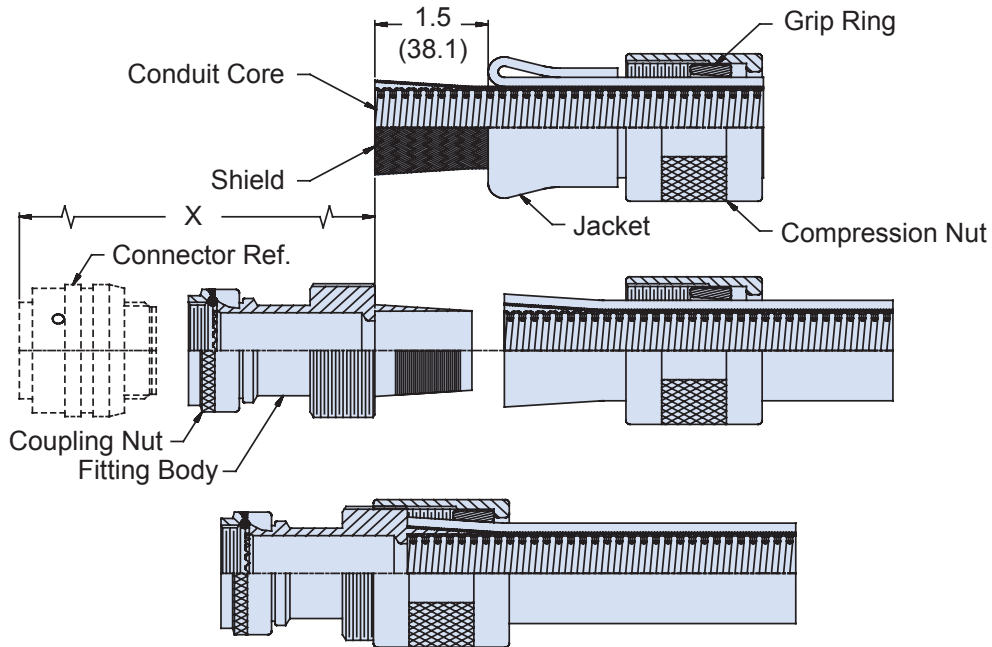




Installation Procedures for Legacy MIL-C-24758 System (712-188, 712-386, 712-387 & 712-388)

Legacy MIL-C-24758 System Fittings



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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 connector. Prepare conduit and assemble to fitting per instructions below.

Fitting/Conduit Assembly

1. Cut conduit to length per pre-assembly preparation step 2 using an abrasive disk or an equivalent. Ends of conduit must be perpendicular to the bore to assure proper termination.
2. Slide compression nut and grip ring onto conduit.
3. Fold jacket back approximately 1.5 inches (38.1 mm), as shown in figure 1. Silicone grease or other lubricant may be used to aid this process.
4. Deburr and remove all sharp edges on inside diameter, face and outside diameter of conduit core.

5. Flare shield out from conduit to fit over serrated cone of fitting. Slide conduit core into bore in fitting and bottom on shoulder at "X" dimension. Shield should be flush to external shoulder of fitting. Trim loose strands if required.
6. Fold jacket forward. Jacket should be flush with shoulder at "X" dimension.
7. Bring grip ring and compression nut forward, thread to fitting body and torque to recommended value in Table I. Silicone grease or other lubricant may be used to aid this process. For stainless-steel fitting, use an "anti-sieze" lubricant on threads to prevent galling and obtain correct torque values.

Conduit Dash No.	Torque Values	
	Fitting Torque Values (Inch Pounds)	Newton/Meters
8	140	16
12, 16	150	17
20, 24, 32	175	20
40, 48, 56	190	21
64, 80, 96	210	24