Instruction Sheet

No. 412564
Rev. C

Connector Assembly for S-FLC 14-50 Coaxial Cable

Tools Required

1. Fine Toothed Hacksaw
2. Light Metal Snips
3. Ruler
4. Flat Flle
5. Knife
6. Electrical Tape
7. Hammer
8. Long Nose Piiars
9. Soldering Iron and Solder
10. Open End Wrench (2), 7/16"
11. Heat Gun or torch

Connector Assembly

1. Disassemble the connector and identify all parts as shown in Figure 1. A tube of gasket grease is not shown.

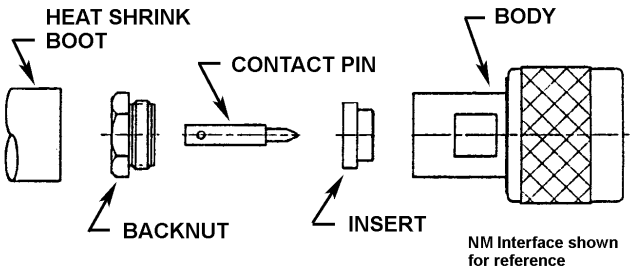

Figure 1.

2. Cut the cable end even with a hacksaw.

3. Trim the cable Jacket 7/8 inch from the cut end with a knife. See Figure 2.

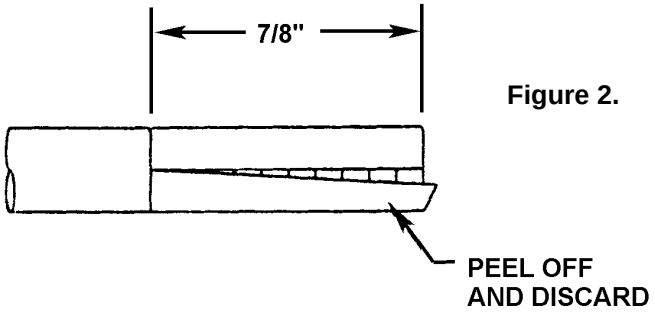

Figure 2.

4. Slide the heat shrink boot over the cable end and out of the way.

5. Thread the backnut onto the cable outer conductor and up to the trimmed Jacket - then unscrew one half turn. Temporarily secure the backnut to the cable with electrical tape. See Figure 3.

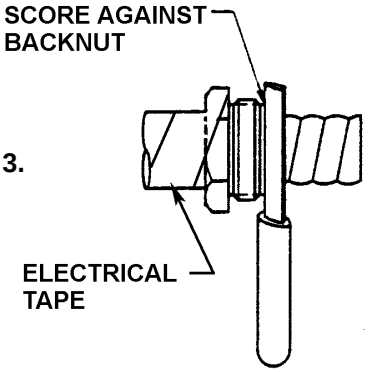

Figure 3.

6. With a knife, carefully cut the outer conductor flush to the backnut. Do not use excessive force that might crush the corrugations, and be careful not to cut through to the center conductor. See Figure 3.

7. Grasp the cut end of outer conductor with pliers and carefully remove It from the dieletric. Use a twisting motion to free the cut section If necessary. See Figure 4.

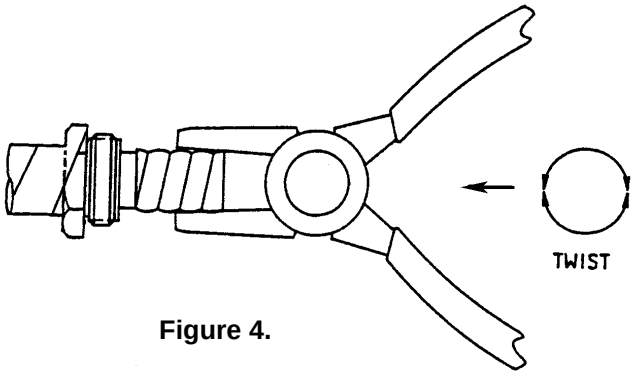

Figure 4.

