

Installation Instructions

Mounting of connector **NF-RE60** to **RADIAFLEX®** waveguide RE60

1000009531-02 (M36317a)



These instructions were written for qualified and experienced personnel. Please read them carefully before starting work. Any liability or responsibility for the results of improper or unsafe installation practices is disclaimed!

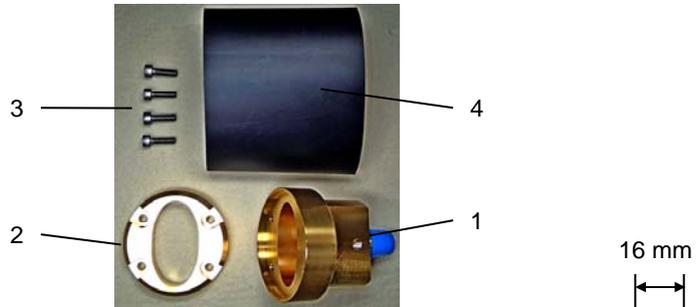
Tools and Materials

Tape measure (metric system), fine-toothed hacksaw, knife, solid small tin shears, ball peen hammer, 5 mm allen wrench, cloth, cleaner, self-adhesive tape, emery paper (approx. 80 grain), hot air source (alternatively propane/butane gas torch)

Connector Disassembly

Do not touch the inner part of the connector body!

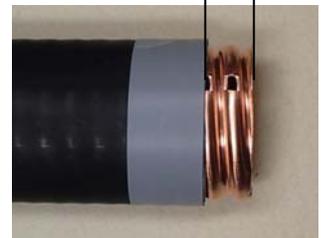
- 1 Connector body
- 2 Fitting disc
- 3 Screw set
- 4 Heat shrink sleeve with adhesive coating



Waveguide Trimming

Straighten and cut end of waveguide perpendicular. Tilt the waveguide downwards, to prevent swarf from falling into centre. Remove **16 mm** of the jacket with the knife; a helpful positioning mark can be made with adhesive tape.

Slide the fitting disc (2) onto the waveguide until it bottoms against trimmed jacket. The bigger diameter of the disc must be placed towards the waveguide jacket.



Flaring

Make longitudinal cuts in the waveguide down to the fitting disc with small tin shears. Space the cuts approx. 3 - 5 mm apart, with the narrower spacing being on the small radii of the ellipse. With a ball peen hammer, flare the waveguide over the fitting disc. When completed, the flare should be smooth and flat and must not protrude over the outer diameter of the fitting disc. If necessary, snip protruding tabs.



Final Assembly

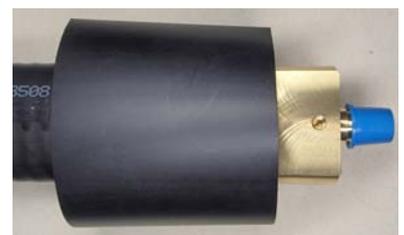
Insert the four screws into the fitting discs thru holes. Attach the connector body and tighten the screws securely, alternating crosswise to ensure the body sits even to the fitting disc.

Fitting of Heat-Shrinking Sleeve

Roughen shrinking area of waveguide jacket with emery paper. Carefully clean connector and jacket with cleaner and pre-heat to approx. 50° C (be careful with the jacket).

Position the shrinking sleeve (4) over the circular part of the connector.

Fix and shrink, **while heat source is kept moving circular** (max. shrinking temperature 130°C).



Start with shrinking at connector body and move to middle and end part of the sleeve. Shrinking is completed when adhesive coating emerges on the insides at both ends.

Don't touch or apply any mechanical stress before complete assembly has cooled!

Please note:

When using a gas torch, the flame should not be too small; work with a low yellow flame!



Earthing

The M6 thread in the connector body is foreseen for earthing purposes. Use a suitable screw and cable lug.



部件名称/Component Name	有毒有害物质或元素/Toxic or Hazardous Substances and Elements					
	铅/Pb	汞/Hg	镉/Cd	六价铬/Cr 6+	多溴联苯/PBB	多溴二苯醚/PBDE
金属零件/metal parts	X	○	○	○	○	○

产品在正常使用条件下, 其环保使用期限才在此标识有效期内。 / The environmental protection use period is valid if the product is used as intended.