



7/8" EIA Flange connector shown



A: Connector body
B: Inner assembly
C: Back nut

Tools

- A: Scouring pad
- B: Ruler
- C: M3 Hex key
- D: Knife
- E: File
- F: Spanner 32mm
- G: Spanner 7mm
- H: Torque wrench 36mm
- I: Screwdriver (small)
- J: Screwdriver (med)
- K: Sealant Pactan
- L: Roll form Tap
- M: Insulating tape
- N: Hacksaw fine tooth
- O: Multigrip pliers (teeth removed)
- P: Silicone grease (not shown)



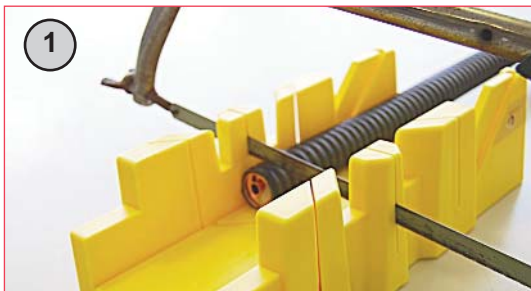
Tools and materials

Note 1:

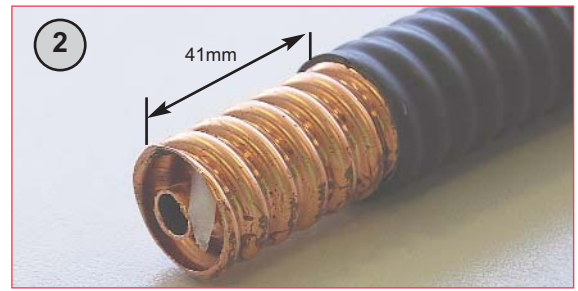
Each connector termination adds an additional 48mm (approx) to the total length of the cable.

Note 2:

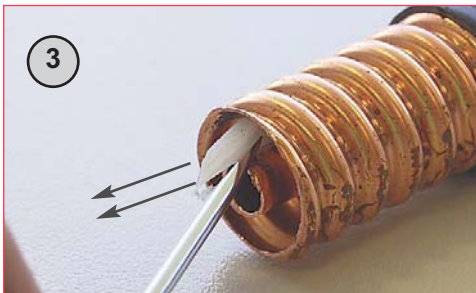
Connectors supplied are normally gas pass.



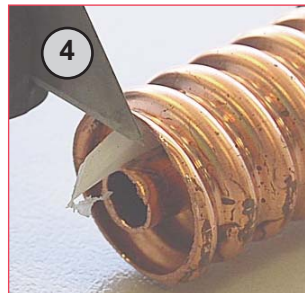
1 Straighten cable and ensure that it is cut square using a mitre box or similar aid.



2 Trim jacket 41mm (1 5/8") carefully, using a knife, ensure copper outer is not scored or cut.



3 Pull out approximately 15 mm (5/8") of helix.

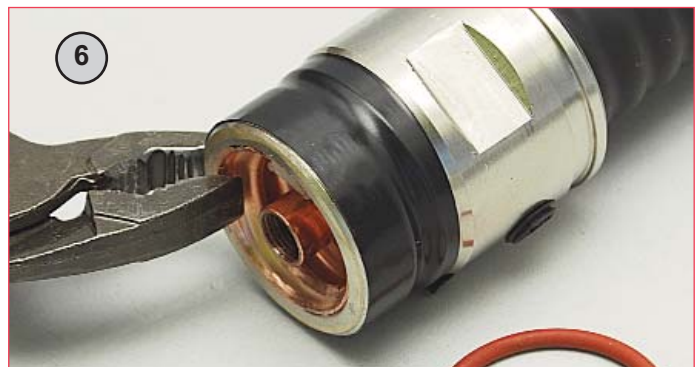


JB Series cables only. Remove "Polyment" using white spirits, cloth and scouring pad until copper is clean.

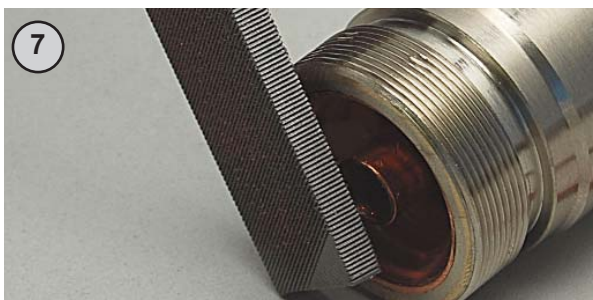
Trim and discard 5mm (3/16") off the helix then push back into original position. Make sure copper inner & outer edges are smooth and free of burrs and copper surfaces are clean, using the file and scouring pad. Ensure all debris is removed.



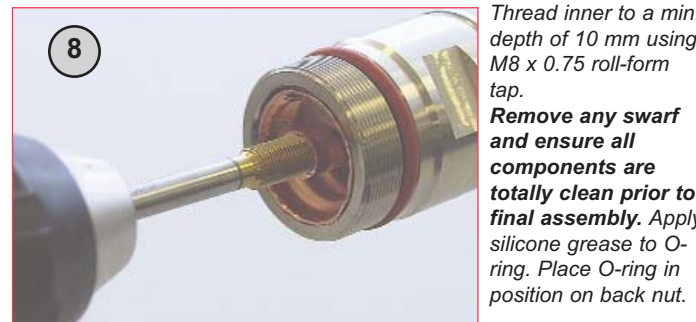
5 Screw back nut clockwise onto the cable.



