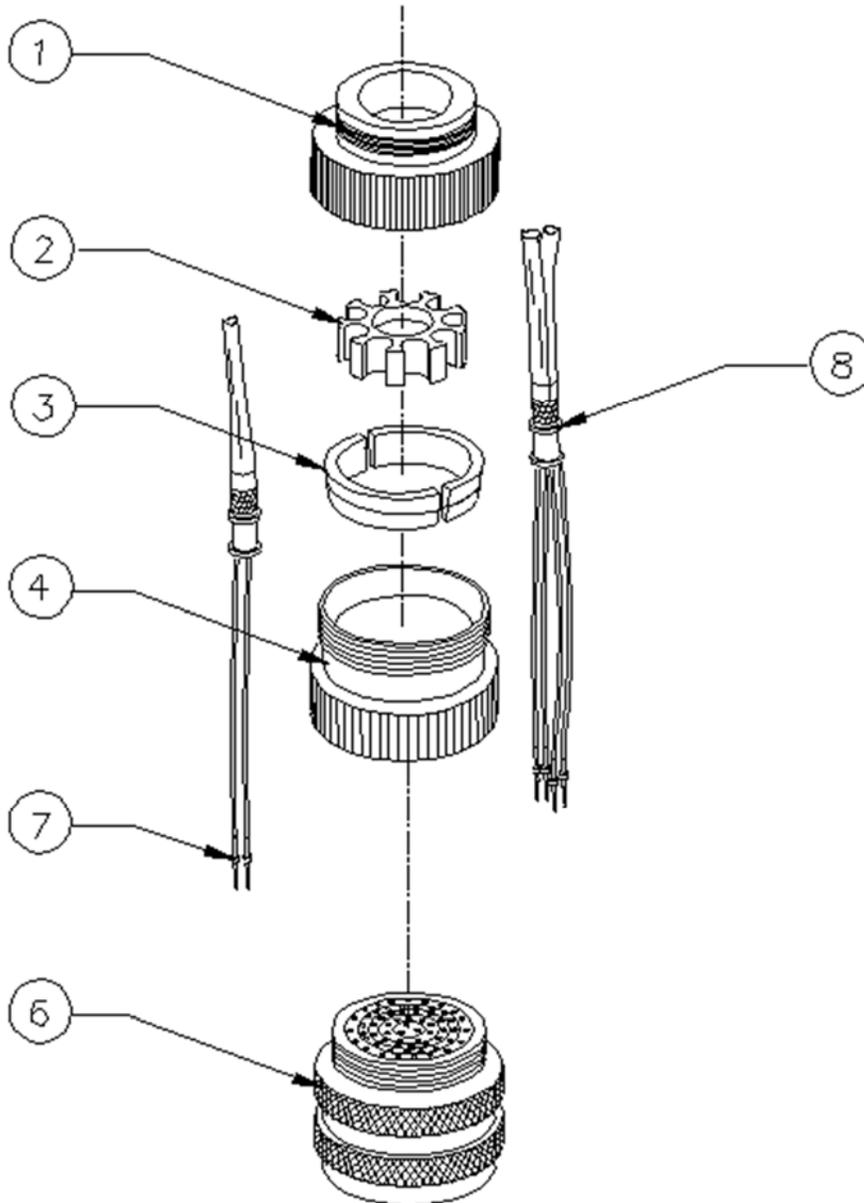
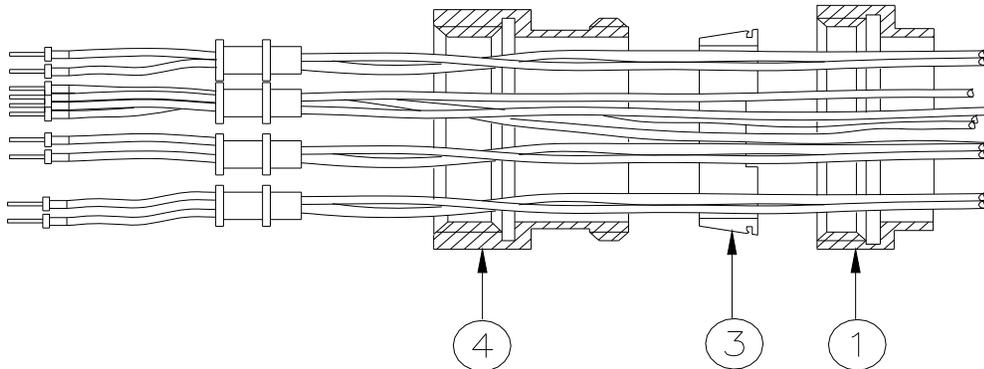


