STANDARD STEEL TERMINATION GUIDE

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1 Scope

This guide describes mounting of a standard steel termination on steel cables.

2 Materials

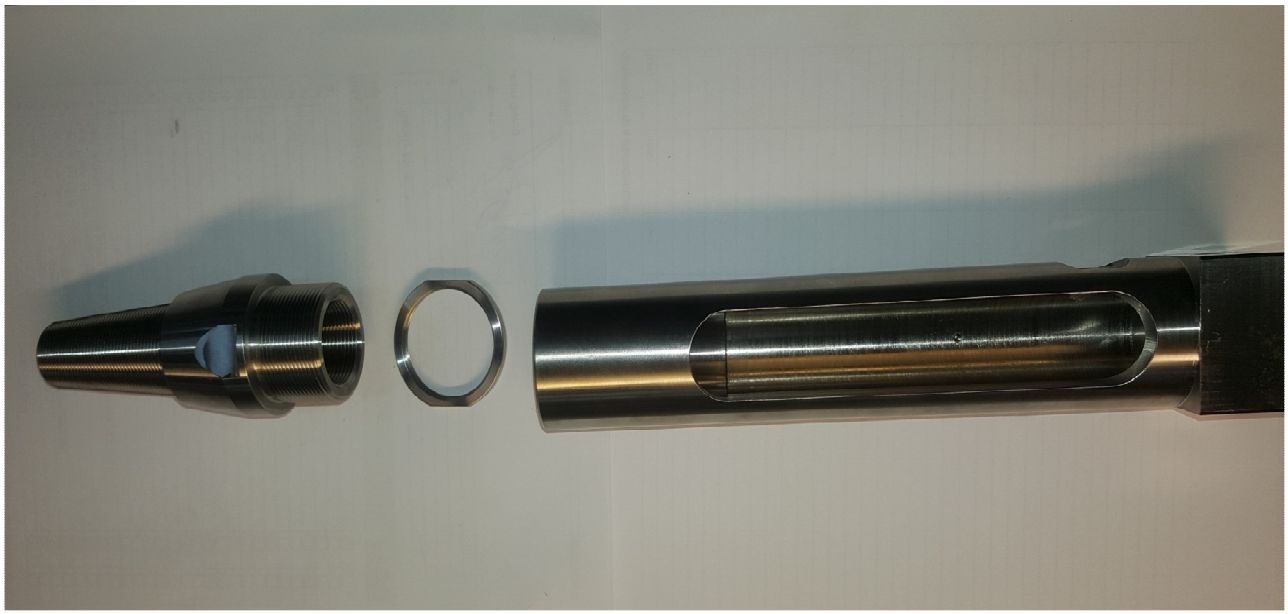

Figure 1 Steel termination parts.

Other needed items:

- Two 210 gram 3M Scotchcast
- Acetone to clean the termination and the cable
- Cleaning paper and brush
- Wire lock
- Grease to protect tighten work for the termination (Loctite 542 or 577)
- Bulkhead connector with O-ring

3 Instruction

Follow below instructions step by step:

Prepare the cable to cut the damaged section by taping it with electrical tab as you see in Figure 2 and Figure 3, remember to use safety glasses and the right cutting tools.