6 Remove the O-ring and ensure thread of the connector is protected by overwrapping with insulating tape. Flare outer conductor of the cable to the back nut using the soft jaw pliers.



7 Remove PVC tape. File outer conductor flat with the outside of the connector mating surface. Remove any debris from the back nut.

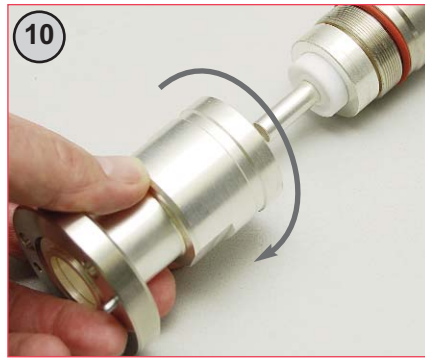


8 Thread inner to a min. depth of 10 mm using M8 x 0.75 roll-form tap. Remove any swarf and ensure all components are totally clean prior to final assembly. Apply silicone grease to O-ring. Place O-ring in position on back nut.

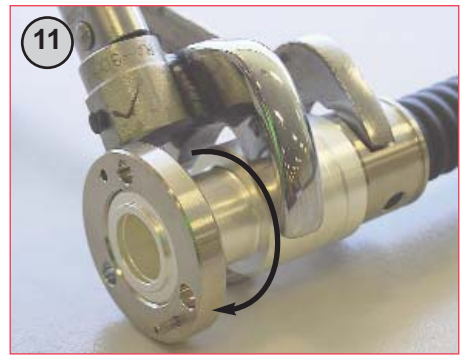
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9 Insert inner cable assembly into back nut and finger tighten using M3 hex key.



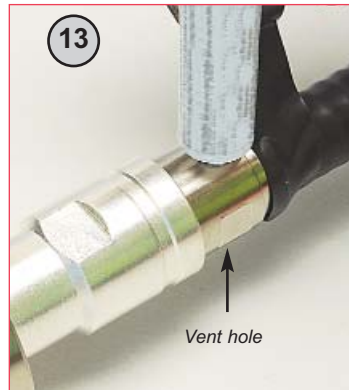
10 Screw connector body clockwise onto back nut, keeping the cable and back nut stationary.



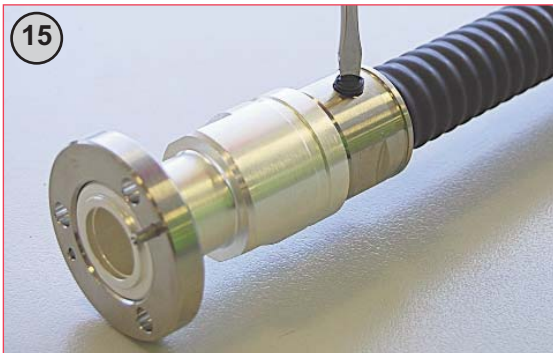
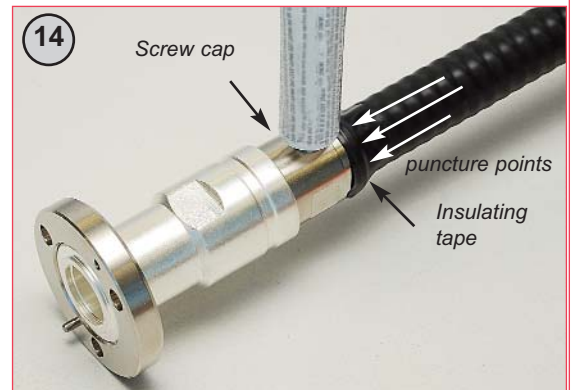
11 Tighten the connector body onto the back nut using a 36mm torque wrench whilst holding the back nut still with a 32 mm spanner. Torque to 50 Nm (37 lb ft).



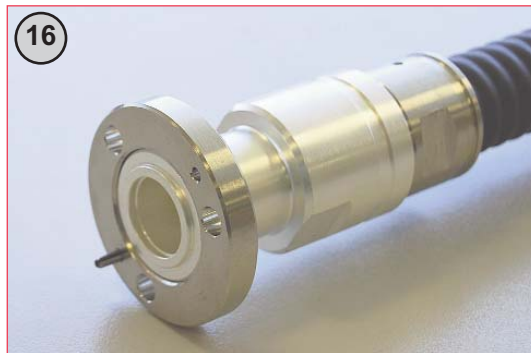
12 Re-tighten inner assembly to a torque of 2.6 Nm.



13 Remove screw cap on back nut. Finely spray back nut/cable with water to accelerate curing. Wrap insulating tape around the rear of the back nut/cable. Inject sealing compound (approx. 8cc) until the sealant appears at the vent hole on the opposite side of the back nut. Place finger over the vent hole to stop the flow of sealant. Puncture the tape in 4 places as shown and then continue injecting compound until it appears at the puncture points. Remove sealant tube cartridge and replace screw. Do not pressurise for 24 hrs to allow compound to harden.



15 Replace screw and clean any excess sealing compound.



16 Completed connector.

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