Splice Connector

for HELIAX® LDF4-50A LDF4-75A Coaxial Cable

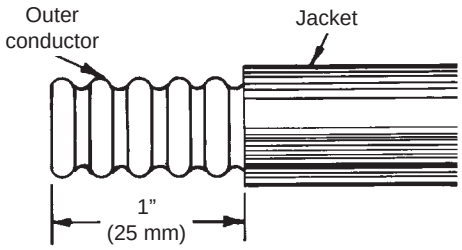
Description

This splice connector is designed to join two ends of coaxial cable by means of soldering the inner conductors together with an inner connector. Each outer conductor is slit to form tabs and flared by bending the tabs against the clamping nut. Two spacer halves are placed around the solder connection and the outer body threaded onto the long clamping nut and tightened.

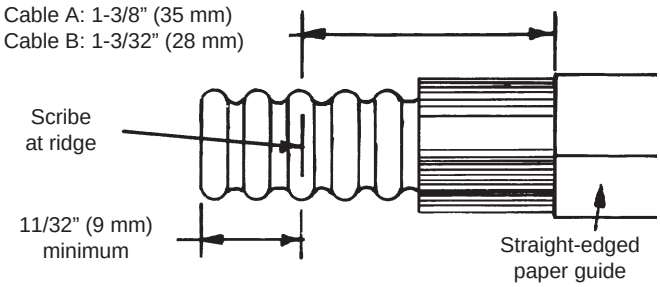
Tools and Materials Required for Assembly

Scale	Garnet cloth, 240 grit or finer
Knife	Fine-toothed hacksaw
Wire brush	Two wrenches: 1“
Flat file	Soldering iron, 150 W;
Metal snips	a resistance-type iron is
Damp cloth	recommended when soldering in
Spacing gauges (supplied)	low-temperature environments
Silicone grease (supplied)	Solder, 63/37 RMA flux core

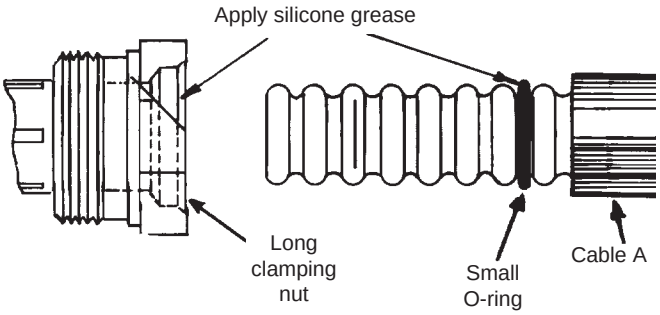
Read the Following Instructions Thoroughly Before Assembly



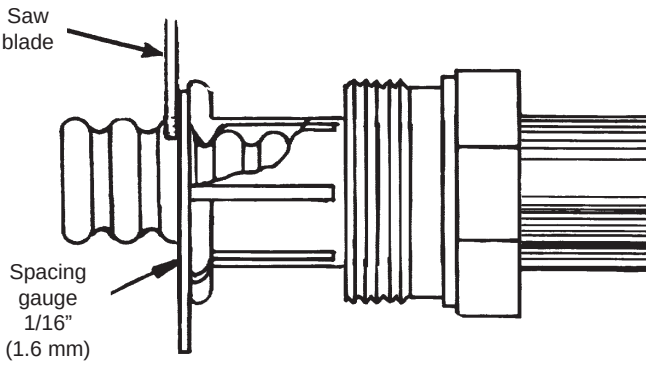
1 Straighten each cable for at least 10” (254 mm). Cut each cable end square and remove burrs from the outer conductor. Remove 1” (25 mm) of the jacket from each cable.



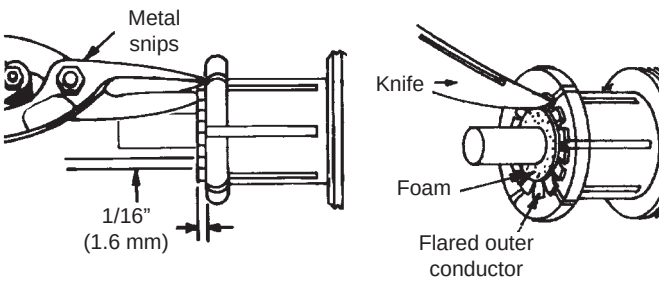
2 Scribe a line on a ridge of the outer conductor of each cable as shown. This line must be at least 11/32” (9 mm) from the cable end. Remove the amount of jacket shown for each cable, cable A for the long clamping nut or B for the short clamping nut, as measured from the scribe line. Wrap paper around the cable to form a cutting guide.



