

## Installing a Flange on 5/8" Flex Coax

### Tools required:

- Hacksaw with a fine-tooth blade
- Flat file
- Knife
- Soft solder
- Flux for soft solder
- Soft silver solder (Silvabrite 100 or equivalent)
- Flux for soft silver solder (Rectorseal, Nokorode or equivalent)
- Solvent (comothene, vythene, or other non-flammable cleaning fluid)
- Garnet cloth
- Torch (MAPP, acetylene or equivalent)
- Heat gun for heat-shrink tubing

### Materials provided:

- 5/8" cable, P/N 55789-03, with a 7/8" flange factory-installed on one end, quantity 1.
- Flange hardware kits, P/N 82912-G506, qty. 2.
- Follower, P/N B94095-01, qty 1.
- Inner conductor, P/N A94096-01, qty 1.
- Insulator, P/N A55789-18, qty 1.
- Tubing, heat shrink, P/N A57941, qty 4 inches.
- Follower, flange, P/N 55579-01, qty 1.
- O-ring for 7/8" flange, P/N 9068-215, qty 2.

The customer is to cut the cable to the desired length and install a second 7/8" flange on the cut end.

### Step 1: Prepare the cable end (figure 1).

- Cut the cable to length. Make sure the cut is square.

#### CAUTION

Be very careful not to score the outer conductor. This will cause the outer to break easily when it is formed.

- Cut the jacket back 3-1/4" as shown, using a straight-edged piece of paper wrapped around the cable as a guide for the knife.

#### CAUTION

Hold the cable end pointing downward while cutting and filing, to prevent metal chips from entering the open end of the cable.

- Cut the outer conductor back 5/16" as shown.
- File the cut edges of the cable to deburr and remove rough edges. Tap the cable lightly to ensure no chips are left inside.
- Clean the outer conductor with solvent to remove grease or dirt that might interfere with solder adhesion.

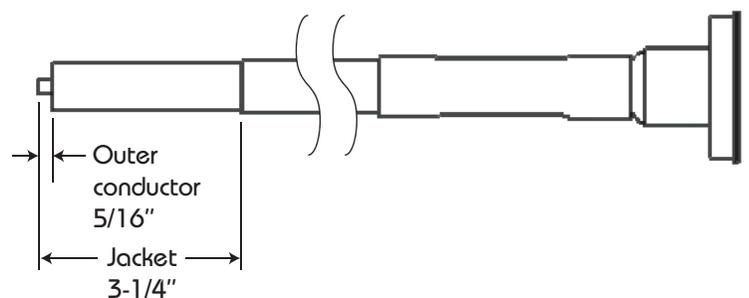


Figure 1. Cut back the jacket and the outer conductor.

### Document No. ts-flange on coax (150320)

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## Step 2. Install the inner conductor end (figure 2).

- Apply flux inside the inner conductor end to ensure a good bond.
- Slip the inner conductor end over the protruding end of the cable's inner conductor and silver-solder it in place.
- Clean excess solder and flux, using the solvent.

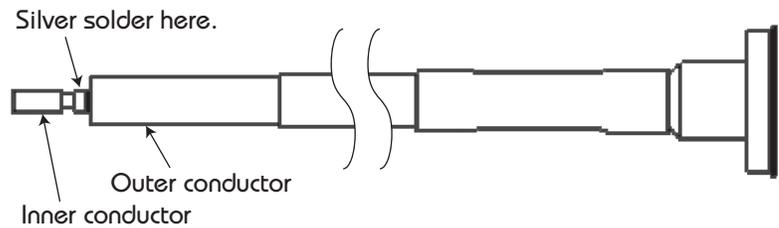


Figure 2. Install the inner conductor end.

## Step 3. Install the insulator (figure 3).

- Slide the flange follower and the flex cable follower over the cable end and push them back out of the way.
- Carefully spread the insulator and slip it over the inner conductor, seating it in the groove in the inner conductor.

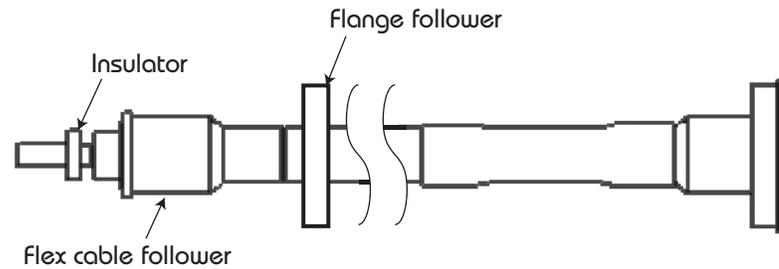


Figure 3. Install the insulator.

## Step 4. Install the flange (figure 4).

- Slip the flex cable follower out to the end of the cable until it butts against the insulator inside. Solder it in place, using the silver solder as shown.
- Clean excess solder and flux, using the solvent.
- Leave the flange follower out of the way until after the heat-shrink tubing is in place.

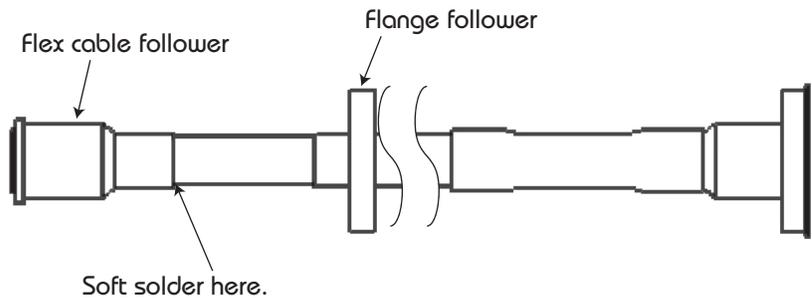


Figure 4. Install the flange.

## Step 5. Check the cutback dimension (figure 5).

- The "cutback" of the inner conductor end within the flange should be  $1/2"$  to  $9/16"$  as shown.
- If the dimensions are not as shown, do not attempt to use the cable. Call the factory,

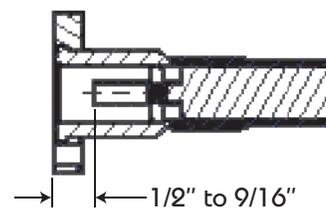


Figure 5. Check the cutback dimension.

## Step 6. Install the heat-shrink tubing (figure 6).

- The heat-shrink tubing should fit over the flex cable follower and under the flange follower. Slide it into place.
- Using the heat gun, gently warm the tubing to shrink it into place over the cable and cable follower.
- Slide the flange back against the cable follower. You're all finished!

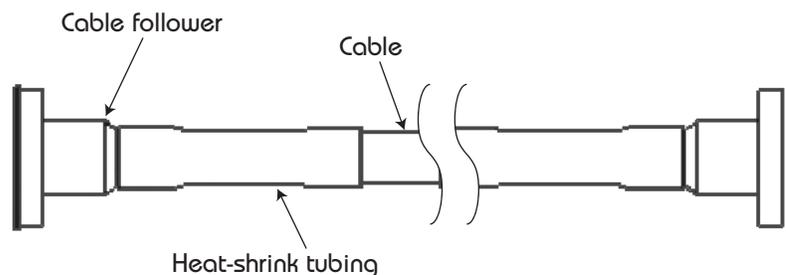


Figure 6. Install the heat-shrink tubing.