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200 Pondview Drive
Meriden, CT 06450
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8. Remove the tape from the backnut, then tighten the backnut one half turn to expose approximately 1/16 Inch of outer conductor. See Figure 5.

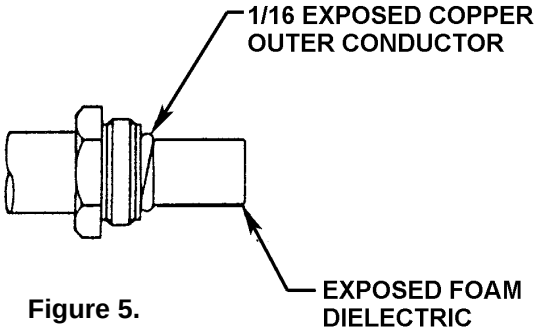


Figure 5.

9. Make a series of equally spaced cuts around the exposed outer conductor with light metal snips. Flare the outer conductor against the front surface of the backnut with long nose pliers. Trim any portion of outer conductor that protrudes past the front surface and smooth all sharp edges with a file.

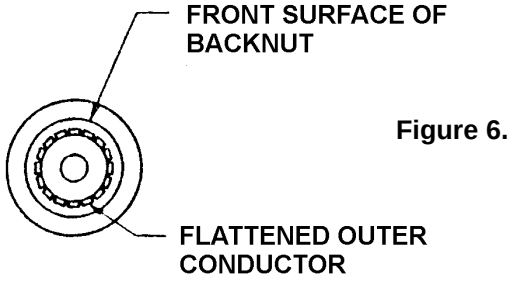
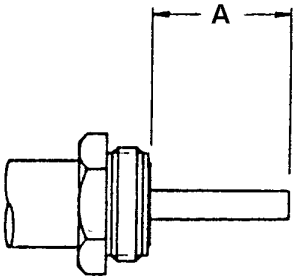


Figure 6.

See Figure 6.

10. Remove the exposed foam dieletric from the cable center conductor with a knife. All foam must be scraped completely from the center conductor and trimmed flush to the flared end. See Figure 7.

    Cut the center conductor with a fine toothed hacksaw to the "A" dimension shown. Chamfer the end with a flat file to remove any burrs.



Connector "A" Dimension	
NM, NF	1/2"
BNC	3/8"

Figure 7.

11. Slide the contact pin onto the center conductor to the "B" dimension shown in Figure 8. Solder the contact pin In place.

    Remove any excess solder from the contact pin and center conductor. Check to be sure the contact pin is stralght and properly bonded to the center conductor.

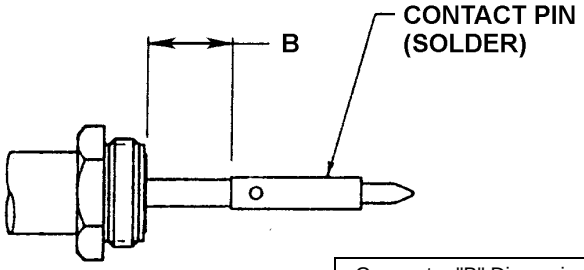


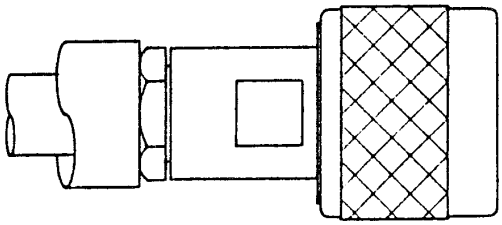
Figure 8.

Connector "B" Dimension	
BNC	9/32"
NM	1/4"
NF	5/16"

12. Place the connector insert - small end first, into the back end of the connector body. See Figure 1 for insert lliustration.

13. Slide the connector body over the contact pin and onto the backnut. Tighten the connector with two 7/16 inch wrenches. See Figure 9.

Figure 9.



14. Slide the heat shrink boot over the connector backnut and up to the connector wrench flats. Use a heat gun or apply a light flame to the boot until it shrinks smoothly forming a weather proof seal.

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Meriden, CT 06450
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