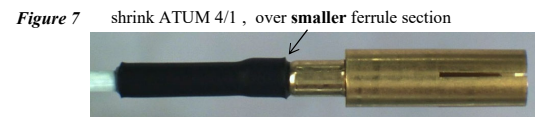
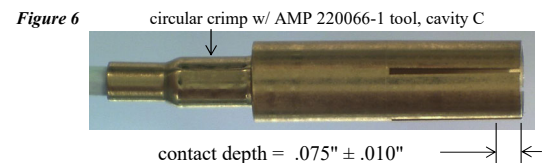
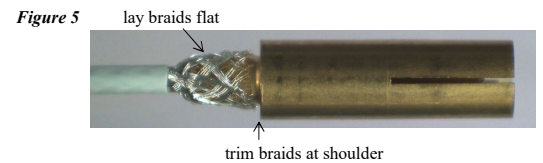
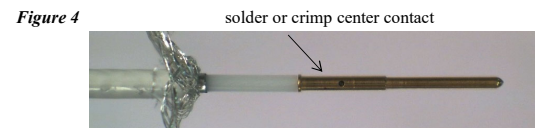
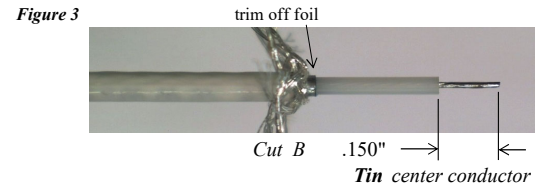
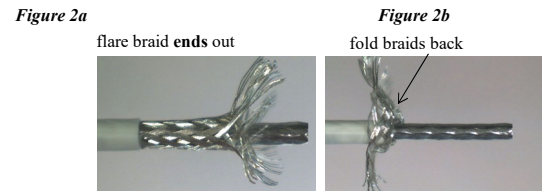
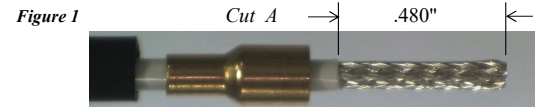


**Termination Instructions for PIC P/N 110928 ARINC Size 5 Socket**  
*(for S31601 Coax Cable)*

Recommended Hand Tools :	X-acto Knife, Sharp Razor, Wire Cutters
Required Cable Tools :	AMP (Tyco) # 220066-1 Circular Crimp Tool (alternate AMP # 220066-2)
	Soldering equipment, OR
	M22520 / 2 - 01 Center Contact Crimp Tool, Selector Dial @ # 5 recommended positioner: Daniels Mfg # K345
	Heat Gun

Dimensions in Inches - NOT to Scale

- 1) Cut cable end squarely, re-form to concentric shape. Install ATUM 4/1 shrink tube and crimp ferrule onto the cable as shown (Fig. 1). Make Cut A @ .480" from cable end, scoring the jacket only (Fig. 1). Do Not nick or cut into wire braids. Remove 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 C (Fig. 2b), maintaining braid weave as intact as possible.
- 3) Score foil around the circumference of the cable just past the flared braids and lengthwise to the end of the cable. Use caution to avoid nicking or cutting any braids. Do not cut into the dielectric. Remove foil to expose the dielectric (Fig. 3). Apply heat with heatgun as necessary to weaken the bond of the foil to the dielectric. Do not exceed 500° F, and apply heat for 10 seconds maximum. Inspect the dielectric to ensure all foil was removed. There may be a blue residue left on the surface of the dielectric.
- 4) Make Cut B @ .150" 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. Tin the center conductor sparingly (Fig. 3).
- 5) Solder or crimp the center contact onto cable center conductor (Fig. 4). If crimping, use M22520/2-01 crimp tool, dial setting @ # 5 , with Daniels Mfg # K345 positioner.
- 6) Inspect and clean dielectric and center contact as needed, using clean, dry compressed air if necessary (carefully). Inspect and clean connector body as needed.
- 7) Install the connector body over the dielectric and under the shields, until the center contact is fully seated. Verify the center contact depth is  $.075" \pm .010"$  (Fig. 6). Lay all braids down flat over the rear of the connector body, covering the knurl (Fig. 5), and trim braids at the shoulder (Fig. 5).
- 8) While securing connector body, pull crimp ferrule up over braids, up to the shoulder (Fig. 6), and trim off any stray braids. Confirm the correct center contact depth (Fig. 6). Crimp the larger section of the ferrule, using AMP (Tyco) 220066-1 circular crimp tool, cavity C,  $\varnothing .166"$  (Fig. 6).
- 9) Locate the ATUM 4/1  $\times .750"$  dual wall shrink tube over *smaller* section of the crimp ferrule *only*, and over cable. Shrink onto the ferrule and cable (Fig. 7). Do Not shrink over the larger ferrule section, which could potentially affect proper fit of extraction tools.



Note : Connector Length added to cable = + .570" nominal