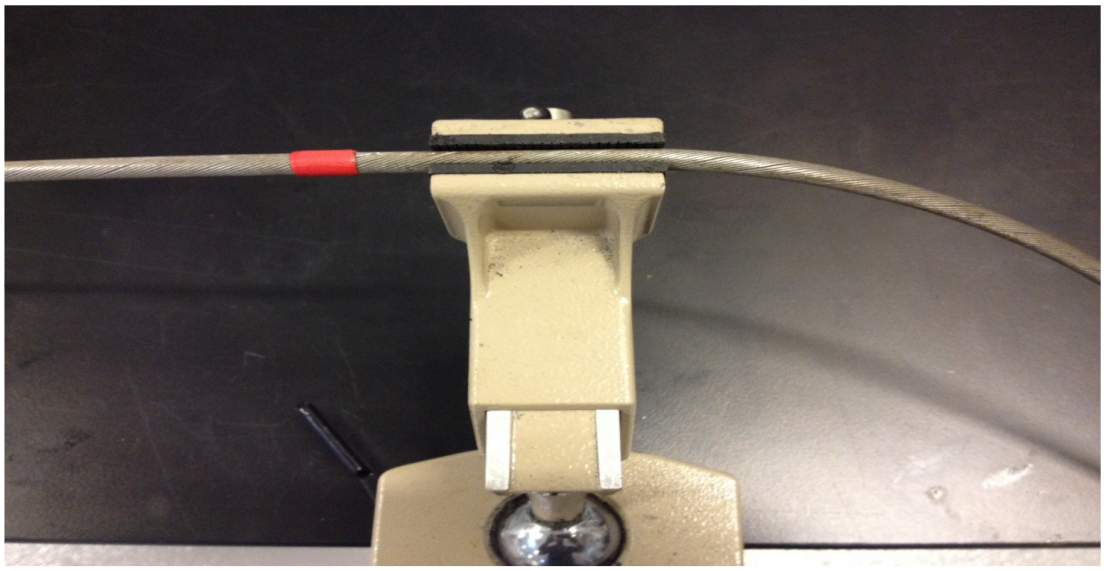

Figure 2 Marking cable with electrical tape

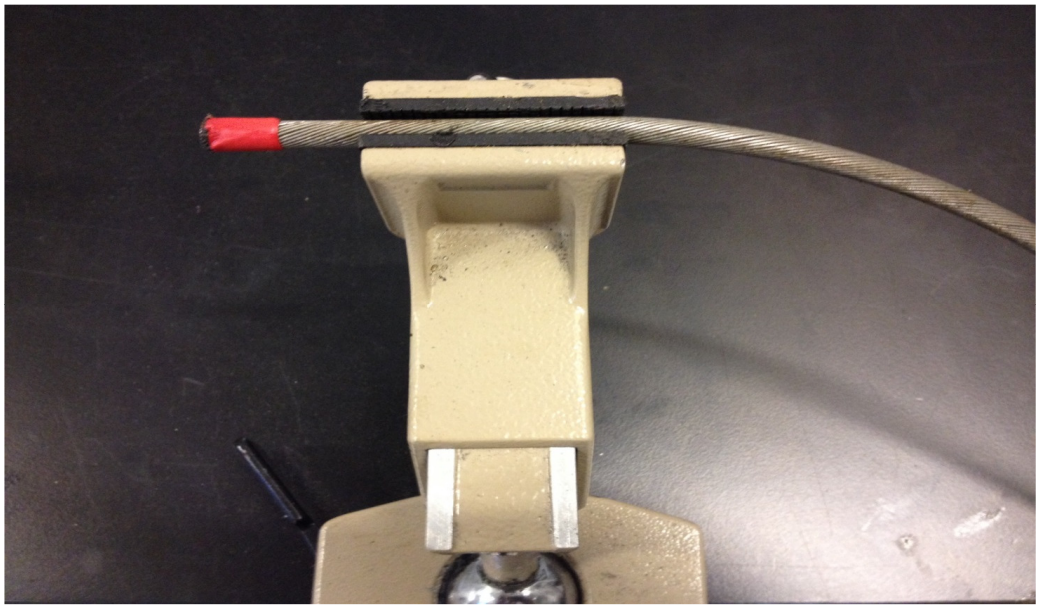

Figure 3 Cutting cable

Take off about 20cm of the metal wire around the coax cable to isolate it. See Figure 4 and Figure 5.

