PIC Wire & Cable
A Division of the Angelus Corporation
Ph (262) 246-0500 Fax (262) 246-0450 www.picwire.com
W220 N1051 Springdale Road Waukesha, WI 53186

Termination Instructions	T-110786
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Distribution : USER	Uncontrolled if Printed

Termination Instructions for PIC P/N 110786 - Size 5 Pin

(for S31601 Coax Cable)

Required Tooling :	M22520 / 5- 01 Hex Crimp Tool, w/ M22520 / 5 - 09 Hex Crimp Die Set (.068" hex and .178" hex) Soldering equipment, Heat Gun
Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Magnifier, Cuticle Scissors

1) Cut cable end squarely, re-form to concentric shape.Make Cut A @ .512" from cable end, scoring the jacket only (Fig. 1). Do not nick or cut into braids. Remove the jacket.

2) Install the crimp ferrule over the braids, and locate it tight against Cut A (Fig. 2).

3) Flare the braid ends out, keeping at least half the braid weave intact. Fold all braids back to expose foil, maintaining braid weave as intact as possible. Trim braids at .177" from end of ferrule. Score foil just past the folded braids, using caution to avoid nicking or cutting ar braids. DO NOT cut into dielectric. Remove foil to expose the dielectric (Fig. 3).

3a) 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.

4) Make Cut B @ .080" from the folded briads, through the dielectric (Fig 4). Do Not nick or cut into the small, stranded center conductor. Remove dielectric, verify center conductor integrity. Lightly tin the center conductor (Fig. 4).

5) Install the insulator over the center conductor, locating it tight against folded braids, as shown (Fig. 5). Make Cut C on the center conductor .235" from the insulator (Fig. 5).

6) Solder the center contact over the center conductor, making sure it's tight against the insulator. Clean excess solder off, solder should be visible in the inspection hole (Fig. 6).

7) Inspect and clean connector body as needed. Install the connector body over the contact, and over the braids and ferrule until fully seated. It should cover the braids (Fig. 7a). Verify that the center contact is correctly located and tight to the end insulator (Fig. 7b).

8) Crimp the ferrule using M22520/5-01 hex crimp tool, with M22520/5-05 Cavity B (.178" Hex). Trim any excess braids at the shoulder of the crimped section. (Fig. 8).

Dimensions in Inches - NOT to Scale

Figure 1

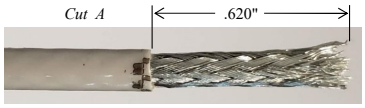


Figure 2

Figure 3

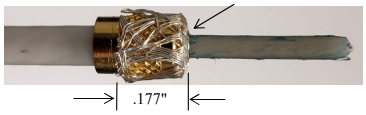


Figure 4

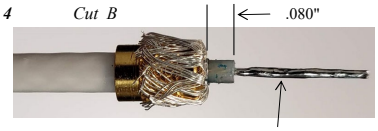


Figure 5

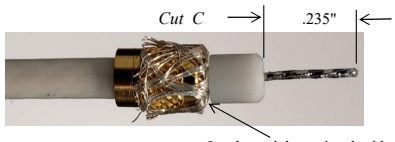


Figure 6

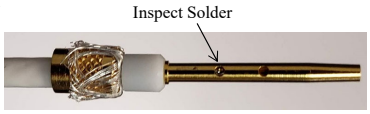


Figure 7a

Figure 7b

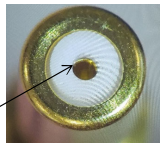
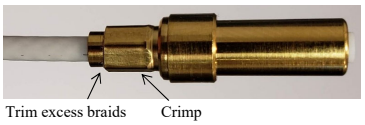


Figure 9



Note : Connector Length added to cable = + .365" nominal to end of connector.