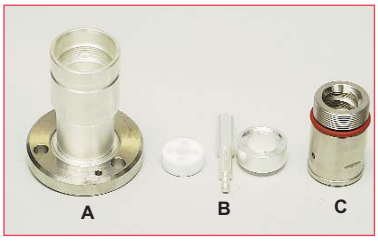
HELIFLEX® Lite Connector Installation Instructions
For HCA58 cable

Connector: 78EIA-HCA58-009
P/N: 15412840

7/8" EIA Flange connector shown

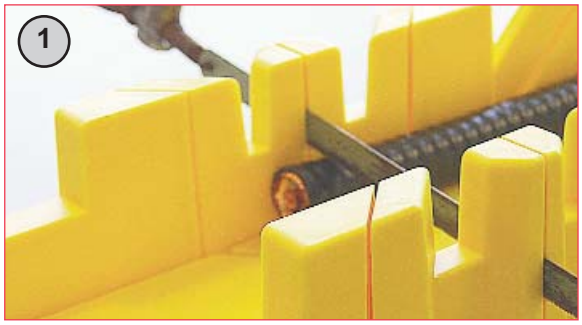


A: Connector body *B: Inner assembly* *C: Back nut*

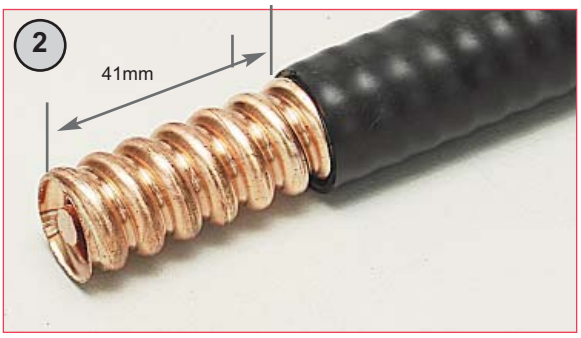
Tools
A: Scouring pad
B: Ruler
C: Hex key M3
D: Knife
E: File
F:Screwdriver Flat (medium size)
G: Multigrip pliers, (teeth removed)
H: Sealant Pactan
I: Hacksaw fine tooth
J: Insulating tape
K: 3mm / 1/8" drill bit
L: M4 x 0.7 roll-form tap
M: Spanner 26mm
N: Torque wrench 30mm
O: Screwdriver Flat (small size)
P: Silicone grease (not shown)

Tools and materials

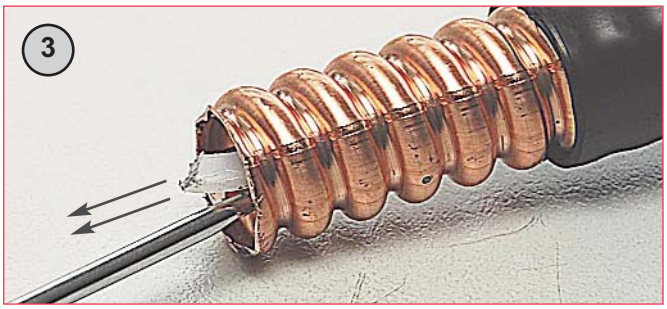
Note 1:
Each connector termination adds an additional 48mm (approx) to the total length of the cable.
Note 2:
Connectors supplied are normally gas pass



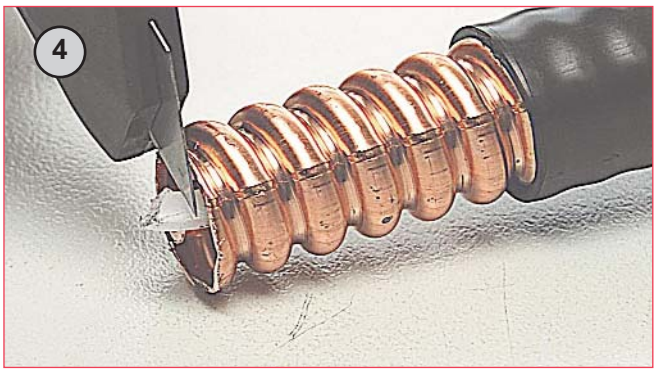
*Straighten cable and ensure that it is marked and **cut square** using a mitre box or similar aid.*



Trim jacket 41mm (1-5/8") carefully, using a knife or hacksaw, ensure copper outer is not scored or cut.
JB Series cables only.
Remove "Polyment" using white spirits, cloth and scouring pad until copper is clean.

