

PIC Wire & Cable

Termination Instructions

T-110842

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Approved : *JVH*
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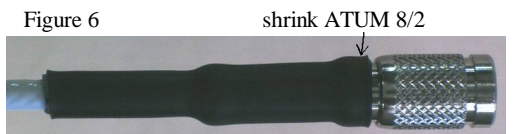
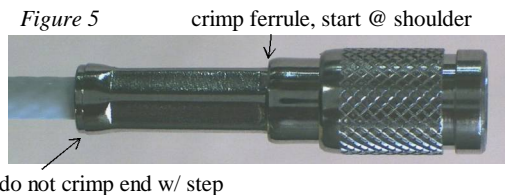
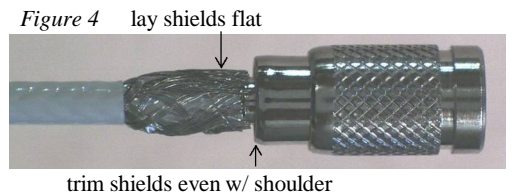
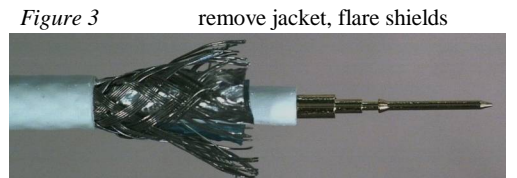
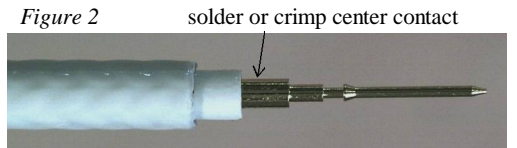
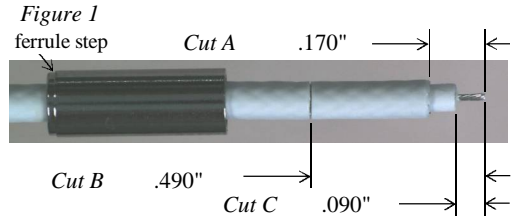
Date : 08/26/14
Rev. 0
Uncontrolled if Printed

Termination Instructions for PIC P/N 110842, 1.0/2.3 DIN Straight Plug connector for PIC V76261, V73263, V75268 Coax Cable

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	M22520 / 5-01 Hex Crimp Tool M22520/ 5-41, cav. B (.178" hex) Soldering equipment, OR Daniels # Y1833P Die Set (.042" square crimp)

Dimensions in Inches (Not To Scale)

- 1) Install ATUM 8/2 dual wall shrink tube x 1.5" onto the cable. Install the crimp ferrule onto cable, small step first (Fig. 1). Make Cut A @ .170" from cable end, through the jacket, wire braids, and foil (Fig. 1). Do not cut into dielectric. Remove jacket, wire braids, and foil.
- 2) Make Cut B @ .490" 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 @ .090" 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) Verify proper fit of the center contact onto the stranded center conductor, with all strands intact, and visible in the inspection hole. Solder or crimp the center contact onto cable center conductor (Fig. 2). If crimping, use .042" square crimp cavity (M22520/5-01 crimp tool w/ Daniels # Y1833P die set), crimping the center contact between the inspection hole and cable dielectric.
- 5) Remove jacket at Cut B. For **V76261**, flare the wire braids away from the cable, slit foil in 3 or 4 places and flare out (Fig. 3). For **V75268**, flare all braids out. For both, clean exposed dielectric and contact with clean, dry compressed air as needed. For **V73263**, unwrap the spiral shield layer all the way down to the bottom (of Cut B) without twisting it. The spiral strip can be positioned straight out along the inside of the flared braids. Dielectric must be exposed for the full length of the strip length (to Cut B).
- 6) Inspect and clean the dielectric as needed, prior to installing the connector body onto the cable. Inspect and clean connector body entry as needed.
- 7) Install the connector body over the dielectric and under the flared shields, until the center contact snaps into the connector's internal captivation.
- 8) Smooth all braids down over the rear of the connector body, covering the knurl. Trim off any excess braids past the knurled rear body, trim even with the shoulder (Fig. 4).
- 9) Pull the crimp ferrule up over the braids. 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 connector body.
- 10) Verify that the connector is fully seated onto the cable. Crimp the ferrule with the M22520 / 5 -01 hex crimp tool, using the M22520/ 5-41 hex crimp die set, cavity B (.178" hex). Start crimp at connector shoulder (Fig. 5), do not crimp the end of ferrule with step (Fig. 5).
- 11) Shrink the ATUM 8/2 dual wall shrink tube, starting approximately .050" behind the 1.0/2.3 coupling nut, covering the rear of the connector body, and onto the cable (Fig 6).



Note: Connector Length added to cable = .400" nominal