Instruction Sheet

FLC78-50J FLEXWELL Connector Assembly using Coaxial Cable Prep Tool P/N 921199

Instruction Sheet 412691 replaces Instruction Sheet 412447 (included with the connector) when using coaxial cable trim tool P/N 921199.

Tools Required

1. Hacksaw, fine toothed	4. Open End Wrenches:
2. Utility Knife	1-3/8" for 7-16 DIN,
3. Rule, 6"	1-1/8" for N connectors.
	5. Heat Gun or Torch

Prep Tool Description

FLEXWELL FLC78-50J Prep Tool P/N 921199 contains two preset cutting blades designed to efficiently trim the cable jacket, outer conductor and foam dielectric.

When using the Prep Tool, do not add any additional closure force beyond the preset spring tension.

The prep tool blades are offset and may be reversed for a fresh cutting edge. Spare blades are located in the blade storage area contained within the tool handle. Replacement blades may be ordered from the factory. Reference the tool number and blade description when ordering.

Note: For FLC78-50 JFRT radiating cable preparation, use Instruction Sheet No. 412447.

> **Warning**
> This tool is a spring loaded device containing exposed cutting blades. Use tool only as instructed. Keep fingers clear of cutting surfaces at all times.
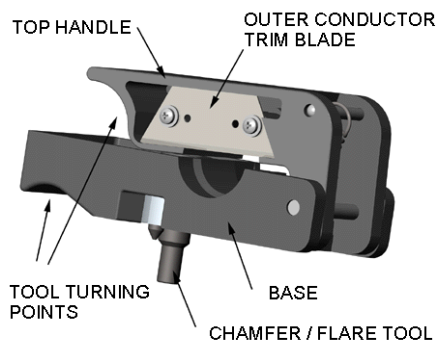

TOP HANDLE — OUTER CONDUCTOR TRIM BLADE — TOOL TURNING POINTS — BASE — CHAMFER / FLARE TOOL

Figure 1.
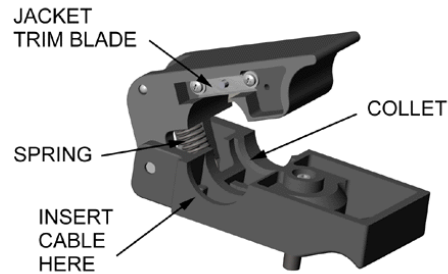

JACKET TRIM BLADE — COLLET — SPRING — INSERT CABLE HERE

Figure 2.

Cable Preparation

1. Cut the cable end even with a fine tooth hacksaw.

2. Trim and remove the cable jacket with a knife to the 3/4 inch dimension shown in Figure 3.
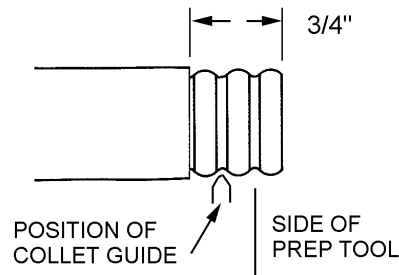

3/4" — POSITION OF COLLET GUIDE — SIDE OF PREP TOOL

Figure 3.

3. Open the spring loaded Prep Tool and insert the cable into the tool from the jacket blade side . Position the first cable corrugation nearest to the trimmed jacket over the collet guide as shown in Figure 3. Two corrugations will protrude past the side of the Prep Tool.

4. Slowly rotate the Prep Tool clockwise around the cable (in the direction of the arrow). Be sure the cable is seated over the collet guide while turning the Prep Tool.
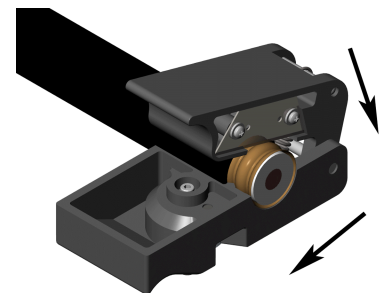
5. Remove the cable from the Prep Tool.

Figure 4.

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6. With a knife, remove the trimmed jacket from the cable. See Figure 5.

PREP TOOL JACKET CUT

PREP TOOL OUTER CONDUCTOR AND CENTER CONDUCTOR CUT
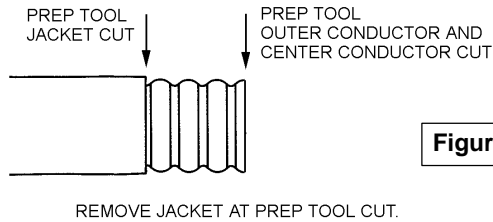
Figure 5.

REMOVE JACKET AT PREP TOOL CUT.

7. Prepare the end of the cable with the combination chamfer and flare station located on the base of the Prep Tool. Insert the the cable guide into the center conductor. Press down while turning the Prep Tool. See Figure 6.
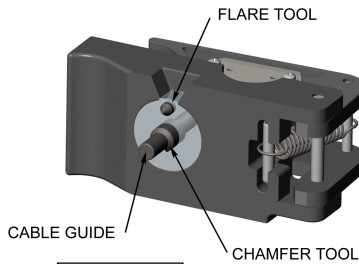
FLARE TOOL

CABLE GUIDE

CHAMFER TOOL

Figure 6.

