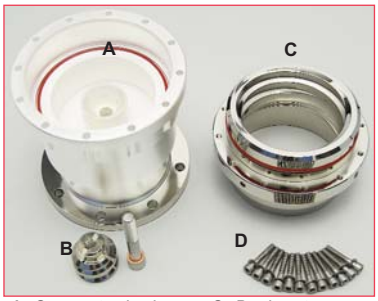
HELIFLEX® Lite Connector Installation Instructions
For HCA495 cable

Connector: 412IEC-HCA495-009
P/N: 15462050

4 1/2" IEC Flange connector shown

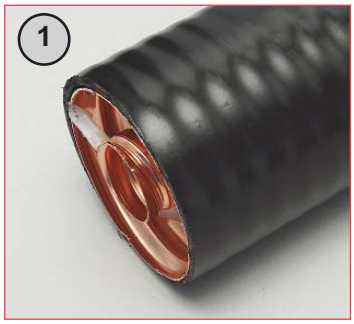


A: Connector body
B: Inner assembly
C: Back nut
D: Screws

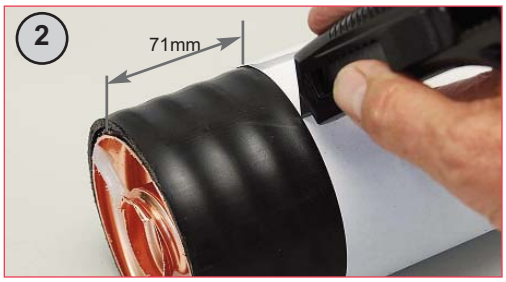
Tools
A: Scouring pad
B: Tape measure or ruler
C: Hex keys 5mm & 10mm
D: Knife
E: File
F: Screwdriver flat (medium size)
G: Soft nylon hammer
H: Multigrip pliers, smooth jaw
I: Sealant (Pactan)
J: Hacksaw fine tooth
K: Insulating tape
L: Tin snips
M: Philips screwdriver
Silicone grease (not shown)
3mm / 1/8" drill bit (not shown)

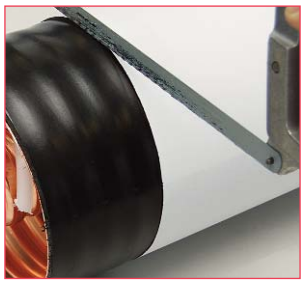
Tools and materials

Note 1:
Each connector termination adds an additional 108mm (approx) to the total length of the cable.
Note 2:
Connectors supplied are normally gas stop; to enable gas pass refer to Step 14.

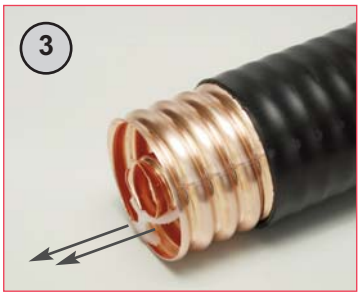


*Straighten cable and ensure that it is marked and **cut square**.*

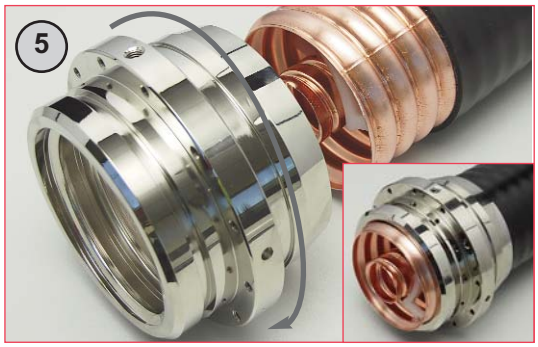




Trim jacket 71 mm (2-3/4"), ensure copper outer is not scored or cut. NB: A piece of paper makes a handy guide.
JB Series cables only.
Remove "Polyment" using white spirits, cloth and scouring pad until copper is clean.

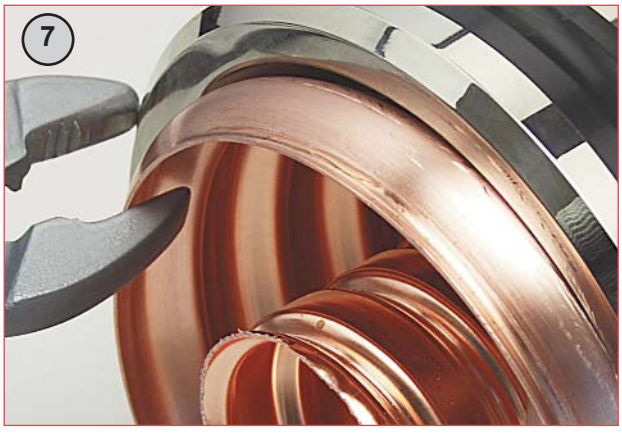


*Pull out approximately 50mm (2.0") of helix.Trim and discard 40mm (1 1/2") off the helix then push back into original position. **Make sure copper inner & outer edges are smooth and free of burrs and copper surfaces are clean, using the file and scouring pad. Ensure all debris is removed.***

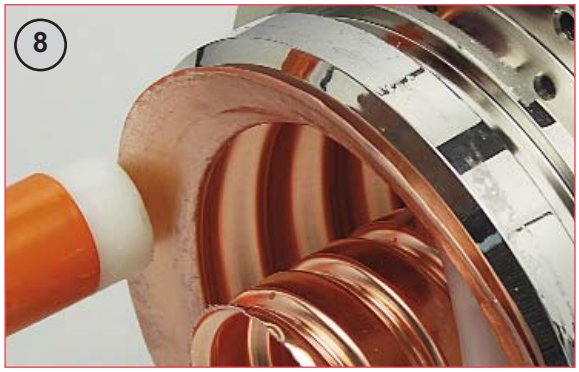


Screw connector back nut clockwise as far as possible onto the cable.

