

PIC Wire & Cable

A Division of the Angelus Corporation
Ph (262) 246-0500 Fax (262) 246-0450 www.picwire.com
N220 W1051 Springdale Rd, Waukesha, WI 53186

Termination Instructions

T-111202

Approved : FMB

Date : 05/04/22
Rev 1 (06/1/2022)

Distribution : USER

Uncontrolled if Printed

Termination Instructions for PIC 111202 BNC Bulkhead Jack connector

for S44191, S44193, S46191, RG142, and RG400

Recommended Tooling :	X-acto Knife, Cuticle Scissors, Cable Cutter, Heat Gun
Required Tooling :	M22520/5-01 Hex Crimp Tool with die 5-11. Soldering equipment

- 1) Cut cable end square. Slide ATUM heat shrink and Crimp Ferrule over the cable jacket. Make Cut A through the jacket and all shields. DO NOT nick or cut the dielectric. SCORE the jacket at cut B, being careful not to nick or cut the shield. Leave jacket on for now (Fig. 1)
- 2) Make Cut C, through the Dielectric, down to Center Conductor (Fig. 2). DO NOT nick or cut into the Center Conductor. Remove the dielectric and clean the face of the exposed dielectric of debris or stray braids.
- 3) Install Center Contact onto the cable center conductor, until end of contact is flush with dielectric. DO NOT force the center contact into the dielectric. Ensure center conductor is visible through inspection hole. Solder OR crimp the center contact using M22520/5-01 with die 5-11 hex B .068" (Fig. 3).
- 4) Complete Cut B, through the Jacket (Fig. 3). DO NOT nick or cut into the wire braids. Slit lengthwise and remove the jacket.
- 5) Flare out the wire braids, to approximately 45° (Fig. 4). Slit the Foil lengthwise in three or four places, and flare out to expose the Strip Braid. Carefully flare the Strip Braid out, away from the dielectric (w/ X-acto knife), all the way down to the bottom. Avoid disturbing the dielectric. The dielectric must be exposed for full length of the strip dimension (near Cut B).
- 6) Clean the dielectric and center contact as needed. Dry compressed air may be used if necessary (carefully). Inspect and clean Connector Body as needed. Install the connector body over the dielectric and under the shields (Fig. 5), until the center contact captivation groove is engaged. Avoid disturbing or deforming the dielectric. Verify captivation with a light tug.
- 7) Smooth all braids down over the rear of the connector body, covering the knurl. Pull the crimp ferrule up onto the connector body. Secure the body while positioning the ferrule, to avoid shifting the captivated center contact. Trim any stray braids/foil at the shoulder prior to seating the ferrule against the connector body (Fig. 5).
- 8) Verify Center Contact position visually. Crimp the ferrule with M22520/5-01 Crimp Tool and crimp die 5-11 Hex A .213" (Fig. 6).
- 9) Shrink the ATUM dual wall shrink tube onto the connector and cable, starting behind the shoulder as shown (Fig. 7)

