



1 5/8" EIA Flange connector shown



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

**Tools**

- A: Scouring pad
  - B: Ruler
  - C: Hex keys 4 & 5mm
  - D: Knife
  - E: File
  - F: Screwdriver (medium size)
  - G: Soft nylon hammer
  - H: Multigrip pliers (teeth removed)
  - I: Sealant Pactan
  - J: Hacksaw fine tooth
  - K: Insulating tape
- Silicone grease (not shown)



Tools and materials

**Note 1:**

Each connector termination adds an additional 73mm (approx) to the total length of the cable.

**Note 2:**

Connectors supplied are normally gas stop, to enable gas pass refer to Step 16.



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

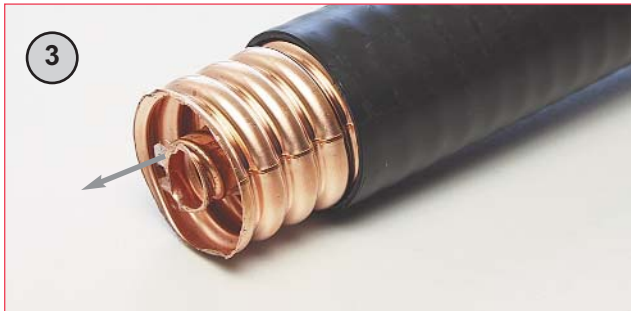


Trim jacket and outer 37mm (1 7/16") carefully, using a knife or hacksaw, ensure copper outer is not scored or cut.

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 15mm (5/8") of helix.



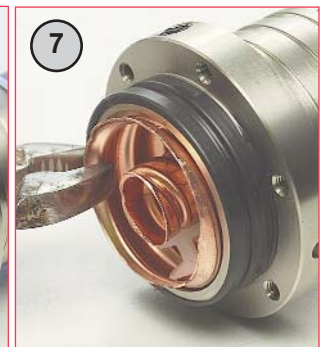
Trim and discard 5mm (3/16") off the helix then push back into original position. **Make sure copper inner & outer edges are smooth and free of burrs and copper surfaces are clean, using the file and scouring pad. Ensure all debris is removed.**



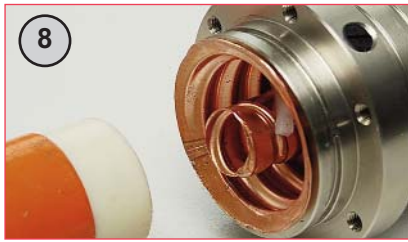
Screw connector back nut clockwise onto the cable.



Remove O ring and protect groove with PVC tape.



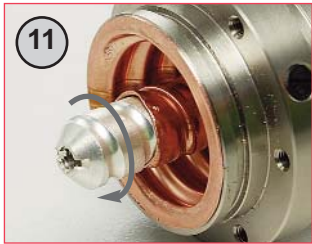
Flare outer conductor with soft jaw pliers. Work slowly around the perimeter flaring a small amount each time. Do not split the copper (refer Step 14 & 15 for remedial process).



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 14 & 15 for remedial process).



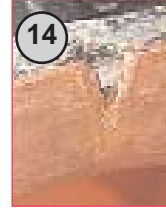
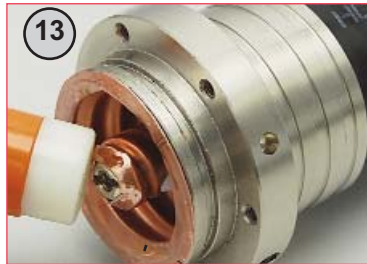
Snip excess copper to make flush, file, deburr and clean. **Make sure all metal debris is removed.**



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



Snip inner with 3 mm (1/8") long x 2 mm (3/32") wide V cuts, approx every 10 mm. Screw inner nut out until it protrudes by 4 mm (3/16") beyond the end of the **inner** conductor. Hammer copper to form over inner cable nut. Finished measured dimension from outer flared face to tip of inner 5.9 ± 0.2 mm. Clean assembly.



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.



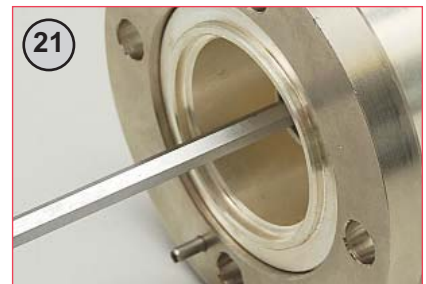
**Gas Pass process:**  
Using a 3mm 1/8" drill bit, drill a hole through the PTFE spacer midway between the inner assembly and the connector body.



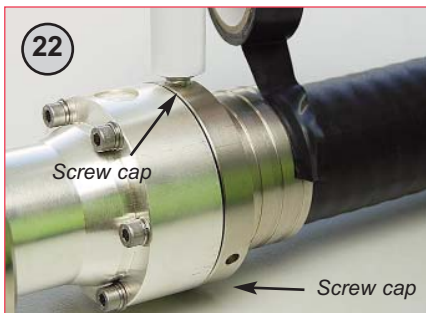
Place copper washer on shank of socket cap screw. Add small lubricated O-ring. Washer must sit between screw head and O-ring. Lubricate medium O-ring. Place in Teflon groove of inner assembly. Position inner assembly against back nut. Tighten screw (anticlockwise) with 5 mm hex key.



Fit connector body and finger tighten the connector body screws following the sequence shown (inset) torque to 5Nm. Repeat tightening process.



Tighten inner assembly to torque of 8Nm. Note: Copper washer (on the inner screw) is single use only. In case of repeated assembly replace used copper washer with the spare provided.



Remove both screw caps on back nut. Finely spray back nut/cable with water to accelerate curing. Inject sealing compound (approx 12cc) 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.**



Completed connector

These RFS fitting instructions are produced for qualified and experienced personnel. Any liability or responsibility for the result of improper or unsafe installation practice is disclaimed. Always make sure to use appropriate personal protection.