

# INSTALLATION INSTRUCTIONS

## Type L46Z Splice for LDF6-50 HELIAX® Coaxial Cable



### TOOLS AND MATERIALS REQUIRED FOR ASSEMBLY

Scale, 6 in (152 mm)	Hacksaw, fine-toothed blade	Wrench: (1) 1-3/4 in
Knife	Solvent, comothene, vythene or other	Wrench: (1) 1-7/8 in
Wire brush	non-flammable cleaning fluid	Snap ring (provided)
Mallet	File, 10 in (254 mm)	Snap ring tool
Rod, non-metallic	Metal snips	Turning bar (provided)

### READ THE INSTRUCTIONS THOROUGHLY BEFORE ASSEMBLY

**STEP 1. Prepare Cables.** End of each cable must be straight for at least 10 in (254 mm). Cables are identified as Cable A on right and Cable B, left. Remove jacket to approximate dimension shown. Use knife. Deburr sharp ends of outer conductors.

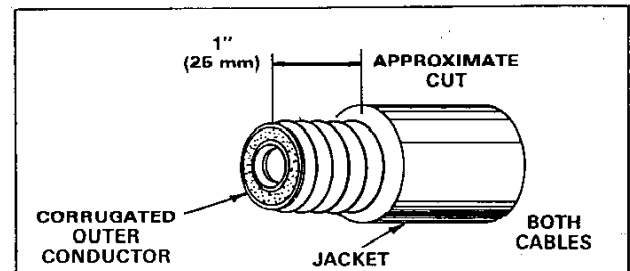


FIGURE 1

**STEP 2. Cut Cables.** Use tool to add snap ring to corrugation groove. Snap ring serves as cutting guide. Use hacksaw and cut off cable keeping blade against snap ring. File cut clean leaving no high spots. Remove snap ring. Deburr sharp ends of inner and outer conductors. Use knife to separate foam from inside outer conductor. Repeat above procedure for both cables.

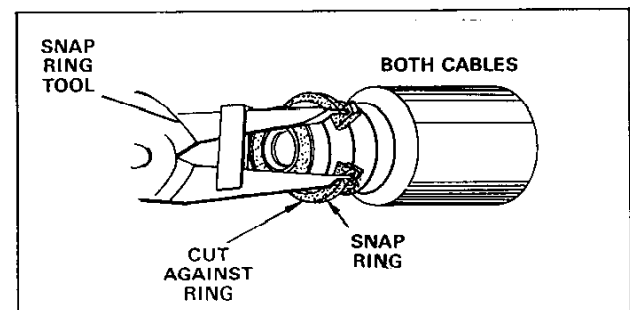


FIGURE 2

**STEP 3. Make Second Jacketing Cut.** Remove jacket to dimension shown for each cable. Use straight-edged piece of heavy paper around each cable to guide cut. Clean outer conductors with solvent.

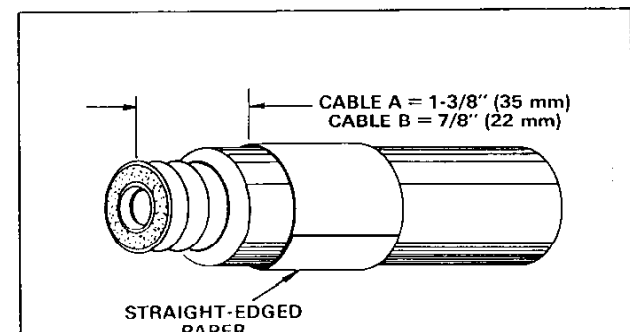


FIGURE 3



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**STEP 4. Add Outer Body and Gaskets.** Slip outer body onto Cable B with internal threads facing cut end of cable. Add O ring gasket to first full groove from end of each cable. Apply thin coating of silicone grease to outer surfaces of gaskets and gasket lead chamfers in clamping nut and clamping ring using finger tip.

