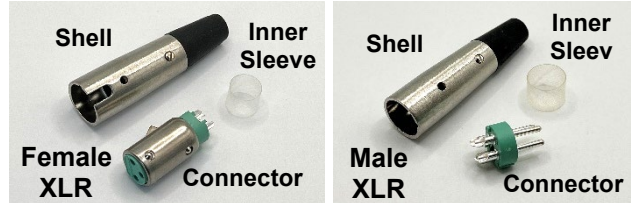
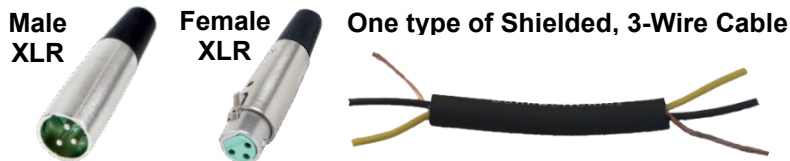


How to Solder “XLR” Connectors / Microphone Cables



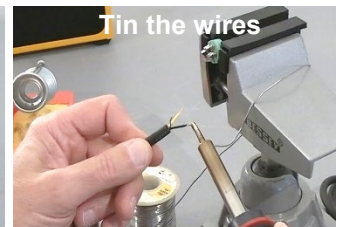
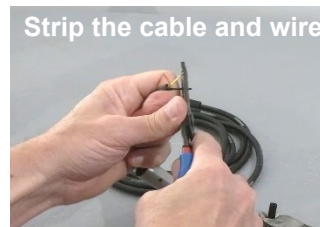
First follow Steps 1 - 5: 1) Clear the Work Area. 2) Turn on the Soldering Iron, Fan, Wet the Sponge. 3) Set up your Vice. 4) Ready the Solder, and Most Importantly 5) Put on your Safety Glasses Now!

6. Prepare the Cable and Connectors: The preparation of the cable and connectors go hand in hand (so they are combined in this step).

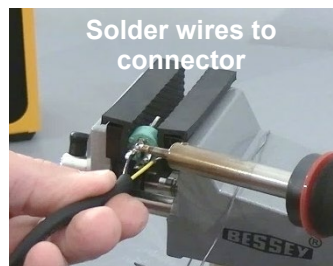
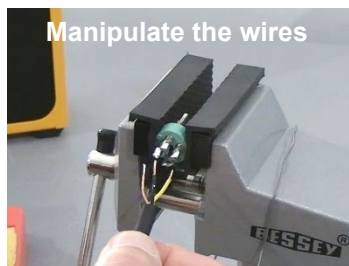
- Determine the cable length you need – roll the cable up slightly.
- Take the connectors apart (loosen the screws slightly).
- Slide the connector handles (and inner sleeves) on each end of the cable, and in the correct orientation. Do not skip this step or you will have to un-solder your connections to get the covers and inner sleeves on later.
- Place the “male” connector in the vice (we are only using the male XLR end in this example as the female XLR connector was covered earlier). Do not over tighten the vice on the connector.
- Tin the connector leads.
- Prepare both cable ends by stripping the cable jacket back, and then stripping the wire to the pre-determined lengths (size the wires up to the connector).
- Twist the wire strands together as needed – then Tin the wires on both ends of the cable.



7. Soldering: It’s now time to solder the wires to the connector. First, “manipulate” the wires so that they line up with the connector leads. Then with the male XLR connector firmly in the vice, hold the end of the cable and solder the “Shield” wire onto the Pin-1 connection, then the “Black” wire on the Pin-3 (middle connection), and finally the “Yellow” wire on the Pin-2 connection.



Pin configuration: Pin 1 = Shield, Pin 2 = Hot, and Pin 3 = Common



Once you are finished soldering the wires on the connector, slide the connector shell and inner sleeve up the wire and connect both ends of the connector together (when pulling on the cable, pull gently, just enough to work the wire through. With the connector all together, take your small screwdriver (tweaker) and tighten the screws (as shown, be careful not to over-tighten). Now solder the Female XLR connector to the other side of the cable using the same steps stated above (also reference the video clip).

All finished: Test the cable/connectors, then wrap the cable (as shown on website). The XLR connector is a fairly easy connector to solder, and with a bit of extra practice, it will get even easier. The XLR connector is used on many types of audio cables (for balanced connections) and is also referred to as a “Canon” plug. [Video Clip!](#)

Safety must be made a priority whenever you solder – AVCSS Tech World cannot be held responsible or liable for any injuries incurred from any soldering method or technique shown in this Handout or on our Video Clips. Always use Caution!