

## Terminating Kings 1705-2 SHV connector onto RG-180

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Material:

-RG-180 coax cable

-Kings 1705-2 connector

-Shrink tubing  $7/16$ " diameter x  $1\ 1/4$ " long

-Shrink tubing  $1/4$ " diameter x  $3/4$ " long

-Using a coax stripping tool, cut or score the outer jacket of the coax  $5/8$  inch and  $15/16$  inch from the end of the cable.



Fig. 1

-Remove the  $5/8$  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.

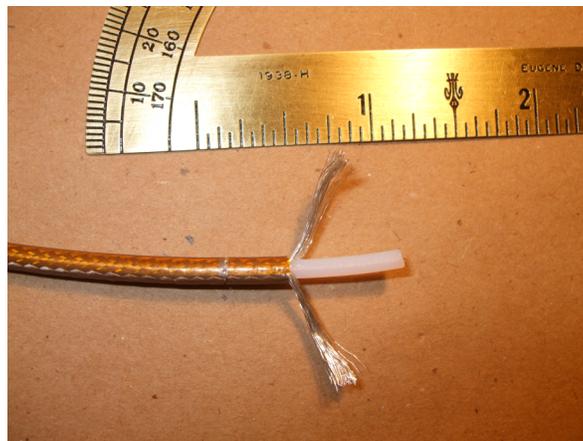


Fig.2

-Slide the barrel of the Kings connector onto the coax.

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

-Carefully remove  $3/16$  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.



Fig.3

-Move the 1/4 inch diameter shrink tubing up to the edge of the score or cut in the outer jacket at the 15/16 inch point and heat shrink it onto the outer jacket.

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

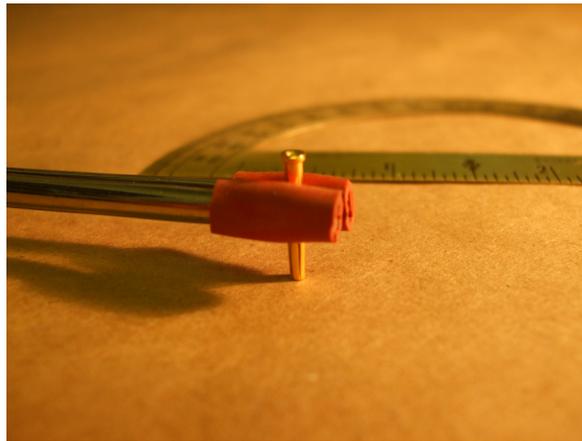


Fig.4

-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 15/16 point.

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



Fig.6

-Slide connector barrel over previously shrunk 1/4" tubing and braid on connector body.

-Crimp connector barrel with 0.215 inch hexagonal die.



Fig.6



Fig.7

-Slide 7/16 shrink tubing over crimped connector barrel and up onto Kings connector approximately 5/16 of an inch and heat shrink into place.



Fig.8