**HexaShield for Cylindrical Connectors
Installation Procedure-Straight Body**

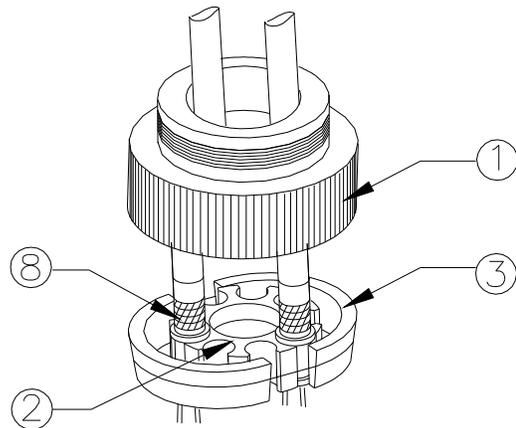
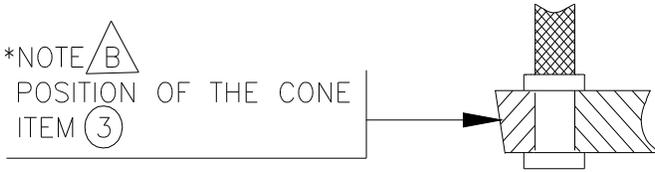


1. Install the ferrules (8) with the Soldershield or the heat shrinkable sleeve.
 - see RPIP 696-00 (Soldershield).
 - see RPIP 696-03 (Heat-shrinkable sleeve).
2. Terminate cables with crimp contacts (7).
 - Refer to crimp contact manufacturer's instructions.
3. Pass the clamping nut (1), the conic ring (3), and then the body (4) over the cable bundles (as shown). For adapters containing drilled stars, route the wires that pass through the center hole of the star before inserting the contacts into the connector.



4. Insert the contacts (7) into the connector (6).
 - Refer to the manufacturer's instructions.
5. Tighten the body (4) on to the connector (6), see paragraph 11.
 - Torque value: see table A.
6. Clip the ferrules (8) into the star (2). For star-in-star or split star configurations, install the ferrules starting from the inner star or ferrule slot.
7. Position the conic ring (3) on the star (2), according to note B*.

*NOTE 
 POSITION OF THE CONE
 ITEM 

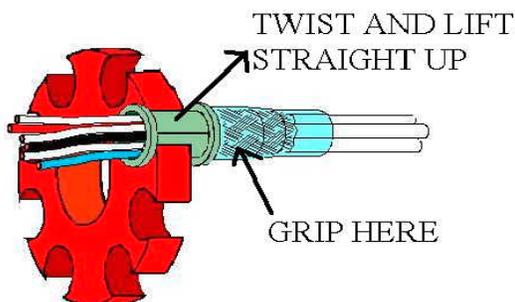


8. Position the sub-assemblies (stars+conic rings+ferrules) into the body by carefully twisting the cables. Heat may be applied to the primary wires, to make the wires easier to twist. Apply heat, then push and twist the wires until the clamping nut (1) threads will engage with the threads on the body (4). Hot air tool: Steinel HL1802E, without reflector, Setting 4-5, Low speed (220°C±20°C). Equivalent tools may be used.
9. Tighten the clamping nut (1) on the body (4), see paragraph 11.
Torque value: see table B.
10. If a tinel lock is mounted on the clamping nut, see Raychem Tinel Lock* installation procedure.
For band strap clamping nuts, use the band strap manufacturer's installation procedure.
11. Tightening of Hexashield adaptors.
It is essential for reliable electrical performance to adequately tighten the adaptor onto the connector. The following procedures are recommended.
 - 11-1. Apply a suitable liquid lock compound (e.g. Loctite 243) to the first thread, also acts as a lubricant when tightening Hexashield adaptors.
 - 11-2. Hand tighten the body onto the connector ensuring that antirotation teeth are properly mated. It is recommended that the connector is mated to a receptacle or connector wrench before final tightening takes place.
 - 11-3. Using a torque tool and strap wrench, tighten the body first then the clamping nut to the specified torque. Recommended tool: Glenair Series 600 assembly tool, or Daniels DMC Beta accessory tool. Equivalent tools may be used.

HEXASHIELD	Recommended Torque			
	Table A		Table B	
Sizes	Lbf in	mN	Lbf in	mN
08 / 09	35	4.0	22	2.5
10 / 11	40	4.5	25	2.8
12 / 13	45	5.0	25	2.8
14 / 15	50	5.7	50	5.7
16 / 17	60	6.8	65	7.4
18 / 19	70	8.0	90	10.2
20 / 21	80	9.0	105	12.0
22 / 23	90	10.2	115	13.0
24 / 25 / 61	100	11.3	130	14.7

12. Dismantling HexaShield Adaptors.

Dismantling is the reverse of the assembly. To remove a ferrule from a star, grip the ferrule assembly as close to the star as possible. Carefully twist and lift the ferrule straight up from the ferrule slot in the star. Do not remove the ferrule by lifting or pulling on the cable or wires only, or damage to the ferrule assembly may result.



For maximum contact extraction tool access, unclip all ferrules from the star, remove the star from the cable bundle before pushing the adapter body (4) toward the cable.