maintaining braid weave as intact as possible. Score foil just past the folded braids, use caution to avoid nicking or cutting any braids. Do not cut into dielectric. Remove foil to expose the dielectric (Fig. 3).
2a) To Remove Foil: Apply heat with heat gun if necessary to weaken the bond of the foil to the dielectric. Do Not exceed 500° F, and Do Not apply heat for more than 10 seconds max. Inspect the dielectric to ensure all foil was removed. Some blue residue may remain on the surface of dielectric. Clean dielectric as needed, using clean, dry compressed air and Isopropanol if necessary.
- 3) Make Cut B @ .110" from the cable end, through the dielectric (Fig. 3). Do Not nick or cut into the small, stranded center conductor. Remove dielectric, verify center conductor integrity. Lightly tin the center conductor (Fig. 3).
- 4) Insert the cable into the connector, lining up the center conductor with the slotted groove, solder the center conductor by filling the slotted groove (Fig. 4). Clean any excess solder as necessary. Apply a small amount of Loctite #271 to the threads and tighten the cap down.
- 5) Lay braids down flat over the rear of the connector body, covering the knurl, and trim braids at the shoulder (Fig. 5).
- 6) Pull crimp ferrule up over braids, up to the shoulder, and trim off any stray braids. Verify the center contact is in the correct position. Crimp the ferrule using M22520/5-01 hex crimp tool, with M22520/5-08 hex crimp die set, .128" hex (Fig. 6).
- 7) Locate and shrink the ATUM 8/2 × 1.0" dual wall shrink tube over the connector and cable, starting at the shoulder (Fig. 7).



Note : Connector Length added to cable = + .13" nominal to end of cube body