Termination Instructions for PIC P/N 190809-L, TNC 90° Ext Length Plug Conn.

(For PIC S83204 / S86208 / S88207 Coax Cables)

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Cuticle Scissors or Wire Cutters
Required Cable Tools :	M22520 / 5- 01 Hex Crimp Tool PIC P/N 190818 Hex Crimp Die Set (For use with PIC weatherproof ferrule) M22520/5-09, Cavity A, .178" hex (For use with alternate ferrule - no weatherproof seal) Soldering Equipment Heat Gun

Dimensions in Inches (Not To Scale)

1) Straighten the end of cable, and re-shape the cut end to concentric, to assist in accurate stripping. Install the ATUM 12/3 dual-wall shrink tubing and selected crimp ferrule onto cable (Fig. 1). If using the ferrule with weatherproofing, install onto the cable as shown (Fig. 1a). If using the optional ferrule, install with shoulder towards the cable end (Fig. 1b).

Figure 1a

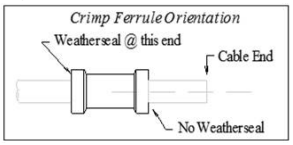
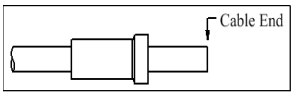


Figure 1b *(using Optional Crimp Ferrule)*

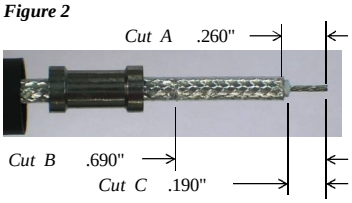


2) Make Cut A @ .260" from the end of the cable, through cable jacket and all cable shields, down to the dielectric (Fig. 2). Avoid cutting into the dielectric. Remove jacket and shields from Cut A (Fig. 2).

3) Make Cut B @ .690" from the end of the cable, scoring the cable jacket. Do Not nick or cut into the wire braids (Fig. 2). Do not remove jacket yet, leave in place (Fig. 2).

4) Make Cut C @ .190" from the end of the cable, through the dielectric, down to the center conductor (Fig. 2). Do Not nick or cut into the center conductor. Remove dielectric from Cut C (Fig. 2).

Figure 2

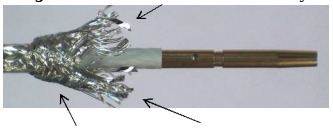


5) Install center contact onto the cable center conductor, to verify correct fit. Conductor should be visible in the inspection hole. Solder the center contact onto the center conductor (Fig. 3).
Do Not crimp the center contact.

Figure 3 solder contact on

6) Remove the cable jacket at Cut B. Flare braids slightly (Fig. 4), maintaining braid weave as much as feasible. Flare out the inner shield all the way down to the bottom to Cut B (Fig. 4). The dielectric must be exposed for the full strip length (to Cut B). Clean dielectric and center contact as needed, using clean, dry, low-pressure compressed air, avoid disturbing flared shields.

Figure 4 flare braids minimally



7) Inspect and clean connector body as needed. Install the connector body over the dielectric and under the shields until the center contact is fully seated (Fig. 5). Verify that the center contact is captivated.

8) Smooth all braids down over the rear of the connector body covering the knurl, maintain braid weave as much as possible (Fig. 5). Trim off stray braids at the shoulder (Fig. 5).

9) Position crimp ferrule over braids, up to connector body shoulder (Fig. 6). Secure the body while locating ferrule, to avoid shifting the center contact. Trim any stray braids at the shoulder prior to seating the ferrule against the connector body.

10) Verify center contact position prior to crimping. Crimp ferrule with M22520/5 - 01 hex crimp tool and PIC 190818 hex crimp die set (for weathersealed crimp ferrule), or M22520/5-09 hex crimp die set, Cavity A, .178" hex (if using optional crimp ferrule).

11) Shrink the ATUM dual-wall shrink tubing (Fig 7), centered over the connector body and cable as shown (Fig. 7).

Figure 5 Lay braids flat

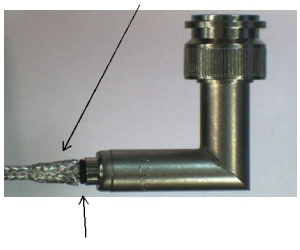


Figure 6 Hex crimp

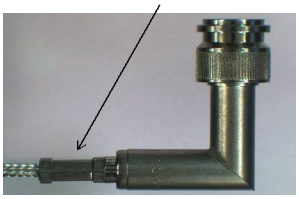


Figure 7 Shrink ATUM