

Instruction Sheet

No. 412399
Rev. B

CONNECTORS — SELF FLARE FOR FLC 12-50 CABLE

Read instructions carefully before attempting assembly

TOOLS REQUIRED

- | | |
|--|------------------------|
| 1 Fine Toothed Hacksaw | 1 Hammer |
| 1 Tubing Cutter*
(Rigid No. 20 or Equivalent) | 1 Long Nose Pliers |
| 1 Rule, 6" | 1 Flat File |
| 1 Knife | 1 Heat Gun or Torch |
| | 2 Open End Wrench 7/8" |

*Optional

PREPARATION

1. Disassemble the connector and identify all parts as shown in Figure 1. Gasket grease (515121) not shown.

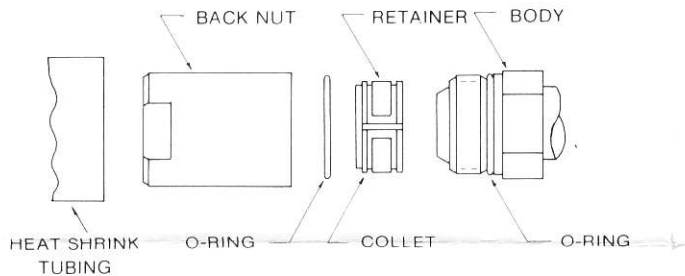


FIGURE NO. 1

2. Place the cable so that it is easily accessible, and then with a hacksaw, square off the end at one of the annular corrugation grooves.
3. Score the cable jacket $1\frac{3}{8}$ " from the squared off cable end with a knife or optional tubing cutter. Using a knife, cut a parallel slit down the jacket, peel it back and discard. Do not cut through to the copper outer conductor. Refer to Figure 2.

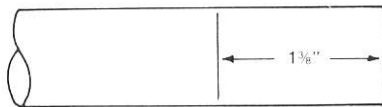


FIGURE NO. 2

4. Slide the heat shrinkable boot, followed by the connector backnut onto the cable and out of the way.
5. Apply a light film of grease to the cable O-ring and slip it onto the cable outer conductor. Place it one groove from the trimmed jacket as shown in Figure 3.

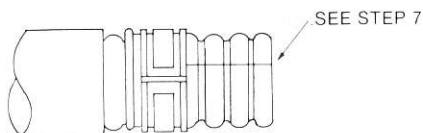


FIGURE NO. 3

6. Fit the spring loaded collet over the cable outer conductor. Position it securely over the fifth ridge from the end, leaving approximately $\frac{3}{4}$ " between the collet and cable end. Refer to Figure 3.
7. With the tip of a knife, cut a parallel slit down the side of the outer conductor from the cable end to the secured collet.
8. Carefully pry a portion of the outer conductor $\frac{1}{4}$ " away from the foam dielectric. Using long nose pliers, fully grasp the pryed section of outer conductor between the collet and the trimmed end. With a twisting motion, carefully peel away the outer conductor from the foam. (Similar to the key method when opening a sardine can.) This method creates a flare on the outer conductor that will mate with the body, providing a good mechanical and electrical connection. Refer to Figure 4.

NOTE: It is acceptable for the resulting flare to have a slightly ragged edge.

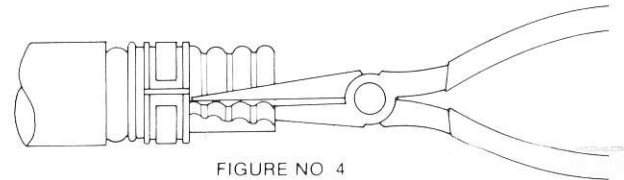


FIGURE NO. 4

9. Using the outer conductor as a guide, make a circular cut around the cable into the foam. Be careful not to cut completely through the foam and damage the center conductor. Remove the foam from around the center conductor by making four knife cuts parallel to and as close to the center conductor as possible. The foam is peeled away as the knife is tapped down to the flared outer conductor.
10. Cut and round off the end of the center conductor with a file to the $\frac{3}{4}$ " dimension shown in Figure 5. With a knife, carefully scrape away all remaining foam from the center conductor. Do not allow metal particles to enter the cable.

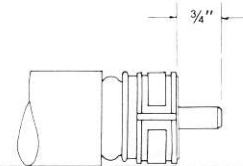


FIGURE NO. 5

11. Apply a light film of grease to the body O-ring and slip it into position on the connector body as shown in Figure 1. Position the connector onto the cable insuring that the body fits securely into the flared outer conductor. Hold the body stationary and thread the backnut onto the body. Tighten with wrenches to 15/20 ft. lbs.
12. Use a heat gun or apply a light flame over the heat shrink boot until it forms a seal over the cable and connector backnut.