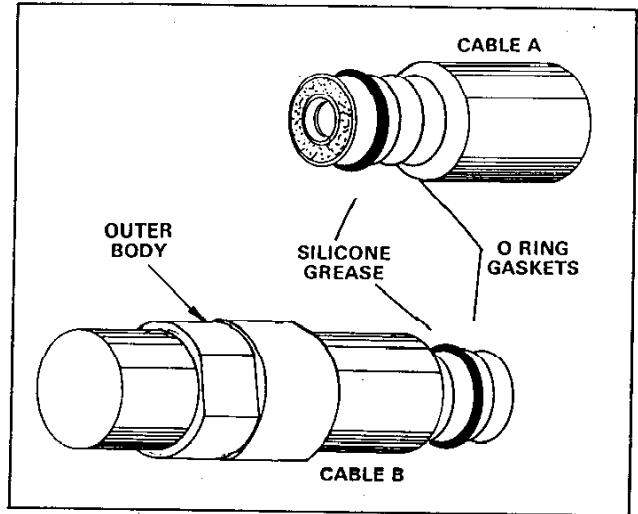


FIGURE 4

**STEP 5. Add Clamping Nut and Ring.** Carefully slide clamping nut over O ring gasket on Cable A and against slope on ridge of outer conductor. Similarly, slide clamping ring over O ring gasket on Cable B and against slope on ridge of outer conductor. Outer conductor on each cable should be exposed 1/8 in (3 mm).

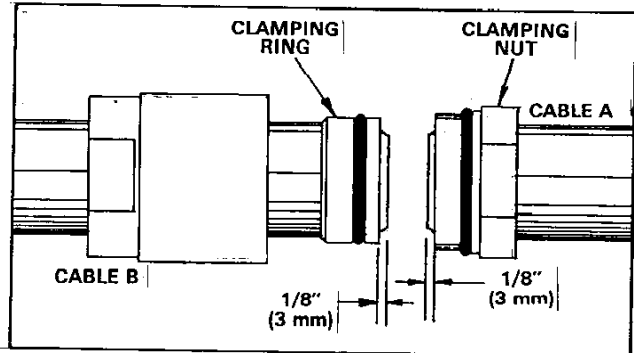


FIGURE 5

**STEP 6. Cut Tabs.** Use metal snips to cut tabs into outer conductor of each cable to intervals shown.

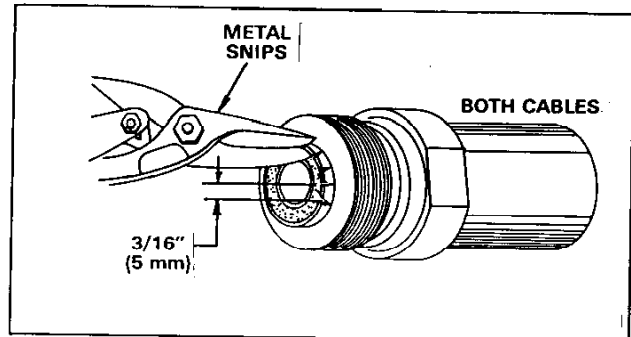


FIGURE 6

**STEP 7. Flare Outer Conductors.** Flare tabs against edges of clamping nut and clamping ring. Use nylon rod with rounded end and mallet to aid in starting flare. Carefully tap outer conductor flat against clamping nut and ring. Use only enough force to flatten tabs.

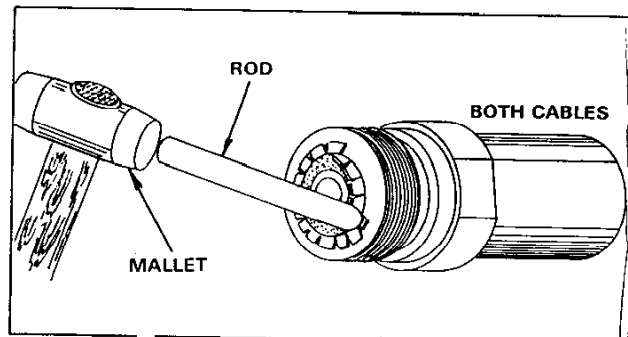


FIGURE 7

**STEP 8. Trim, Cut and Clean.** Use knife to trim foam flush with flared outer conductors. Also cut protruding inner conductor flush with flared conductor. Use hack-saw. Remove burrs and brush away copper particles from foam.

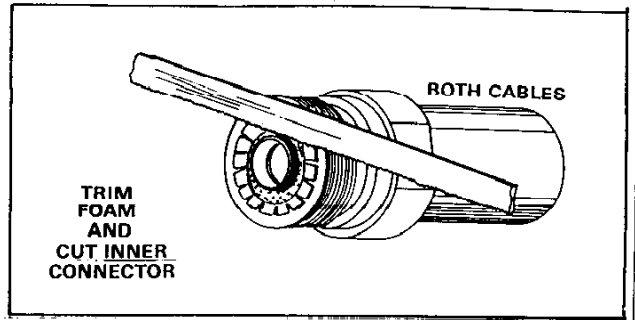


FIGURE 8

**STEP 9. Add Inner Connector and Flare Ring.** Inner connector has right and left-hand threads. Grooved end has right-hand thread. Insert grooved end gently into Cable A inner conductor. Place flare ring over inner connector and insert turning bar through flare ring and inner connector.

