

## Terminating Amp 225087-4 SHV connector to RG-180 cable

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Material:

-RG-180 coax cable

-Amp/Tyco 225087-4 connector

-Polyolefin shrink tubing  $\frac{1}{2}$  inch diameter x 1" long, *do NOT use this item for LAr immersion.*

- Polyolefin shrink tubing  $\frac{1}{4}$  inch diameter x  $\frac{3}{4}$ " long

-Using a coax stripping tool, cut or score the outer jacket of the coax  $\frac{3}{4}$  inch and 1 inch from the end of the cable.

-Remove the  $\frac{3}{4}$  inch piece of the outer jacket.

-Use an awl to straighten out the strands of outer braid and then cut the exposed outer braid strands off.

-Slide the barrel of the Amp connector onto the coax. Make certain the flare of the barrel is towards the cable end and not the connector end of the assembly.

-Slip the two pieces of shrink tubing onto and down the coax.

-Carefully remove  $\frac{1}{4}$  inch of the inner conductor insulation from the end of the coax. The center conductors are very small and fragile.

-Tin the center conductor with solder.

-Move the  $\frac{1}{4}$  inch diameter shrink tubing up to the edge of the score or cut in the outer jacket at the 1 inch point and heat shrink it onto the outer jacket.

-Clamp the center pin/socket of the Amp connector in an insulated vice or tweezers.

-Solder the center conductor of the coax into the center pin of the Kings connector. Since the center conductor of the coax are considerably smaller than the hole in the connector pin, it is possible to get the soldered pin off center, attempt to align the center pin and insulation of the center conductor concentrically.

-Remove remaining piece of outer jacket that was scored at the 1 inch point.

-Spread out exposed braid on coax and then slide center conductor with pin into Kings connector body.

-Slide connector barrel over previously shrunk  $\frac{1}{4}$  inch tubing and braid on connector body.

-Crimp connector barrel with 0.215 inch hexagonal die.

-Slide  $\frac{1}{2}$  inch shrink tubing over crimped connector barrel and up onto Kings connector approximately  $\frac{5}{16}$  of an inch and heat shrink into place, *do NOT use this item for LAr immersion.*