HELIFLEX® Lite Connector Installation Instructions
For HCA400 cable

Connector: 318EIA-HCA400-009
P/N: 15455250

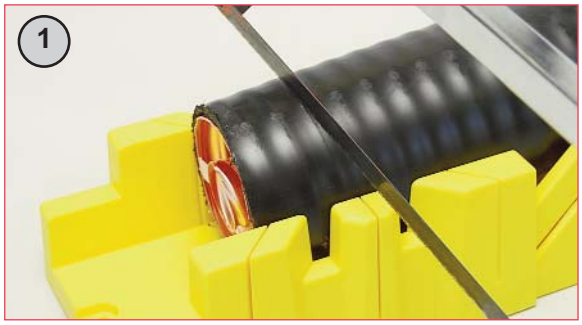
3 1/8" EIA Flange connector shown

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

Tools
A: Scouring pad
B: Ruler
C: Hex keys 5mm & 8mm
D: Knife
E: File
F:Screwdriver Flat (medium size)
G: Soft nylon hammer
H: Multigrip pliers (teeth removed)
I: Sealant (Pactan)
J: Hacksaw fine tooth
K: Insulating tape
L: Tin snips
M: 3mm / 1/8" drill bit
N: Philips Screwdriver
Silicone grease (not shown)

Tools and materials

Note 1:
Each connector termination adds an additional 100mm (approx) to the total length of the cable.
Note 2:
Connectors supplied are normally gas stop; to enable gas pass refer to Step 14.



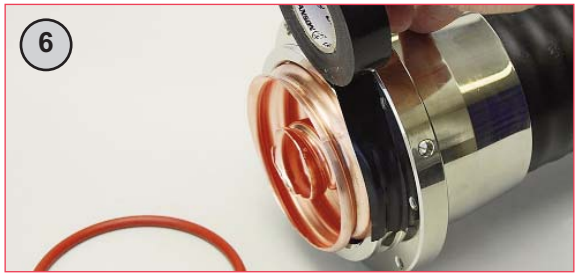
*Straighten cable and ensure that it is marked and **cut square** using a Mitre box or similar aid.*

Trim jacket 57mm (2-1/4") carefully, using a knife or hacksaw, ensure copper outer is not scored or cut.
NB: A piece of paper makes a handy guide.
JB Series cables only.
Remove "Polyment" using white spirits, cloth and scouring pad until copper is clean.

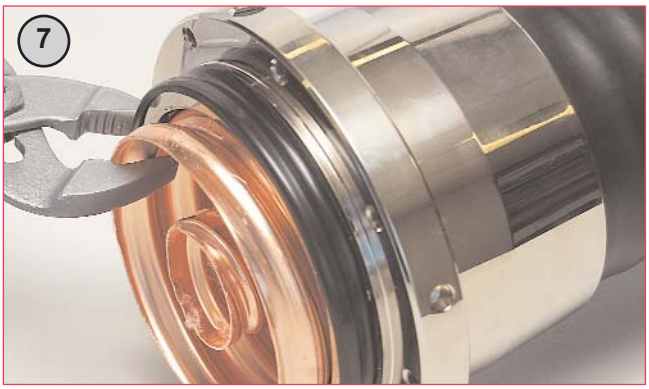
Pull out approximately 30mm (1 1/4") of helix.

*Trim and discard 20mm (3/4") 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.

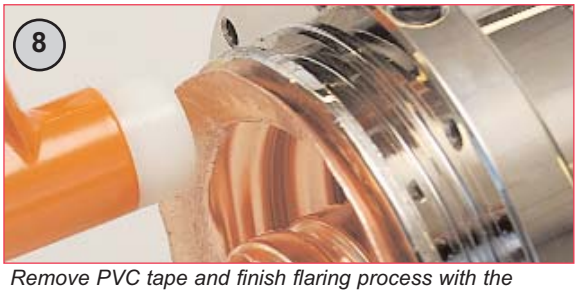
Screw connector back nut clockwise onto the cable.



Remove O-ring and protect groove with PVC tape.



Flare outer conductor with soft jaw pliers. Work slowly around the perimeter flaring a small amount each time. Do not split the copper (refer Step 15 for remedial process).



Remove PVC tape and finish flaring process with the nylon hammer taking extreme care not to split or break the copper outer conductor (refer Step 15 for remedial process).

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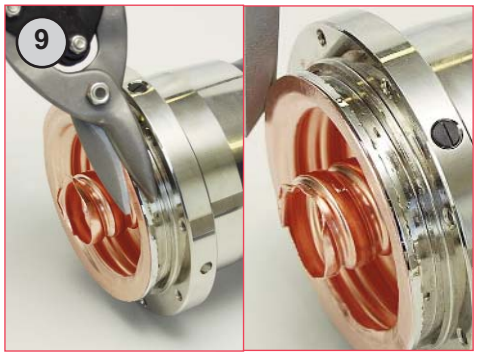
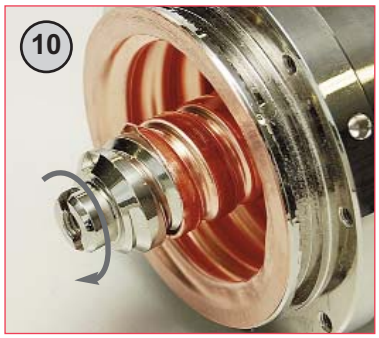
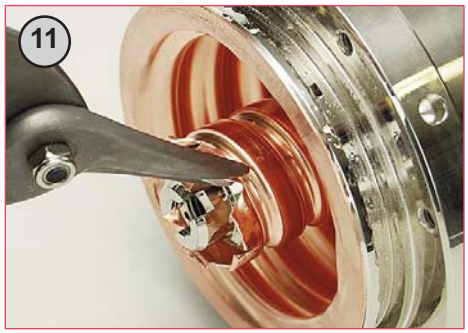