Figure 4 Measuring cable and marking

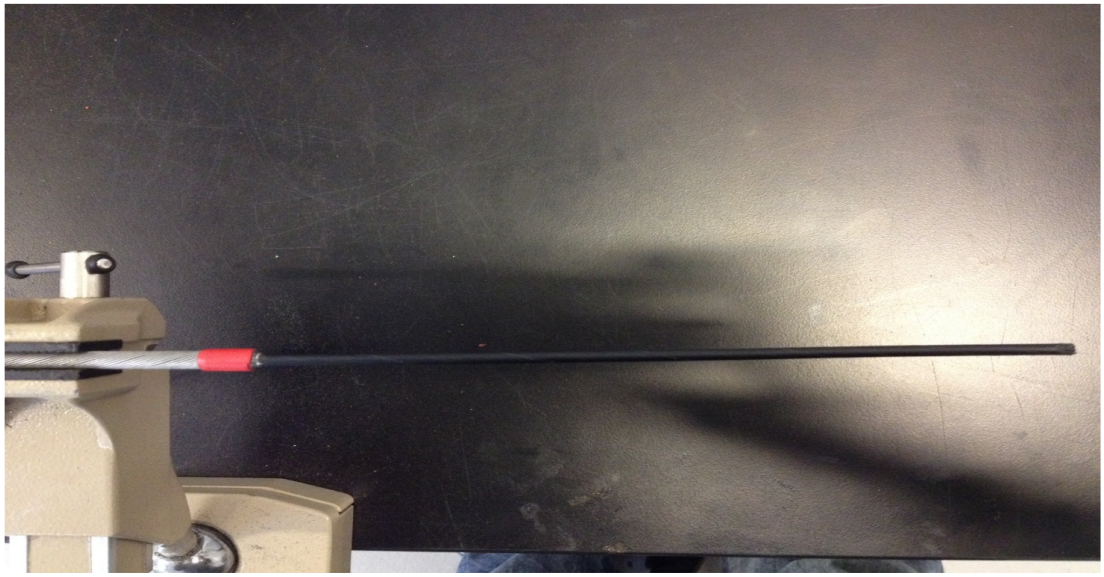

Figure 5 Cutting metal wires and leaving internal core

Clean the bottom part of the termination by using acetone. Screw on the lock nut. As the thread is very delicate, protect it with electrical tape to avoid damage or spilling wire lock. (not showed on next pictures).

Figure 6 Cleaning bottom part and protect thread

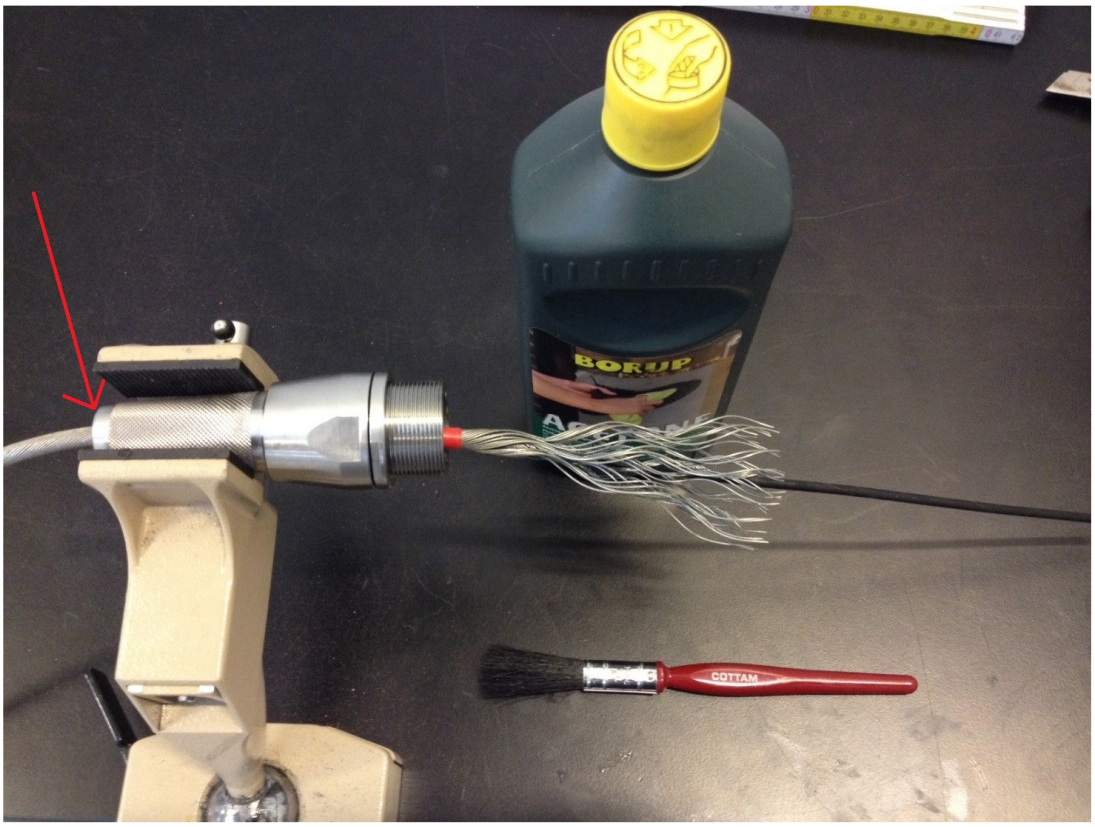

Figure 7 Pulling cable trough termination bottom part

Pull the cable through mark with tape and open the strands approx. 9 cm and clean with acetone. Pull the cable back into the bottom house. Seal the end (red arrow) with some tape to avoid the wire lock “running out” at the bottom.

