



**63 SERIES CONDUIT ADAPTOR BUILD SHEET**

|                                       |              |                |                         |
|---------------------------------------|--------------|----------------|-------------------------|
| <b>WORK INSTRUCTION</b><br>ASQAW 0139 | <b>ISSUE</b> | <b>1</b>       | <b>DATE: 08/12/2011</b> |
| <b>REVIEWED AND APPROVED BY</b>       | <b>NAME</b>  | <b>P.REES</b>  | <b>DATE: 14/12/2011</b> |
| <b>PROCEDURE OWNER</b>                | <b>NAME</b>  | <b>P.FRYER</b> |                         |

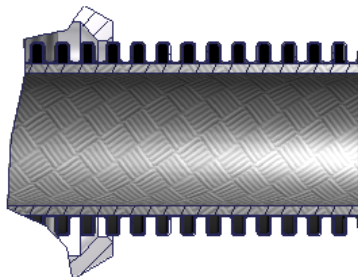
Summary

This document outlines the standard procedure for assembling a Polamco 63 series adaptor with 100P2589 conduit.

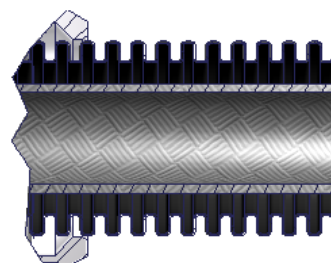
Method

Step 1.

Collect together all of the component parts of the assembly, as shown in Fig.3. below. Cut the braid to a length 10-20% longer than the conduit. This extra length will be consumed by pushing the excess braid back into the conduit after pulling it through. Under tension, the braid “necks” down and increases in length, while under compression the braid diameter expands and decreases in length. By putting the braid in the compressed length state, it allows for the conduit to be stretched and bent without pulling on the braid. When correctly assembled, the braid should be as per Fig.1. along the entire length of the conduit.

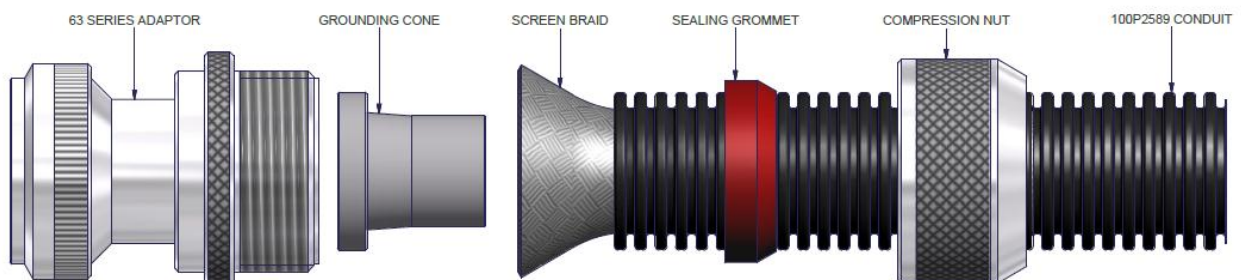


**FIGURE 1**  
 SCREEN BRAID CORRECTLY INSTALLED  
 FILLING CONDUIT ALONG ENTIRE LENGTH



**FIGURE 2**  
 SCREEN BRAID INCORRECTLY INSTALLED  
 NOT FILLING CONDUIT ALONG ENTIRE LENGTH

Arrange the components as per Fig.3. with the screen braid slightly opened up.

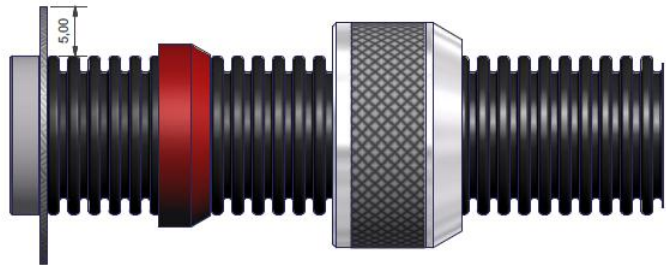
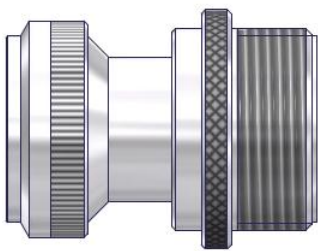


**Figure 3**

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|                                       |              |                |                         |
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Step 2.



