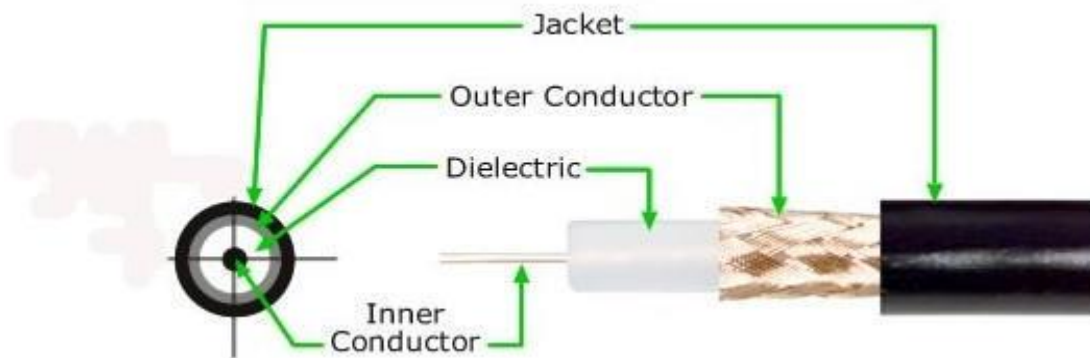


Making Crimp coax connectors for RG-213 & LMR-400

Source: http://www.bcdxc.org/pl259_crimp_on_connectors.htm

The terminology associated with coaxial cable

The primary characteristic of a coaxial cable is that it consists of an inner conductor and an outer conductor that share a common axis (hence the term coaxial). These two conductors are typically separated by a dielectric (non conductive) material.



Note: the 'outer conductor' will be referred to as the "braid" in this document and the 'inner conductor' will be referred to as the "centre conductor"



RG58 cut length



Use good quality coax cable



RG-213 cut length

Note: these cut lengths are shown for information purposes only. The Cablematic tool cuts to the proper length.



Use good quality crimp connectors that are SST (silver body, silver barrel with a Teflon centre)



Step #1
Slip a short piece (1½") of 3/4" shrink tubing and the crimp barrel onto the coax



Step #2
Using the "**First Cut**" end of the Cablematic tool, smoothly rotate the tool while applying even pressure towards the cable. All layers down to the centre conductor will be cut in this single step. About 10 turns of the tool should give you the correct length of exposed centre conductor. As you release cutting pressure on the tool, the cutting action will stop.
Use non-slip gloves for a good grip on the tool and the cable.



Step #3
Here is the trimmed RG-213



Step #4
Using the opposite end of the Cablematic tool, trim off the jacket of the cable. The tool will stop automatically

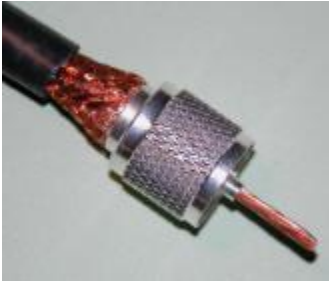
when the correct length has been trimmed off.



Step #5
The jacket has been fully trimmed off



Step #6
Using very sharp nippers, carefully trim back about 1/4" of the braid



Step #7
Carefully slip the connector onto the prepared coax and ensure the connector is fully seated. The braid should just meet the edge of the connector.

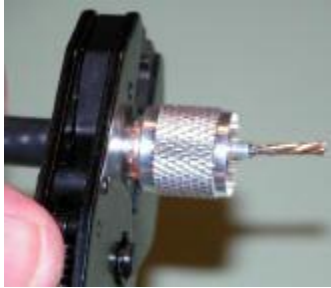


Step #8
Hold the assembly on a slight angle to solder the centre conductor. While you can crimp the centre conductor, a better mechanical connection is made if it's soldered. It helps to have a vise or support for the soldering iron.



Step #9
After the solder has cooled, slip the barrel up to

Step #8
Close-up view of the process



the connector. Ensure the barrel is fully seated against the end of the connector body.



Step #9A
Using the crimp tool, apply even pressure until the ratchet stops. Ensure the crimp tool sits **very** close to the body of the connector

Step #9B
The finished crimp!
The next steps are beautification



Step #10
The excess centre conductor must be cut



Step #10A
Use line pliers to cut the centre conductor



Step # 10B
Apply even pressure in one cut



Step #10C
The finished cut should be just ahead of the connector tip.
Do not cut the connector.



Step #11
Slip the piece of 3/4" shrink tubing into place



Step #11A
Use a good quality heat gun to shrink the tubing.
Be careful not to apply too much heat.
See note below about the heat gun



Step #11B
With the right touch, the shrink tubing will run perfectly



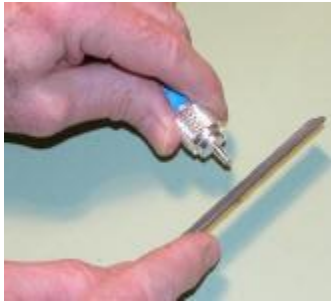
Step #11C
Nearly done



Step #11D
Shrink is fully seated



Step #12
File off the rough end of the centre conductor



Step #12A
Use a small fine file for this process



Step #12B
Apply short even strokes while holding the connector



Step #12 C
The finished job with a little of the centre
conductor showing beyond the connector



The finished connector!
This is a perfect connector in every way