



Termination Techniques for Harbour's SS402 and SS405 Flexible Coax Cables

- 1) Use the same solder-on type connectors you would normally use for RG402 or RG405.
- 2) The cable should be flush-cut, at both ends to the proper length first. The cutting tools can be the same as those currently used for semi-rigid cable.
- 3) Before removing the FEP jacket, dip 1/8 to 1/2 inch of both ends of the cable into a solder pot. This will bond the shield structure together (to maximize shielding effectiveness at the connector joint) and tin the shields in preparation for soldering to the connector body. Flux may be applied to the end of the cable prior to dipping, if desired. Note that this is the single most important step in terminating Harbour's Spiral Strip Coax.
- 4) After the shields are tinned, the FEP outer jacket can be carefully stripped away. Exercise care when cutting the jacket, as the shield structure of the cable requires the use of small diameter members that might be damaged.
- 5) Preparing the cable should now follow the directions that accompany the connectors you are working with. The tinned outer conductor of the cable is the same size as the semi-rigid cable you are replacing.
- 6) Short pieces of shrink-tube are recommended as connector boots to enhance both the strength and appearance of the connector/cable junction.
- 7) Use of automated stripping machines is highly recommended. This can also eliminate the FEP jacket removal step, making it part of the automated stripping sequence. Since no pre-bending of cable assemblies is necessary, automated semi-rigid termination equipment is not required.