Assembly Instruction
Rigid Line

These instructions are intended for qualified and experienced personnel. Before you start, please read these instructions thoroughly.
We disclaim any liability or responsibility for the results of improper or unsafe installation practices.
Please adhere to all applicable environmental regulations during assembly and waste disposal.

Handling

Ensure all components are kept dry and free from grease, dust, and burrs.

Caution: Do not deform the rigid lines while handling.

Recommended Tools

- Measuring tape (with mm graduations)
- Marking tool
- Hacksaw or chop-saw
- Half-round file or/and deburring tool
- Abrasive paper
- Cleaning alcohol

Cleaning

Prior to assembly, clean all rigid line components including the tubes to ensure they are free of grease, dust, burrs, and are dry.

We recommend the use of ethanol, or ethyl alcohol (clean alcohol).

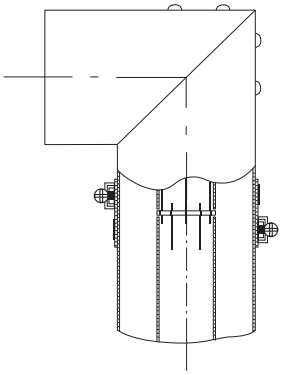


Fig. 1

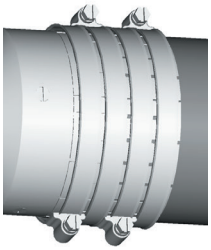


Fig. 2

Fitting

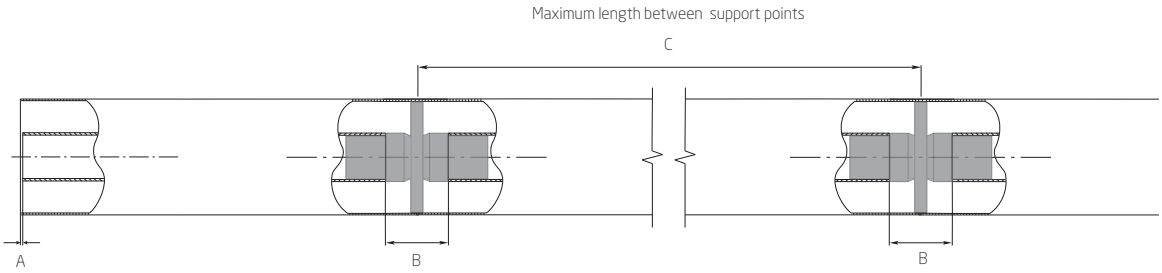
The indoor unflanged rigid line components are connected together using a coupling kit. The kit consists of an inner bullet, an outer sleeve and 2 or 4 tube clamps (depending on format). See figure 1 and 2.

Mount the tube clamps so that every other clamp is positioned on the opposite side to each other for equal contact pressure around the outer conductor tube. See figure 2.

Apply a tightening torque of 5 Nm to the outer clamps around the coupling sleeves. Except for the clamp designed for the 7/8" format, which requires a tightening torque of 1.5 Nm. All rigid line components are built with the inner conductor 1.5mm shorter than the outer conductor (except RL230). See cutback table "A" below.

If the rigid line exceeds a certain length, an inner support must be used. The distance between the support points depend on the format of the rigid line.

Do not exceed the specified distance between support points for optimal performance. These relationships are shown in the table "C" below as well as the cutback "B" table for the inner supports.



Inner conductor cutback when using inner bullet

Inner conductor cutback when using inner support

FORMAT	INNER BULLET CUTBACK "A"
7/8" unflange	1.5 mm
1 5/8" unflange	1.5 mm
3 1/8" unflange	1.5 mm
RL98 unflange	1.5 mm
4 1/2" unflange	1.5 mm
NAX120 unflange	1.5 mm
6 1/8" unflange	1.5 mm
RL230 unflange	2.0 mm

FORMAT	INNER SUPPORT CUTBACK "B"
7/8" unflange	24 mm
1 5/8" unflange	29 mm
3 1/8" unflange	46 mm
RL98 unflange	33 mm
4 1/2" unflange	48 mm
NAX120 unflange	33 mm
6 1/8" unflange	64 mm
RL230 unflange	140 mm

FORMAT	MAXIMUM LENGTH WITHOUT INNER SUPPORT "C"
7/8" unflange	1000 mm
1 5/8" unflange	1400 mm
3 1/8" unflange	2000 mm
RL98 unflange	2500 mm
4 1/2" unflange	2500 mm
NAX120 unflange	2500 mm
6 1/8" unflange	3000 mm
RL230 unflange	2515 mm