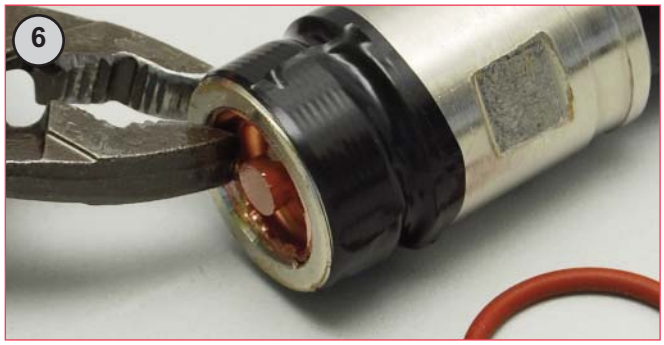


Pull out approximately 5mm (3/16") of helix.

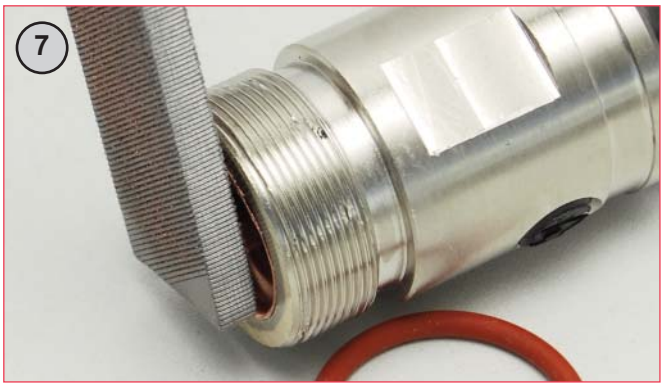


*Trim and discard 5mm (3/16") off the helix then push back into original position. **Make sure copper inner & outer edges are smooth and free of burrs and copper surfaces are clean, using the file and scouring pad. Ensure all debris is removed.***

Screw connector back nut clockwise onto the cable.



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.



Remove PVC tape. File outer conductor flat with the outside of the connector mating surface. Remove any debris from the back nut. Apply silicone grease to O-ring. Place O-ring in position on back nut.

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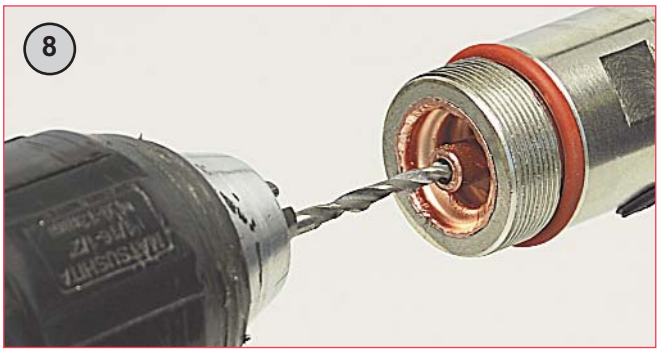
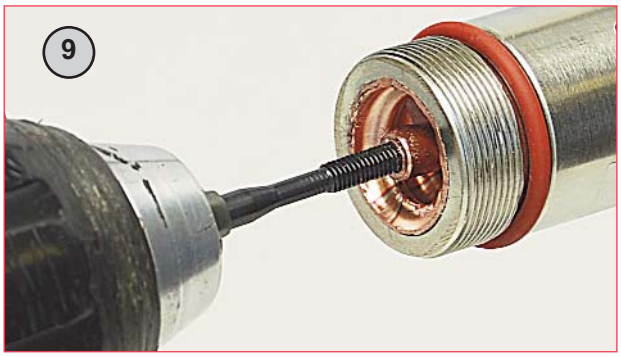
Any liability or responsibility for the result of improper or unsafe installation practice is disclaimed. Always make sure to use appropriate personal protection.

