

A Division of the Angelus Corporation
 Ph (262) 246-0500 Fax (262) 246-0450 www.picwire.com
 PO Box 330 Sussex, WI 53089

Approved : *PFT*
 Distribution : USER

Date : 11/30/20
 Rev. 0
 Uncontrolled if Printed

Termination Instructions for PIC P/N 110876 - N Str Plug
(for S31601 Coax Cable)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Cuticle Scissors,
Required Tools and Equipment:	M22520 / 5- 01 Hex Crimp Tool, w/ M22520 / 5 - 08 Hex Crimp Die Set (.128" hex) & M22520 / 5 - 29 B Hex Crimp Die Set (0.100" hex), Soldering equipment, Heat Gun, Loctite #271, Torque Wrench, w/ 1/4" Hex Attachment

- 1) Cut cable end squarely, re-form to concentric shape. Install ATUM 12/3 shrink tube and crimp ferrule onto the cable as shown (Fig. 1). Make Cut A @ .735" 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 @ .210" 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) Install hex clamp nut, crimp tail, and insulator. Solder or crimp center contact onto the cable center conductor (Fig. 4). If crimping, use M22520/5-01 hex crimp tool, with M22520/5-29 hex die set, cavity B (.100" hex). Inspect and clean parts as needed, using clean, dry compressed air if necessary.
- 5) Inspect and clean connector body as needed. Install the connector body over the contact, and under the shields until the center contact is fully seated. Apply a small amount of Loctite #271 to the hex nut threads and tighten to 7-10 in-lbs (Fig. 5). Lay braids down flat over the rear of the connector body, covering the knurl, and trim braids at the hex clamp nut (Fig. 5).
- 6) Pull crimp ferrule up over braids, up to the hex nut, 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 12/3 x 1.5" dual wall shrink tube over the connector and cable, starting over the hex nut (Fig. 7).

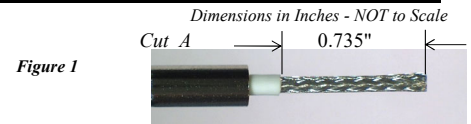


Figure 1
 Figure 2a flare braid ends out
 Figure 2b fold braids back, cut foil

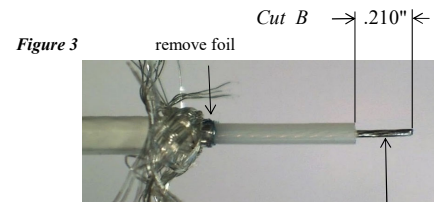
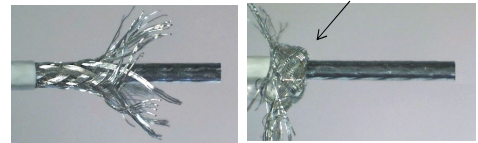
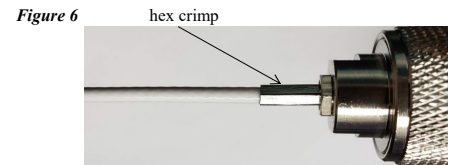
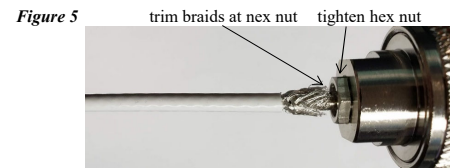
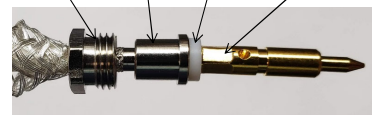


Figure 3
 Figure 4 hex clamp crimp tail insulator solder or crimp contact



Note : Connector Length added to cable = + .52" nominal to end of connector