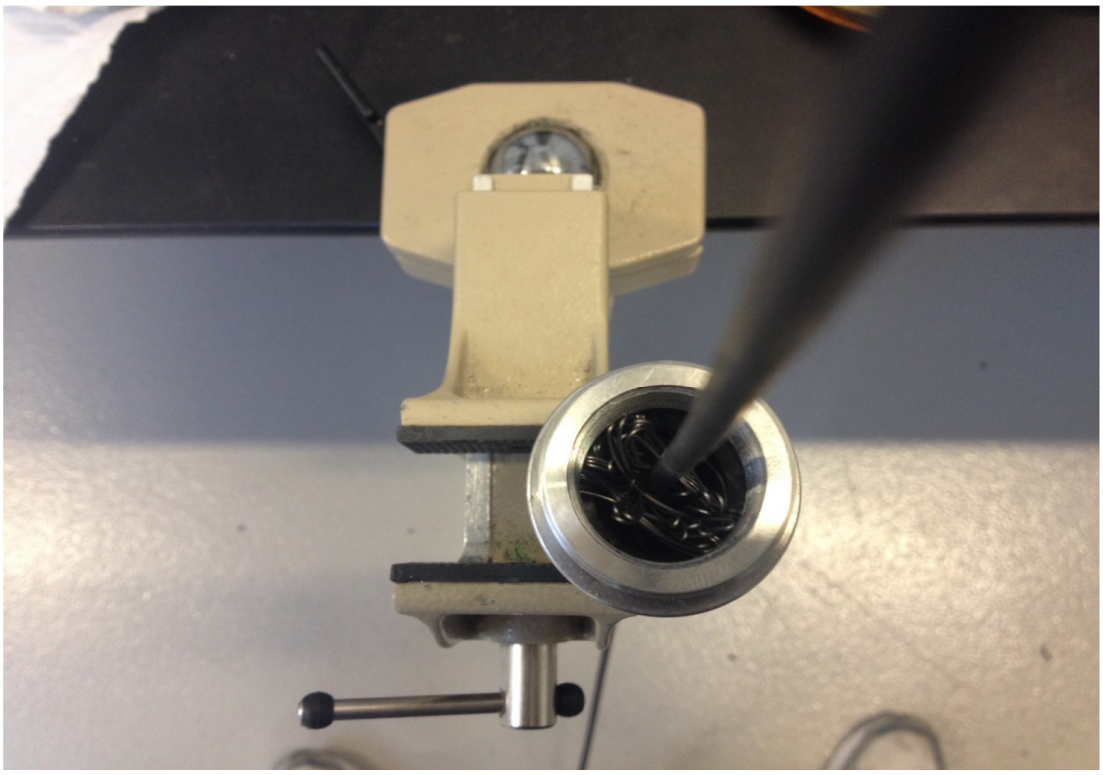

Figure 8 Folding wires inside termination bottom part

Prepare the wire lock and mix with some stick for at least 4 minutes then pour it in the termination's bottom.