Connector Assembly

8. Disassemble the connector and identify all parts as shown in Figure 7. A tube of gasket grease and a heat shrink boot is not shown.
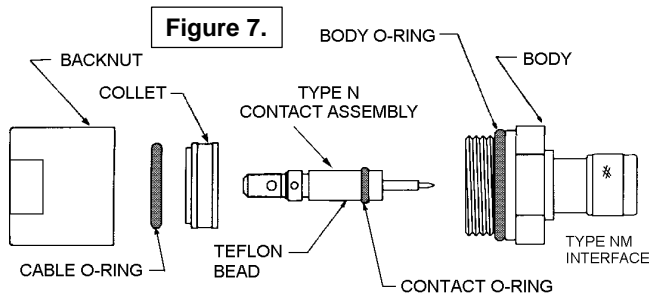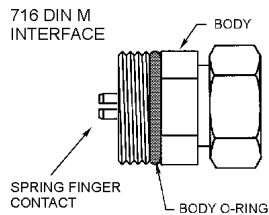
Figure 7.

BACKNUT

COLLET

BODY O-RING

BODY

TYPE N CONTACT ASSEMBLY

CABLE O-RING

TEFLON BEAD

CONTACT O-RING

TYPE NM INTERFACE

9. Slide the heat shrink boot and connector backnut onto the cable and temporarily out of the way of connector assembly. See Figure 8.

716 DIN M INTERFACE

BODY

SPRING FINGER CONTACT

BODY O-RING

10. Place the cable O-ring (smaller of the two O-rings) onto the cable outer conductor and position it in the corrugation groove nearest to the trimmed jacket as shown in Figure 8.
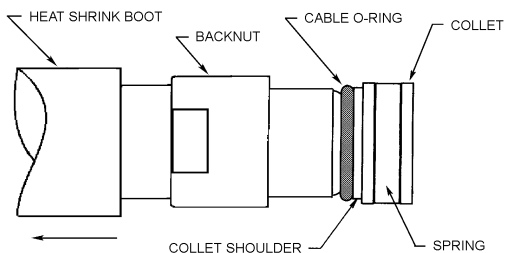
HEAT SHRINK BOOT

BACKNUT

CABLE O-RING

COLLET

COLLET SHOULDER

SPRING

Figure 8.

11. Assemble the two collet halves onto the cable outer conductor with the stepped side facing the trimmed jacket. Position the collet over the corrugation next to the cable O-ring. Secure with the collet spring. See Figure 8.

12. *For Self Tapping Center Contact Connectors:* Thread the self tapping center contact pin into the center conductor. Tighten until the contact bottoms against the flush cut center conductor. Use the contact turn bar tool for ease of assembly. See Figure 9.

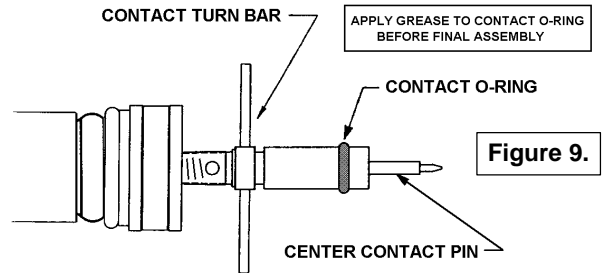√ Apply a light film of gasket grease to the contact O-ring. See Figure 9.

CONTACT TURN BAR

APPLY GREASE TO CONTACT O-RING BEFORE FINAL ASSEMBLY

CONTACT O-RING

Figure 9.

CENTER CONTACT PIN

13. Slide the O-ring over the connector body threads and position it as shown in Figure 7. Apply a light film of gasket grease to the body O-ring and cable O-ring.

14. Carefully thread the connector body and backnut together. Tighten with wrenches to 20 lbf • ft (27 N • m).

15. Slide the heat shrink boot into position over the cable and connector backnut. Use a heat gun or apply a light flame to the boot until it shrinks smoothly forming a weatherproof seal. This completes installation.

COMPLETED INSTALATION

INCHES
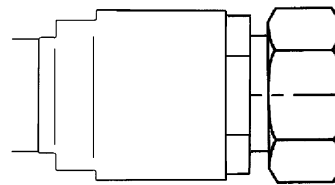
3/4" Dimension Step 2, Figure 3

¼ ½ ¾
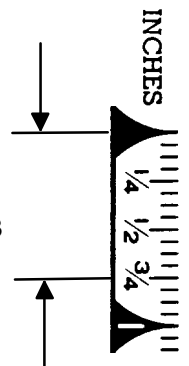
Connector Interface Torque Values (nominal):
N Male coupling force is 25 in-lb (3 N • m)
7/16 DIN Male coupling force is 18 lbf • ft (25 N • m)

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