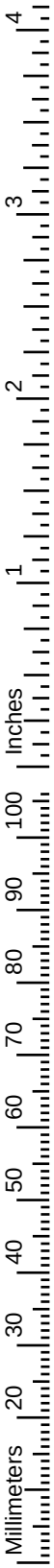
3 Slide the outer body onto cable B with the threads toward the cable splice area. Slide a small O-ring into the second fully exposed groove of the outer conductor from the jacket on both cables. Apply a thin coat of silicone grease to both O-rings and to the lead chamfer of both clamping nuts.

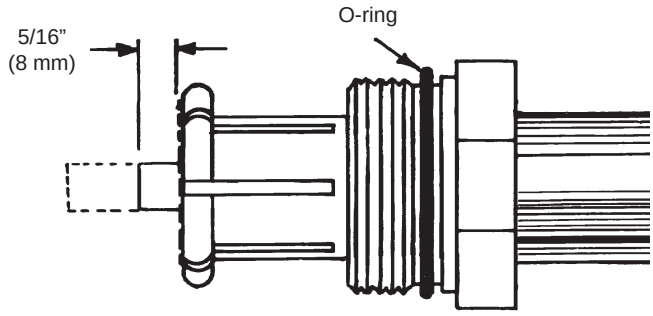


4 Push the long clamping nut fully onto cable A and the short clamping nut fully onto cable B. The scribe line on the outer conductor should be 1/16” (1.6 mm) from the end of the clamping nut on each cable. Place a spacing gauge on the cable and against the clamping nut as a guide and cut the outer conductor on the scribe line. Make a shallow cut to avoid cutting into the inner conductor. Remove the foam and adhesive from the inner conductor.

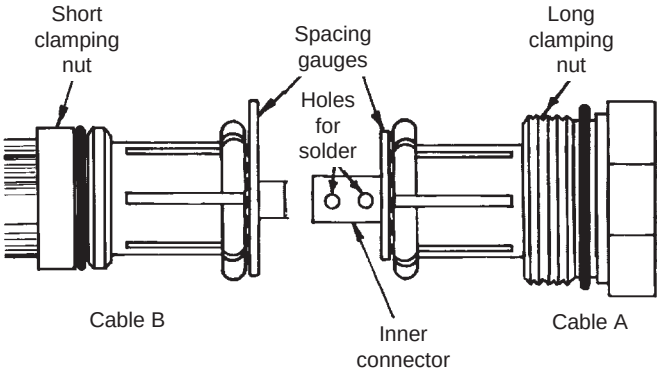


5 Cut each outer conductor at 1/16” (1.6 mm) intervals to form tabs. Bend and gently flatten the tabs against the flat surface of the clamping nut. Trim the foam flush with the flared outer conductor.

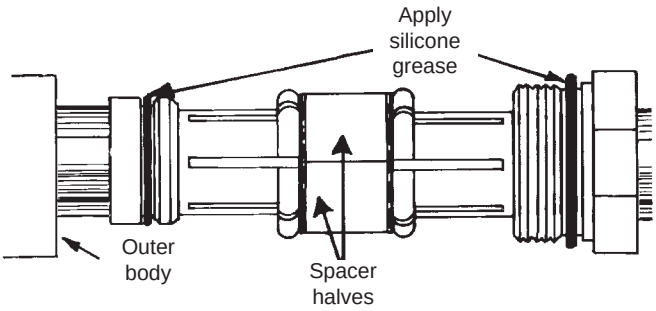




6 Cut each inner conductor to 5/16” (8 mm) from the flared outer conductor. Deburr the cut end of the conductor and brush away any copper particles from the foam. Place the largest O-ring in the groove of the long clamping nut and the next largest O-ring in the groove of the short clamping nut.



7 Remove foam particles and surface oxides from the inner conductor of each cable. Place a spacing gauge on cable A and slide the inner connector onto the inner conductor and against the gauge. Solder the connector, wipe away exces solder, and cool the connection with a damp cloth. Leave the gauge in place. Place the other gauge on cable B, slide the inner connector onto the inner conductor, and solder the connection. Remove the gauges and clean the connection with garnet cloth (do not use emery cloth or steel wool).



8 Apply a thin coat of silicone grease to both O-rings. Insert both spacer halves between the clamping nuts and slide the outer body over the spacer and thread it onto the long clamping nut. Tighten the connection with wrenches by holding the long clamping nut in place and turning only the outer body to 12 ±2 lbf·ft (16.4 ±2.7 N·m).

Notice

The installation, maintenance, or removal of antenna systems requires qualified, experienced personnel. Andrew installation instructions have been written for such personnel. Antenna systems should be inspected once a year by qualified personnel to verify proper installation, maintenance, and condition of equipment.

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