Figure 9 Mixing wirelock

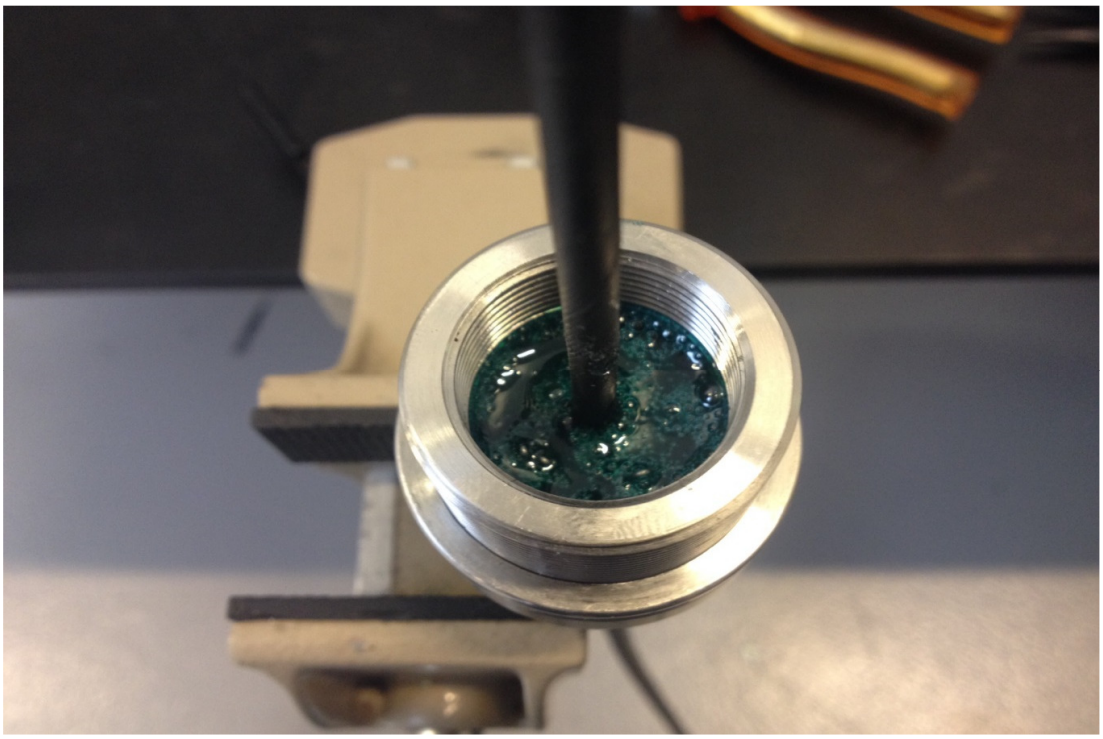
Figure 10 Termination bottom part filled with wire lock

The wire lock must be “topped up” (more than showed on the picture)

Remove the “protecting tape” Grease the thread on the outer core with Loctite and mount the carrier housing. Tighten the lock nut. Screw on the bulkhead (remember the o-ring)

Figure 11 Assembling termination

1. Cut the coax cable to a suitable distance and isolate it, then join it with the bulk connector. After that, it will be ready to the last 3M molding.
2. Figure 13 shows a complete termination.

