

WORKING WITH PL-259s AND COAX

By
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The evolution of a connector installation (note one is out of order).



Mark all 3 cuts on the outer jacket using the connector as a guide. Allow for extra length on the center conductor, make the first 2 cuts $1/16$ " apart on either side of the 2nd raised, knurled section, and make the third cut about $1\ 1/8$ " from the end of the center conductor.

For LMR 400 and RG 213, the jacket may be so tight inside the connector that the braid and conductor will not be in far enough, so make the 3rd cut about $1\ 3/8$ " in.



Make the cuts using a razor knife. Hold the knife with light pressure and roll the cable across the table under the knife.



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After making a circumference cut on the dielectric, it is very difficult to separate it from the conductor by pulling. Shave the plastic down to the conductor on one plane, make a lengthwise cut on the plastic, and it will separate.



After shaving, here is what the end view should look like to facilitate removal.



Clean up any protruding strands of the braided shield with a razor knife before removing the third length of jacket.



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Twist the center conductor tightly and tin the conductor before installing cable in connector.

Twist the cable gently as you push it into the connector. Make sure braid is visible in all solder holes.

Check connector body to center conductor with an ohmmeter Prior to soldering. Verify a reading of infinity.



Mount in bench vise with cable and connector angled down so that solder will flow up without damaging the dielectric.

Solder the center conductor first, letting the solder flow up .

Re-test with ohmmeter.



For the braid, solder with at least 100W.

Place the soldering tip at the edge of the hole and get connector hot enough to transfer heat to the braid. Feed the solder directly into the hole until you can see it flow across the braid.

Complete this solder connection for at least 2 holes.

Hold the connector assembly with a damp rag to dissipate heat.



COAX TO TWIN-POST CONNECTION



After stripping back the outer jacket, pull the braid back as far as possible.



Work an opening in the braid with a pick-type tool being careful not to damage the braid.



Pull the dielectric and conductor through the hole in the braid.



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Twist the braid and strip back the dielectric. Solder or apply crimp connectors

