

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

Approved : *FMB*
 Distribution : USER

T-Sub 50

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 Uncontrolled if Printed

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 or Y140 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	Positioner	Alt. Positioner	Dial #	Hex Crimp Die Set	Hex Size	A	B	C
	PIC Positioner #	PIC # / Daniels #						
110212	Daniels# K2160	110254/K426	3 \ 5	M22520/ 5-41, cav. B	0.178	0.21	0.455	0.180
110260	110254/K426	N/A	7	M22520/ 5-41, cav. B	0.178	0.195	0.430	0.180
110286	110205/K424	N/A	8	M22520/ 5-41, cav. B	0.178	0.195	0.430	0.180
111113	110205/K424	N/A	7	M22520/ 5-41, cav. B	0.178	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	K2160 \ K426	5	M22520/ 5-41, cav. B	0.178	0.21	0.455	0.180

- 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. (Fig 1)
- Cut at Cut C, through the dielectric, down to the Center Conductor. DO NOT nick or cut into the Center Conductor. Remove the dielectric; use caution to keep the small stranded Center Conductor intact (Fig 2). Tin the center conductor if soldering, but do not tin if crimping.
- 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 (Fig 3). For 110212, install the spacer on the center conductor first, then install the center contact and there will NOT be a .060" gap (Fig 3a). 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).
- 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 (Fig 4).
- Clean the Dielectric and Center Contact as needed. Dry compressed air may be used if necessary (carefully). Inspect and clean Connector Body as needed.
- 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. (Fig 5)
- Smooth all braids down over the rear of the connector body, covering the knurl. Trim off braids at the shoulder (Cuticle Scissors). (Fig 5)
- Pull the 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. (Fig 6)
- 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.
- Apply Dual Wall Heat Shrink tubing if applicable.

Dimensions in Inches - NOT to Scale

Figure 1

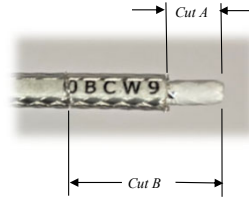


Figure 2

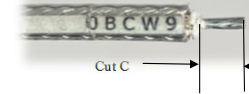


Figure 3

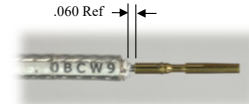


Figure 3a

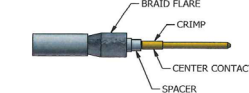


Figure 4



Figure 5

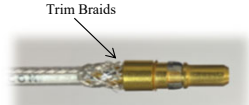


Figure 6