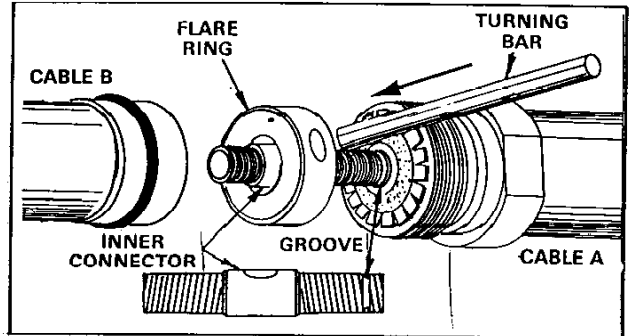


FIGURE 9

**STEP 10. Assemble Splice.** While holding flare ring in place, bring Cable B in line and push gently onto inner connector. Keep firm pressure and turn inner connector clockwise to draw cables together in turnbuckle action. Stop when pressure from clamping nut and clamping ring hold flare ring gently in place. Remove turning bar.

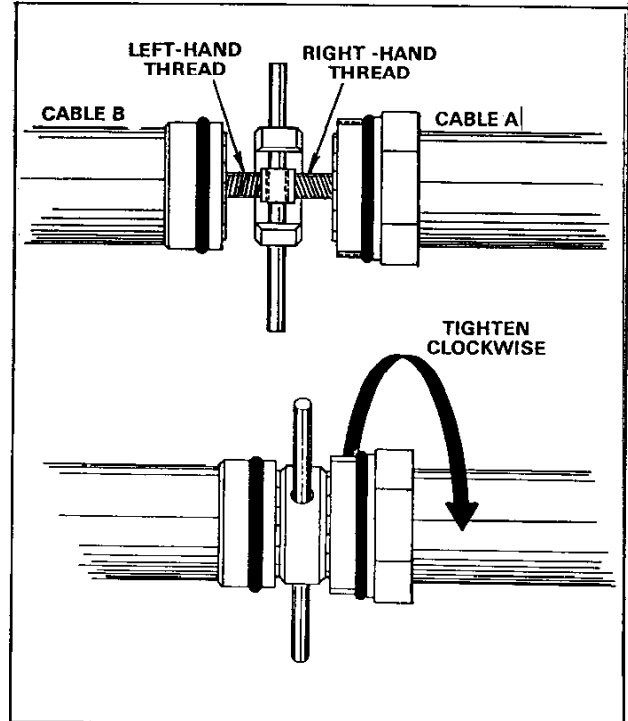


FIGURE 10

**STEP 11. Add Outer Body and Tighten.** Slip outer body over assembly and screw onto clamping nut. Tighten assembly with wrenches. Turn outer body only; do not turn clamping nut.

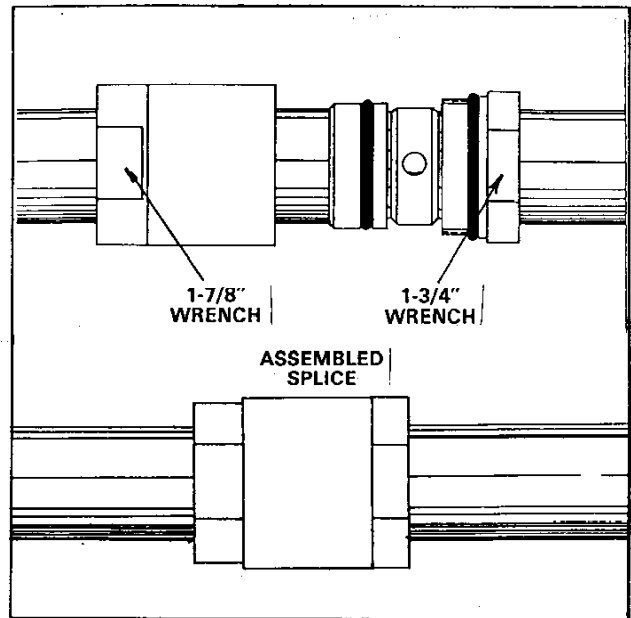


FIGURE 11 |