

PIC Wire & Cable

A Division of the Angelus Corporation

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Termination Instructions

T-110983

Approved :

PFT

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Rev. 0

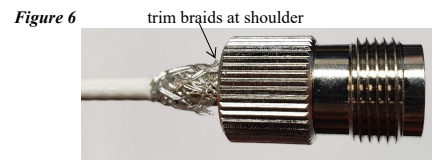
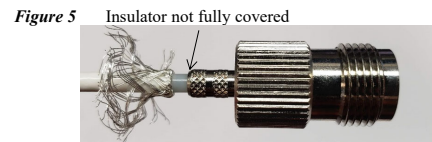
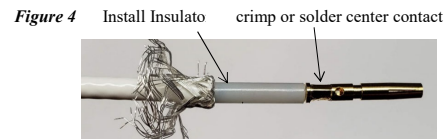
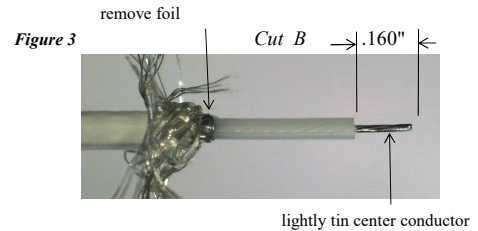
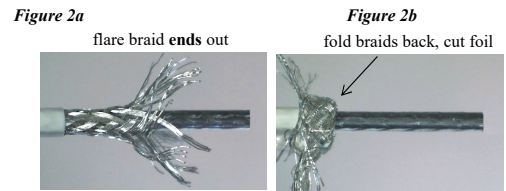
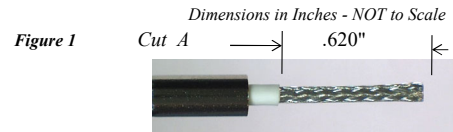
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Termination Instructions for PIC P/N 110983 - TNC Inline Jack (for S31601 Coax Cable)

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, Cuticle Scissors

- 1) Cut cable end squarely, re-form to concentric shape. Install ATUM 8/2 shrink tube and crimp ferrule onto the cable as shown (Fig. 1). Make Cut A @ .620" 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 @ .160" 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 the insulator onto the cable as shown (Fig. 4), as close as possible to Cut A. Solder or crimp the center contact onto cable center conductor (Fig. 4). If crimping, use M22520/5-01 hex crimp tool, with M22520/5-09 hex die set, cavity B (.068" hex), locating the hex crimp between the inspection hole and the end of the contact (Fig. 4). Inspect and clean insulator and center contact 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. Verify that the center contact is captivated. Note, the insulator will stick out from the back of the connector (Fig. 5)
- 6) Lay braids down flat over the rear of the connector body, covering the knurl, and trim braids at the shoulder (Fig. 6).
- 7) Pull crimp ferrule up over braids, up to the shoulder, 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).
- 8) Locate and shrink the ATUM 8/2 × 1.0" dual wall shrink tube over the connector and cable, starting just past the shoulder (Fig. 7).



Note : Connector Length added to cable = + .50" nominal to end of connector.

PIC Wire & Cable Termination Instruction sheets are non-controlled documents if printed. Please contact PIC Wire and Cable or visit the PIC website (www.picwire.com) to ensure the latest revision of the instruction is being used.