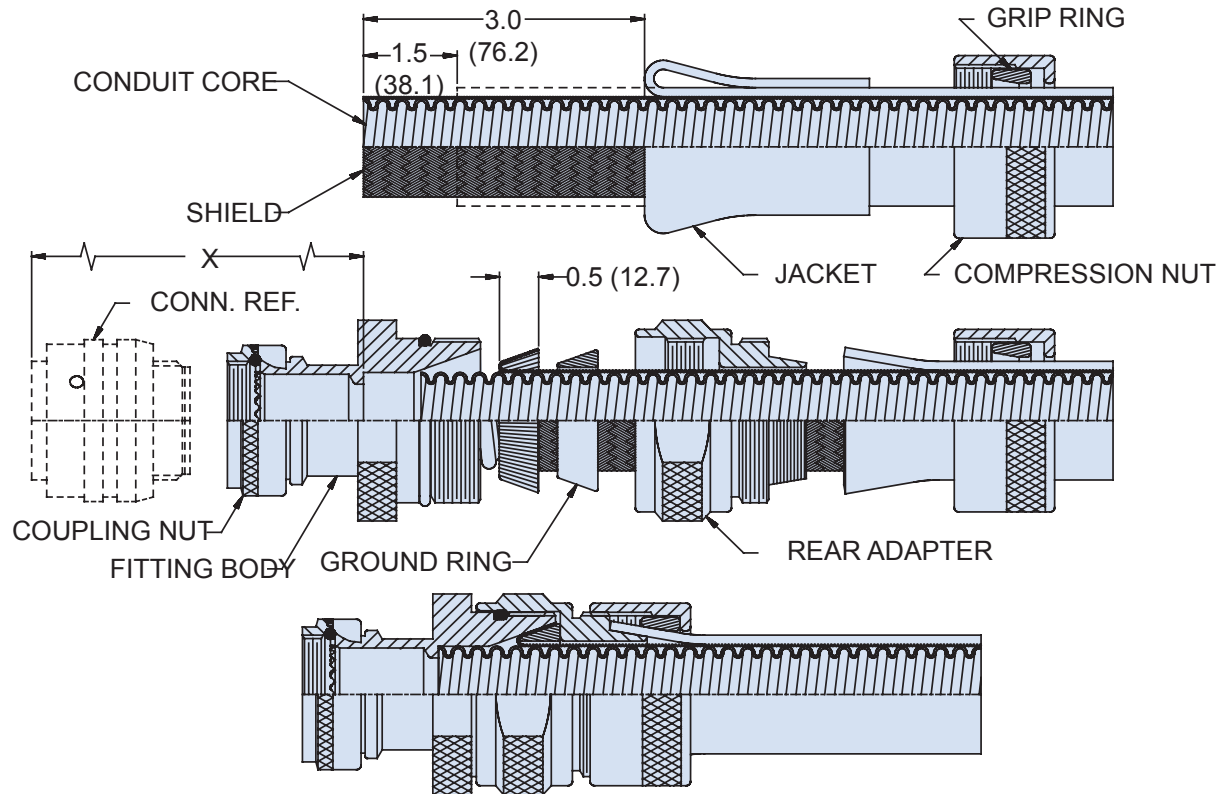


Heavy-Duty Ground Ring System Fittings



Pre-Assembly Preparation

1. Determine overall conduit assembly length required from connector face to connector face. From this dimension, establish conductor length needed for connector termination and add two inches.
2. Temporarily assemble connector to fitting and hand tighten. Establish and deduct the "X" dimension(s) from the overall assembly length in Step 1.
3. Disassemble fitting from connectors. Prepare conduit and assemble to fitting per instructions below.

Fitting/Conduit Assembly

1. Cut conduit to length per pre-assembly preparation step 2 using conduit shears or an equivalent. Trim jacket back 1.0 inches from end taking care not to cut or nick shield underneath.
2. Slide compression nut and grip ring onto conduit.
3. Fold jacket back approximately 3.0 inches (76.2 mm). Silicone grease or other lubricant may be used to aid this process.

4. Trim conduit and the shield perpendicular to the bore. Inspect inside of conduit for trimmings or other foreign matter and remove. Slide rear adapter and ground ring over shield and back to folded jacket.
5. Fold back (or comb out and fold back) shield approximately 0.5 inch (1.3 mm). Slide conduit core into bore in fitting and bottom on shoulder at "X" dimension. Slide ground ring forward into tapered bore in fitting, capturing shield. (If shield has been "combed out", make sure the ends are equally displaced about the ring and not bunched) Trim shield at rear end of ground ring and remove trimmings.
6. Bring rear adapter forward, thread to fitting body and torque 30 to 50 inch pounds. Verify conduit is seated in bore.
7. Fold jacket forward over serrated cone. Trim jacket flush to 1/8 inch back from shoulder and remove any trimmings.
8. Bring grip ring and compression nut forward, thread to fitting body and torque to 30 to 50 inch pounds.

Glenair 600 series backshell assembly tools are recommended for assembly and installation. A catalog is available on request, or may be accessed on the internet at www.glenair.com.