

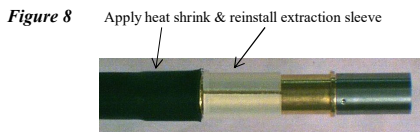
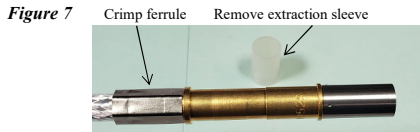
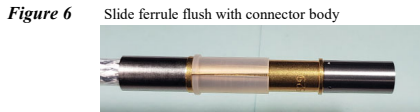
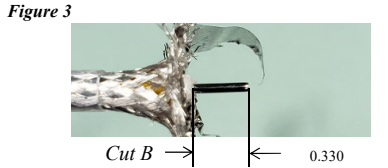
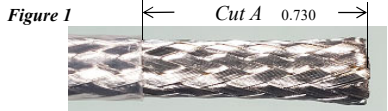
PIC Wire & Cable	Termination Instructions	T-190529
A Division of the Angelus Corporation Ph (262)-246-0500 Fax (262) 246-0450 www.picwire.com PO Box 330 Sussex, WI 53089	Approved : <i>PFT</i>	Date: 07/16/19
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Termination Instructions for PIC P/N 190529, ARINC 600 Size 8 Socket Contact
(for S67163 Coax Cable)

Recommended Hand Tools :	Sharp Razor, Wire Cutters, Cuticle Scissors, Digital Calipers w/ depth gauge
Required Cable Tools :	M22520/5-01 Hex Crimp Tool M22520/5-13, Cavity A, .255" Hex Crimp Die Set Soldering Equipment Heat Gun

- 1) Make sure end of cable is cut square. Install heat shrink and ferrule over the cable before cutting. Make Cut A @ .730" from the cable end, through the outer jacket (Fig. 1). Do not nick or cut into the wire braids.
- 2) Flare out the outer braid to expose the (gold) foil shield. Slit the foil lengthwise in three or 4 places and flare back the same as the outer braid. Carefully flare out the Strip Braid away from the dielectric, away from the dielectric using tweezers or an *X-acto knife* (Fig 2).
- 3) Make Cut B .330" from the cable end, through the dielectric (Fig 3). Do not nick or cut into the center conductor.
- 4) Slide the center contact onto the center conductor of the cable, ensuring it seats against the cable dielectric. Solder the center contact onto the cable center conductor (Fig. 4).
- 5) Install the contact body over the center contact and dielectric until it is fully seated (Fig. 5). Fold the strip braid, foil shield, and wire braid (one at a time) over the contact body crimp area. Trim the braids as necessary up to the shoulder of the crimp ferrule area (Fig. 5).
- 6) Smooth down the braids/foil. Slide the crimp ferrule over the braids, up to the contact shoulder (Fig 6.). Trim any stray braids at the shoulder of the contact body.
- 7) Verify that the contact body is fully seated onto the cable. Crimp the ferrule using the M22520 / 5-01 Hex Crimp tool with M22520 / 5-13 die set, cavity A - .255" hex (Fig. 7).
- 8) Remove the extraction sleeve (Fig. 7) before heating the heat shrink tube. Starting at the contact shoulder, heat the ATUM 12/3 dual wall heat shrink, covering the ferrule and cable (Fig. 8). Re-install the extraction sleeve.

Dimensions in Inches (NOT to Scale)



Note : Connector Length added to cable = + 1.20" nom.