Termination Instructions for PIC P/N 110212, 110260, 111113, and 110286 Size 8 D-Sub 50-ohm Connectors

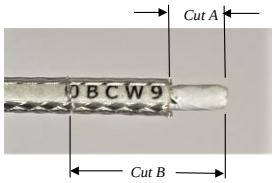
Required Tooling :	M22520/ 2-01 Contact Crimp Tool, M22520/ 5-01 Hex Crimp Tool M22520/ 5-41 Hex Crimp Die Set, Cav. B (.178 hex)
Recommended Hand Tools :	X-acto Knife, Sharp Razor, Cuticle Scissors

S86208/ S88207/ S83204 Cables (50-ohm)					Strip Dimensions			
Connectors	PIC Positioner #	Daniels #	Dial #	Hex Crimp Die Set	Hex Size	A	B	C
110212 110260 110286	110254	K426	7	M22520/ 5-41, cav. B	0.178	0.195	0.430	0.180
111113						0.190	0.500	0.170
V75268 / V76261 / V73263 cable (75-ohm)					Strip Dimensions			
Connectors	PIC Positioner #	Daniels #	Dial #	Hex Crimp Die Set	Hex Size	A	B	C
110212	110254	K426	5	M22520/ 5-41, cav. B	0.178	0.195	0.430	0.180

Dimensions in Inches - NOT to Scale

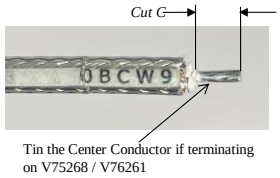
1) Cut the cable end square. Install the crimp ferrule over the jacket. SCORE the outer jacket at Cut A and Cut B, at the dimensions per the chart above, without cutting into cable shielding. Complete Cut A. Trim off all braids at Cut A.

Figure 1



2) Cut at Cut C, through dielectric, down to Center Conductor. DO NOT nick or cut into the Center Conductor. Remove the dielectric; use caution to keep the small stranded Center Conductor intact. *If terminating on V75268 / V76261 cable,* ***tin*** *the Center Conductor of the cable*

Figure 2



3) Install Center Contact onto the cable Center Conductor, until end of Contact is fully seated. This will leave approximately .060" of the Center Conductor exposed between the Center Contact and the Dielectric. Solder or crimp the Center Contact to the Center Conductor. Refer to above chart for correct Crimp Die Set. Inspection hole should show Center Conductor / Solder (if soldered)

Figure 3

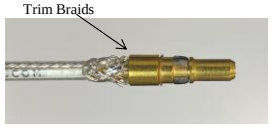
4) Complete Cut B, through the Jacket. DO NOT nick or cut into the Shield or Braids. Slit lengthwise and remove the Jacket. Flare out the Braids, less than 45°. Carefully flare the Strip Braid out (or foil), away from the dielectric, all the way down to the bottom. Avoid disturbing the dielectric. The dielectric must be exposed for full length of Cut B *(X-acto knife).*

Figure 4

5) Clean the 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 Connector Body over the Dielectric and under the shields, until the Center Contact snaps into the captivation groove. Avoid disturbing or deforming the Dielectric. Verify captivation with a light tug.

Figure 5



7) Smooth all braids down over the rear of the connector body, covering the knurl. Trim off briads at the shoulder *(Cuticle Scissors).*

8) 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 at the shoulder prior to seating the ferrule against the connector body.

Figure 6

9) Verify Center Contact position; visually and by verifying captivation.
For 110212, the Center Contact will extend approximately .010 - .020" past the front of the connector when fully inserted.
For 110260 , the Center Contact will be slightly recessed from the front of the connector when fully inserted.
For 111113, the Center Contact will be flush with the internal Dielectric.
Crimp the ferrule with M22520/5-01 Crimp Tool and Crimp Die Set as specified in chart above.

10) Apply Dual Wall Heat Shrink tubing if applicable.