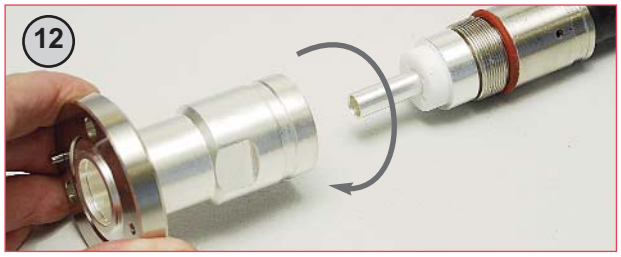


Drill inner 3.6 mm (#27).

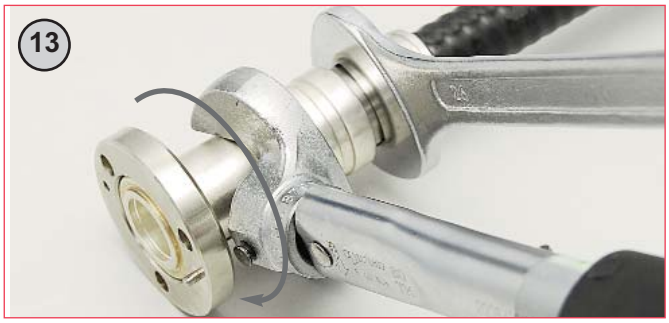


Thread inner to a min. depth of 10 mm (3/8") using an M4 x 0.7 roll-form tap taking care to ensure hole is centered on the inner. ***Remove any swarf and ensure all components are totally clean prior to final assembly.***

Screw inner cable assembly clockwise onto back nut and finger tighten using M3 hex key

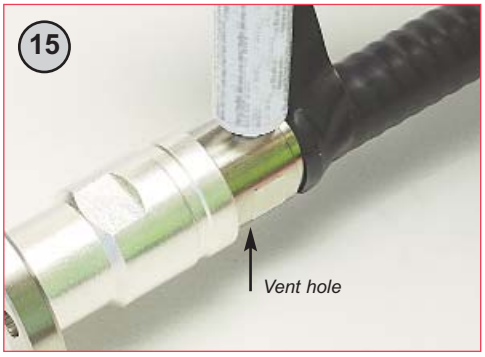


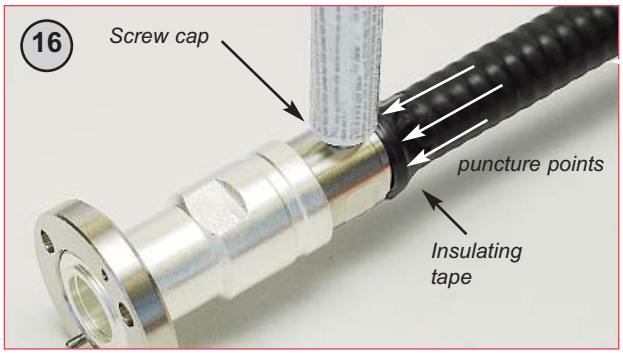
Screw connector body clockwise onto back nut, keeping connector back nut stationary.



Tighten the connector body on to the back nut using a 30mm torque wrench whilst holding the back nut still with a 26mm spanner.Torque to 50 Nm (37 lb ft).

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





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 5cc) until the sealant appears at the vent hole on the opposite side of the back nut. Place finger over vent hole to stop further flow of sealant. Puncture the tape in 4 places as shown and continue injecting compound until it appears at the puncture points. Remove sealant tube cartridge and replace screws. ***Do not pressurise for 24 hrs to allow compound to harden.***

Completed connector.

Installation materials:	
Sealing Compound 20cc P/N 15800440	*Sealing compound 310cc P/N 15800441*

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