

# PIC Wire & Cable

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## Termination Instructions

T-11152

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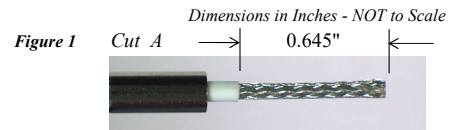
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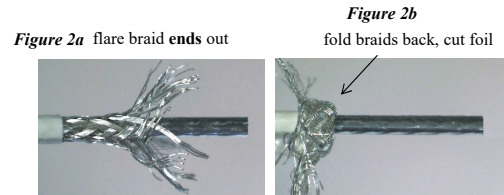
### Termination Instructions for PIC P/N 111152 - Size 8 Socket (for S31601 Coax Cable)

Required Tooling :	M22520 / 5- 01 Hex Crimp Tool, w/ M22520 / 5 - 08 Hex Crimp Die Set (.128" hex) American Beauty #105A3 Resistance soldering tweezers, Heat Gun, Loctite #271, Torque Wrench, Torque Wrench, w/ 1/4" Hex Attachment
Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters, Cuticle Scissors

- 1) Cut cable end squarely, re-form to concentric shape. Install crimp ferrule onto the cable. Make Cut A @ .645" from cable end, scoring the jacket only. Do not nick or cut into braids. Remove the jacket (Fig. 1).



- 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 at Cut A, use caution to avoid nicking or cutting any braids. Do not cut into dielectric. Remove foil to expose the dielectric.  
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) Install crimp tail over the exposed dielectric, tight to Cut A, fold braids over and trim at the shoulder (Fig. 3).



- 4) Slide the crimp ferrule up over the braids, and up to the shoulder. Using M22520/5/01 hex crimp tool, with M22520/5-08 hex die set, crimp the ferrule (Fig. 4).



- 5) Make Cut B at the end of the threaded crimp tail, through the dielectric (Fig. 5). Do not nick or cut into the small, stranded center conductor. Remove dielectric, verify the integrity of the center conductor. Lightly tin the center conductor (Fig. 5).



- 6) Slide the insulator disk over the center conductor and against the threaded crimp tail, then slide the center contact over the center conductor (Fig. 6). Using resistance soldering tweezers, apply heat to the center contact to reflow the solder. Make sure to keep the center contact tight against the insulator disk. Inspect the joint and clean as needed.



- 7) Inspect and clean connector body as needed. Apply a small amount of Loctite #271 to the threads of the crimp tail. Install the connector body over the contact, and tighten to finger tight. Using a torque wrench, tighten to 7-10 in-lbs (Fig. 7).



Note : Connector Length added to cable = + .425" nominal to end of connector

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