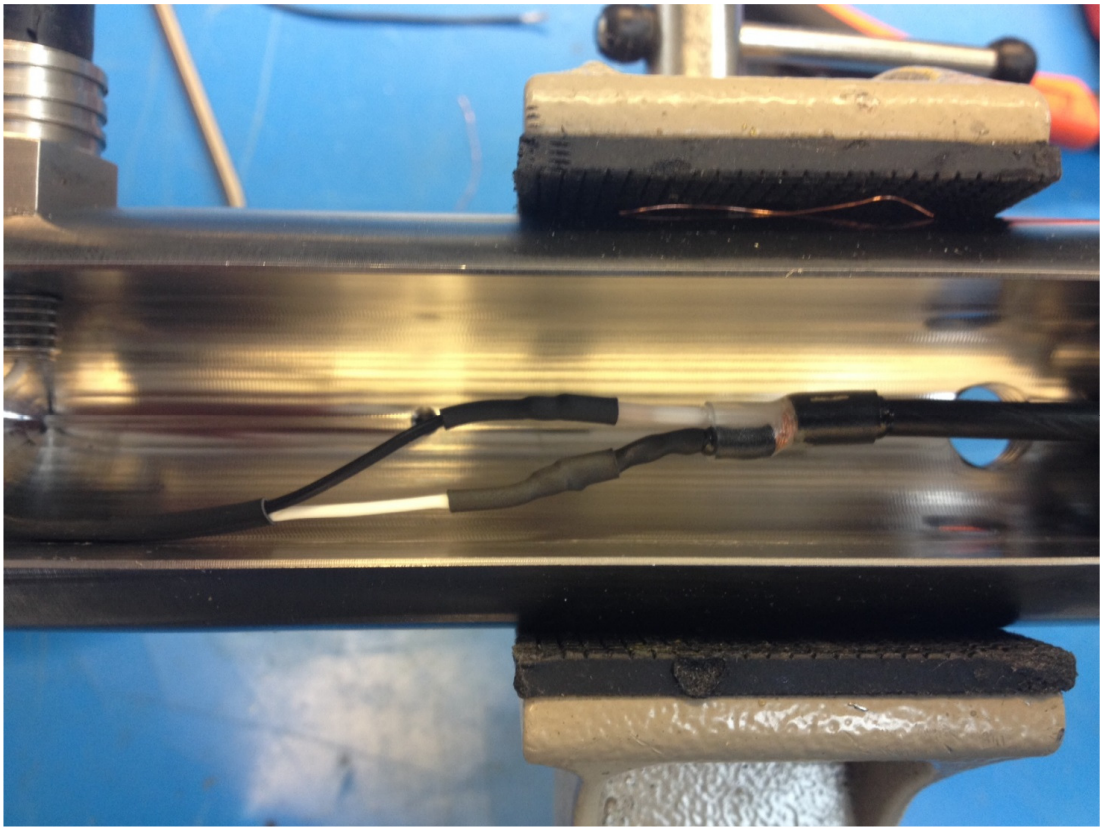

Figure 12 Joining cables with bulk head connector

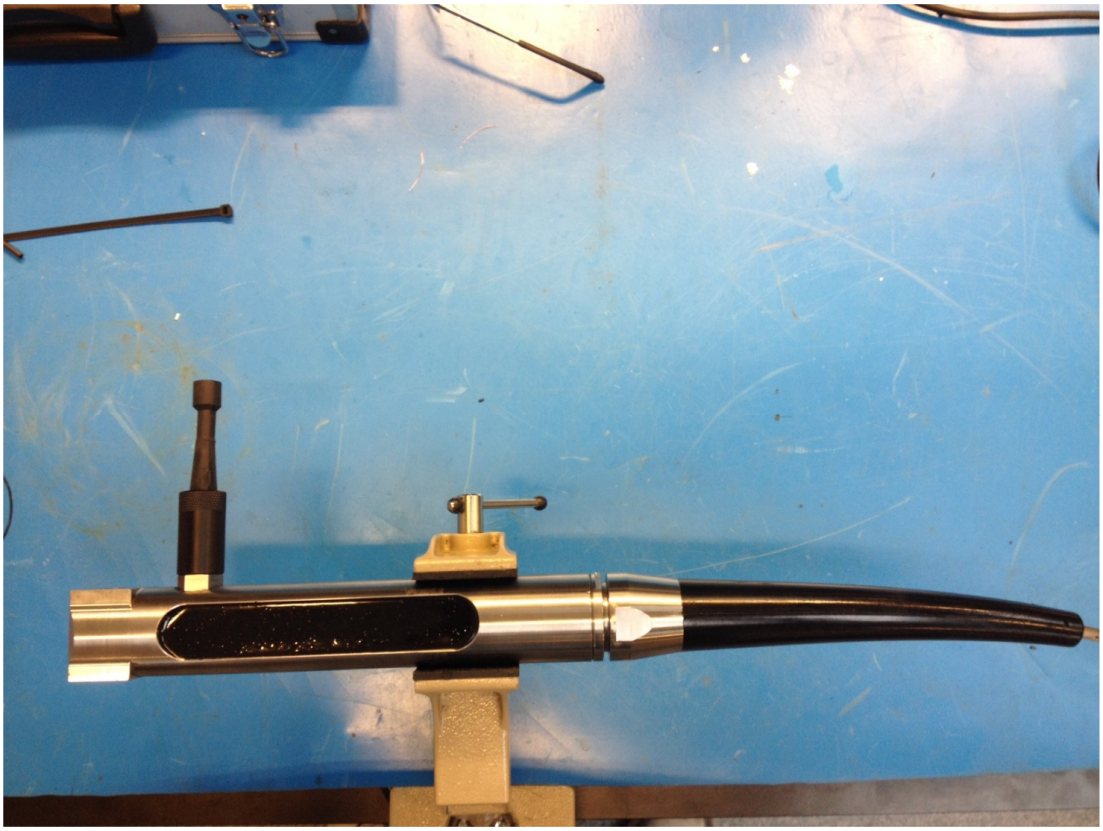

Figure 13 Complete termination

4 Responsebility

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Version number/date	Description
1.0	First version
1.1	Document updated
1.2	Added figures
1.3	Renumbered figures and text