

Design Note

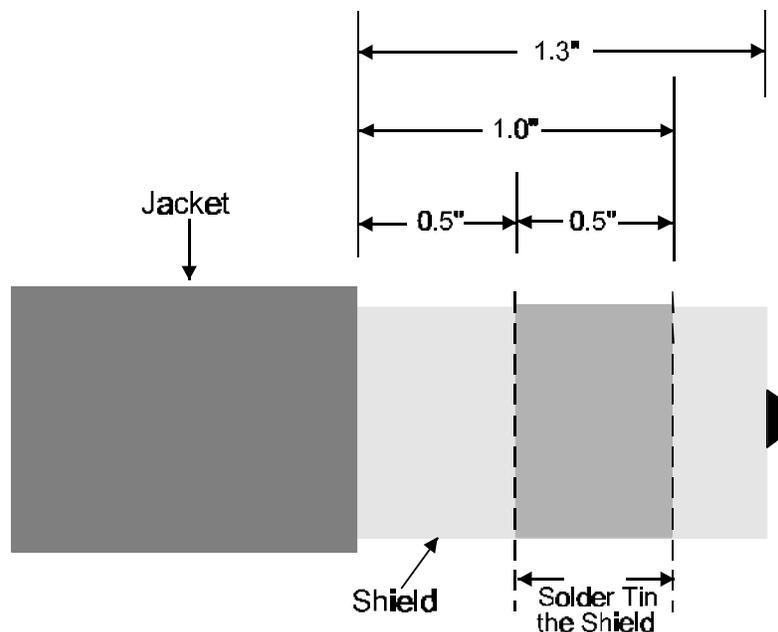
From: DEMI Production Dept.

DN#: 010

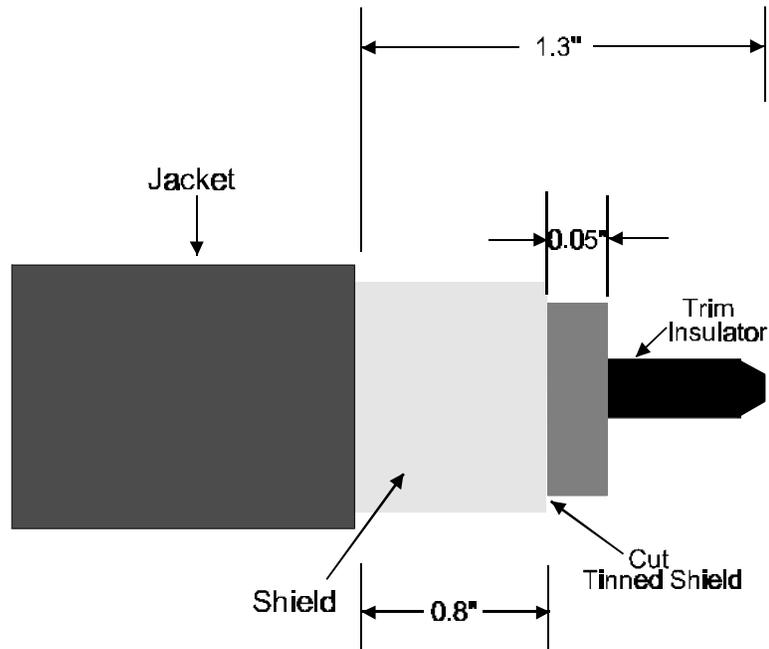
Date: August 15, 2002

Re: Assembly of Times Microwave LMR-400 connectors

PREFACE: The following is a basic 2 step procedure to prepare a Times Microwave LMR-400 cable before connector assembly. The connectors we supply are the RF Industries model RFN-1001-S. It is a 2 piece solder type connector. The tolerance of measurement is not critical and makes the assembly as simple as a standard PL-259 type connector. Examine the first figure and proceed in trimming the cable to the specified dimensions.



After trimming, tin solder the approximate area shown in the figure above. Be sure to flow it evenly and completely around the shield. When completed, the shield will be rigid and will sustain scoring with a knife.



With a knife or small tubing cutter, score the tinned shield as indicated. Cut and remove the shield and insulating material. De-bur the center conductor with a small file. Trial fit the connector. The edge of the shield should be 100% tinned before attempting insertion in a connector. If not the shield will bind and not allow the connector assembly. The connector is slid on until the outer jacket contacts the connector. Then twist in a clockwise direction for a minimum of 1 turn. This should seat the connector. Be sure the center conductor fits into the center pin of the connector completely. If unsatisfied with the fit, remove the connector and re-trim coax.

If the fit is good, solder the pin first. You may apply liquid flux if desired but not necessary. Solder the shield last. It will require a lot of heat but do not use an open flame. When complete, clean and then assemble the outer part of the connector with appropriate wrenches.

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