



# RADIAFLEX® Coaxial Cable Connectors

## Installation Instruction

10000006074-04

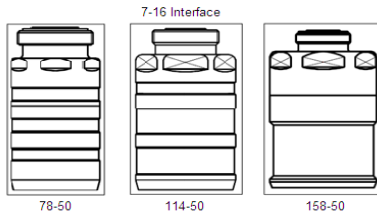
for RADIAFLEX® cables with smooth wall outer conductor 78-50, 114-50, 158-50

Valid for Connectors: NM-RA78-015, NF-RA78-016, 716M-RA78-015,

716F-RA78-016, NF-RA114-016, 716F-RA114-016, NF-RA158-016, 716F-RA158-016

This instruction is written for qualified and experienced personnel. Please study it carefully before starting any work. Any liability or responsibility for the results of improper or unsafe installation practices is disclaimed. Please respect valid environmental regulations for assembly and waste disposal. Always make sure to use appropriate personal protection!

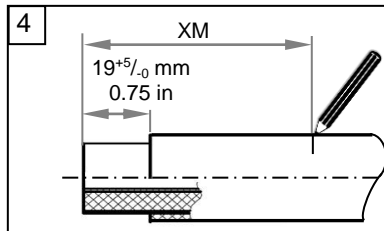
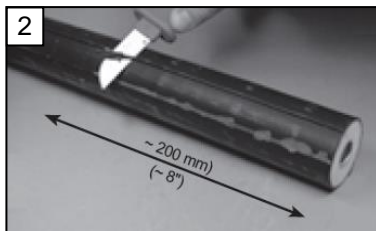
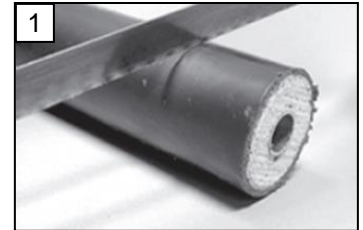
This instruction is based on the use of standard (manual) hand tools.



Samples of Connectors  
Instruction valid for all connectors mentioned above

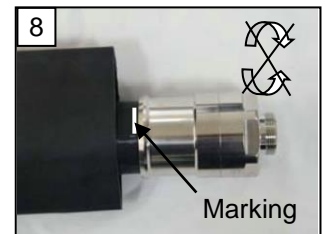
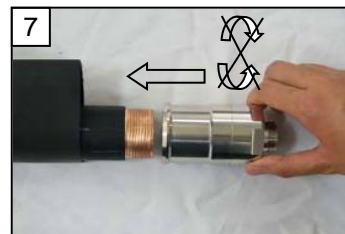
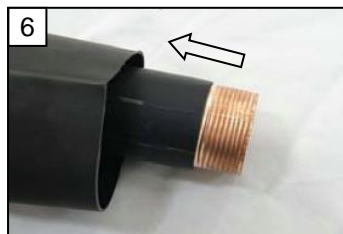


Recommended with straight line, smooth saw tooth



XM Marking dimension

cable size	dimension
78-50	48.0 mm (1.89 in)
114-50	57.0 mm (2.24 in)
158-50	67.0 mm (2.64 in)



**Tools:** Standard tools for manual installation.

Keep the cable end downwards in order to prevent particles from entering during the whole preparation.

- Cut the cleaned straightened cable in a right angle to cable axis with a fine toothed hacksaw.
- Remove the two guides in a length of 200mm – 220mm (7.9in – 8.7in).
- Remove all burrs inside and outside of the inner conductor and inside and outside of the outer conductor as well. Clean the dielectric, remove all particles very carefully and clean the inner conductor as well.
- Schematic of the RADIAFLEX®78-50, 114-50 and 158-50 cable, with smooth wall outer conductor, showing the following stripping dimensions.
- Cut and remove 19mm (0.75in) of cable jacket in accordance to the schematic.  
**Caution:** Do not cut into the outer conductor foil when cutting cable jacket! If the outer conductor foil is deformed, then smoothen it (e.g. with the wooden part of the knife). Do not lift up the copper foil; make sure overlapping foil is closed together. Clean the prepared cable end, remove any particles very carefully. It is recommended marking the connector end position onto cable jacket as shown in the schematic 4.
- Slide the heat shrink sleeve onto the clean cable, keep the sleeve clean.
- Push the connector onto prepared cable without any turning.
- Push connector onto cable until stop. Make sure that the connector is completely pushed onto cable – until the marking.  
**Caution:** Never turn the connector!
- Rub down the cable jacket in the cleaned area of intended installation with emery cloth (280 grain). For inspection reasons it is recommend to rough up approximately 20mm more than necessary. Remove emery cloth remnants. Clean the cable jacket and the connector in the shrinking zone e.g. with cable cleaner. Pre-heat the cable jacket to hand warm and the connector to approx. 60°C (140°F) using an efficient hot-air gun.
- Move the sleeve into correct position as shown. Shrink the sleeve with a circular motion, starting at the end at the connector body. Shrink this front part until the sleeve lies flat completely all around.
- The sleeve is shrunk further by continued application of the hot-air gun with an even circular motion proceeding in the direction of the cable. Keep the gun always moving to avoid overheating the sleeve or the cable - max. temperature 70°C (158°F) shrinking temperature is around 130°C (266°F). Continue shrinking until the sleeve lies flat all around and the hot solvent discharged (is visible) on both sides. Make sure that the connector will stay in place all the time.