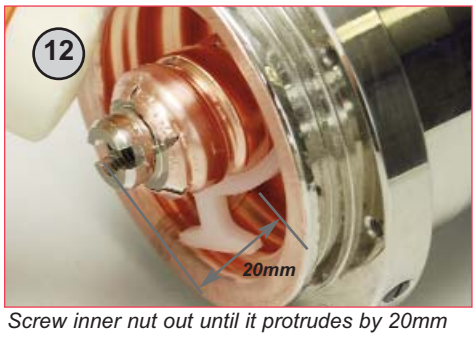
Snip excess to make flush, file, deburr and clean. ***Make sure all metal debris is removed.***



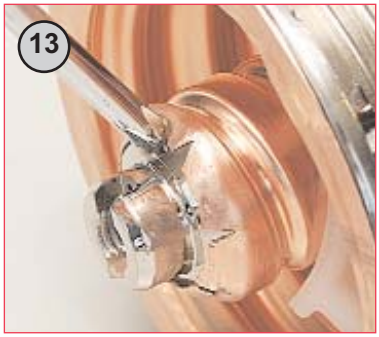
Screw inner nut clockwise into cable until it is approx. 10mm (3/8”) inside the inner conductor.



Snip inner with 3 mm (1/8”) long x 5mm (3/16”) wide V cuts, approx every 10mm (3/8”).

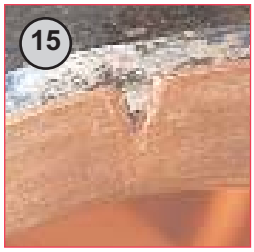


Screw inner nut out until it protrudes by 20mm (3/4”) beyond the end of the ***outer*** *conductor. Hammer copper to form over inner cable nut. Clean assembly.*



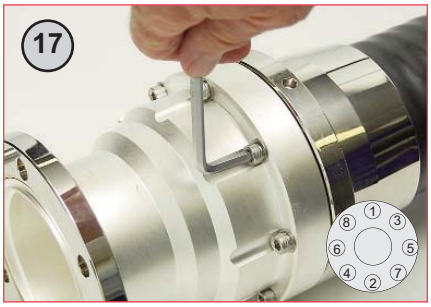
Indent cable inner conductor to prevent connector inner nut from rotating.

Gas Pass process: *Using a 3mm 1/8” drill bit, drill a hole through the PTFE spacer midway between the inner assembly and the connector body.*



In the unlikely event that the outer conductor has split or torn, repair by adding Pactan sealant as shown allowing 45 min to set before fitting the connector body to the back nut.

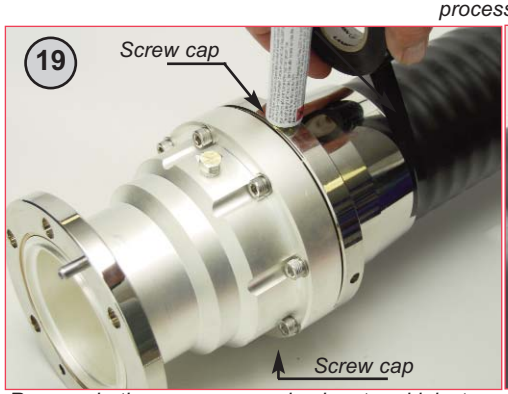
Lubricate and refit O-ring with silicone grease. Fit connector body.

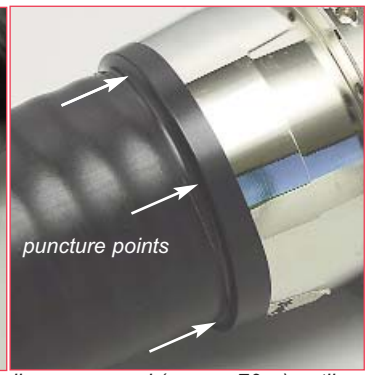


Finger tighten all the connector body screws clockwise following the sequence shown (inset) torque to 8Nm. Repeat tightening process

Tighten inner screw (clockwise) with 8mm hex key. Torque to 30Nm approx. Note: Copper washer (on the inner screw) is single use only. In case of repeated assembly replace used copper washer with the spare provided.

Completed connector.





Remove both screw caps on back nut and inject sealing compound (approx 70cc) until the sealant appears at the opposite side of the back nut. Replace cap to stop further flow of sealant. Wrap insulating tape around the rear of the back nut/cable. 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 screws. ***Do not pressurise for 24 hrs to allow compound to harden.***

Installation materials:

Sealing Compound 20cc P/N 15800440

Sealing compound 310cc P/N 15800441

Gas inlet adaptor 1/8” NPT for 3/8” OD tube. P/N 15811691