**Figure 4**

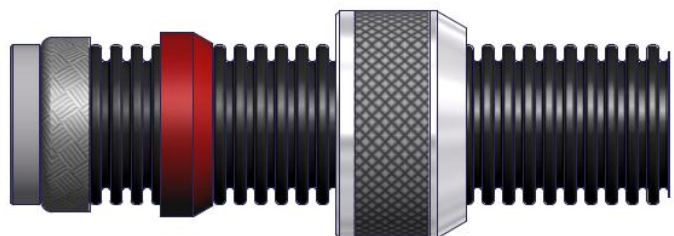
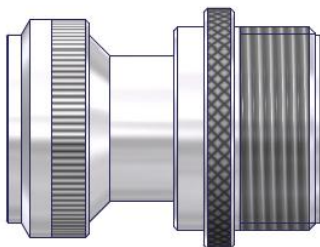
Insert the grounding cone to the opening in the conduit and trim the braid to leave approximately 5mm around the entire circumference, as shown in Fig.4. and Fig.5.



**Figure 5**

Step 3.

Fold the excess screen braid back over the top of the conduit.



**Figure 6**

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Step 4.

Fully insert the conduit into the adaptor, ensuring that the grounding cone is seated against the back face. Slide the sealing grommet up the conduit until it is located as shown in Figure 7, as close as possible to the back of the shell, but not touching.

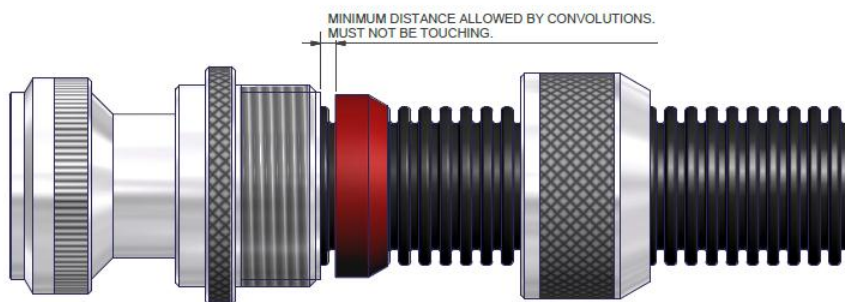


Figure 7

Step 5.

Screw the compression nut onto the thread on the back of the shell and hand-tighten. If bonding, apply adhesive compound to sealing grommet and thread as required before mating.

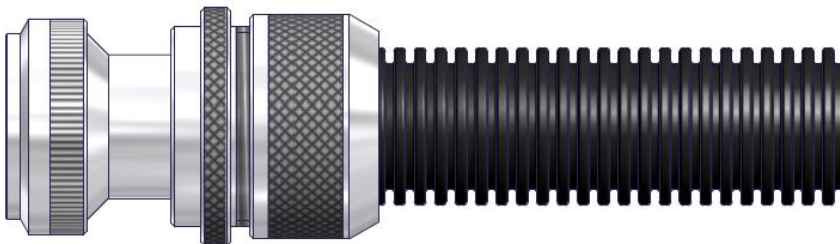


Figure 8

Key points

- Ensure the braid is correctly installed inside the conduit, as seen in figure 1. This is because otherwise when the conduit is bent or pulled, the tension may detach the braid from the grounding cone and affect continuity in the assembly.
- Make sure sealing grommet is positioned correctly before compression nut is tightened as the gap allows pressure to be applied to the grounding cone to ensure sufficient contact with the backshell. Positioned too far up the conduit, it will not create a seal against the backshell.