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).

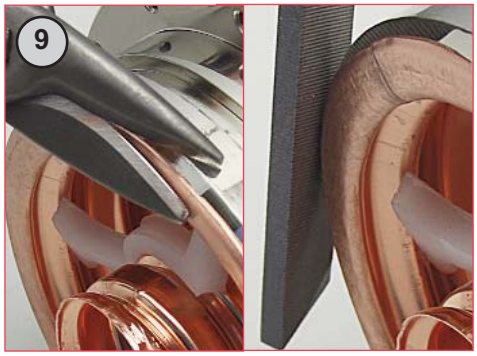


Remove PVC tape and finish flaring process with the nylon hammer taking extreme care not to split or break the copper outer conductor (refer Step 15 for remedial process).

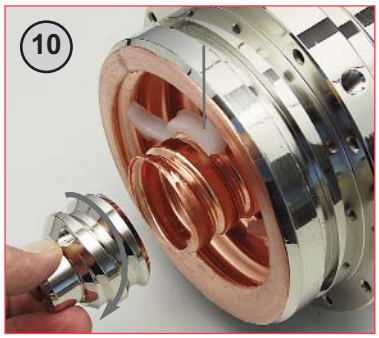
HELIFLEX® Lite Connector Installation Instructions
For HCA495 cable

Connector: 412IEC-HCA495-009

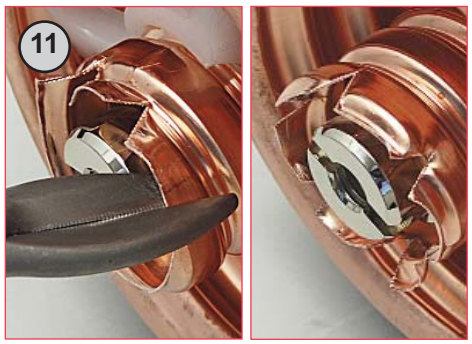
P/N: 15462050



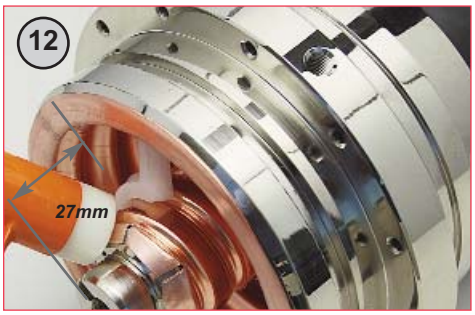
Snip excess to make flush, file, deburr and clean. ***Make sure all metal debris is removed.***



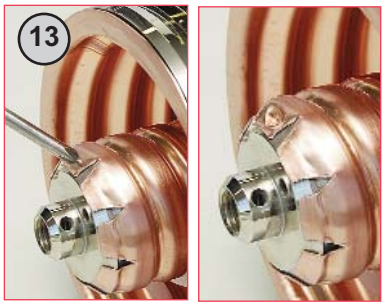
Screw inner cable piece clockwise deep into the cable inner conductor allowing enough room to enable snipping of the inner conductor.



Snip inner conductor with 4mm wide x 6mm deep V cut, approx every 15mm.

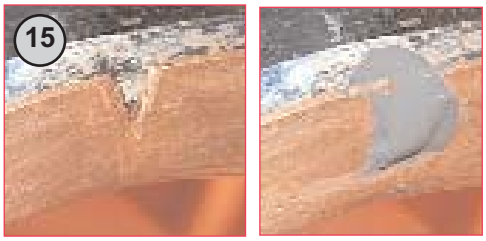


Screw inner cable piece out until it protrudes 27mm (1-1/16") from the outer conductor flared face. Hammer copper to form over inner cable piece. Clean assembly.



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.*



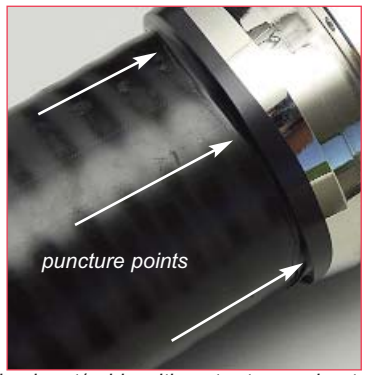
In the unlikely event that the outer conductor has split or torn, repair by adding Pactan sealant as shown allowing 45 min to set before fitting the connector body to the back nut.

Do not use dirty or damaged O-rings. Apply silicone grease to O-ring. Place O-ring in position on back nut. Fit connector body.

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

Tighten inner screw (clockwise) with 10mm hex key. Torque to 40Nm. 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. Finely spray back nut/cable with water to accelerate curing. Inject sealing compound (approx 120cc) 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 310cc P/N 15800441

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