

ALK-L823

Airport Lighting Connector Protection for FAA Type L-823 Plug and Receptacle Cable Connectors

General Instructions

Suggested Installation Equipment (not supplied with kit)

- Cable preparation tools
- Raychem P63 cable preparation kit or cable manufacturer approved solvent
- Clean, lint-free cloths
- Raychem recommended torch or heat gun

Recommended Raychem Torches

Install heat-shrinkable cable accessories with a "clean burning" torch, i.e., a propane torch that does not deposit conductive contaminants on the product.

Clean burning torches include the Raychem FH-2609, FH-2629 (uses refillable propane cylinders) and FH-2616A1 (uses disposable cylinder).

Safety Instructions

Warning: When installing electrical power system accessories, failure to follow applicable personal safety requirements and written installation instructions could result in fire or explosion and serious or fatal injuries.

To avoid risk of accidental fire or explosion when using gas torches, always check all connections for leaks before igniting the torch and follow the torch manufacturer's safety instructions.

To minimize any effect of fumes produced during installation, always provide good ventilation of confined work spaces.

Adjusting the Torch

Adjust regulator and torch as required to provide an overall 12- inch bushy flame. The FH-2629 will be all blue, the other

torches will have a 3- to 4-inch yellow tip. Use the yellow tip for shrinking.

Regulator Pressure

FH-2616A1	Full pressure
FH-2609	5 psig
FH-2629	15 psig

Cleaning the Cable

Use an approved solvent, such as the one supplied in the P63 Cable Prep Kit, to clean the cable. Be sure to follow the manufacturer's instructions. Failure to follow these instructions could lead to product failure.

Some newer solvents do not evaporate quickly and need to be removed with a clean, lint-free cloth. Failure to do so could change the volume resistivity of the substrate or leave a residue on the surface.

Please follow the manufacturer's instructions carefully.

General Shrinking Instructions

- Apply outer 3- to 4-inch tip of the flame to heat-shrinkable material with a rapid brushing motion.
- Keep flame moving to avoid scorching.
- Unless otherwise instructed, start shrinking tube at center, working flame around all sides of the tube to apply uniform heat.

To determine if a tube has completely recovered, look for the following, especially on the back and underside of the tube:

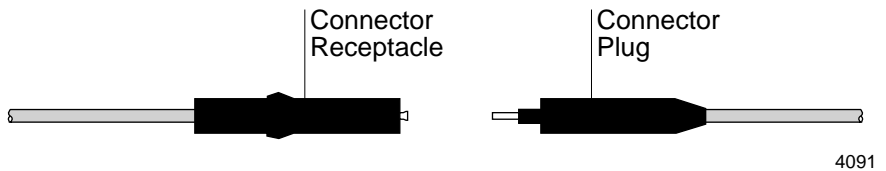
1. Uniform wall thickness.
2. Conformance to substrate.
3. No flat spots or chill marks.
4. Visible sealant flow if the tube is coated.

Note: When installing multiple tubes, make sure that the surface of the last tube is still warm before positioning and shrinking the next tube. If installed tube has cooled, re-heat the entire surface.

Installation Instructions

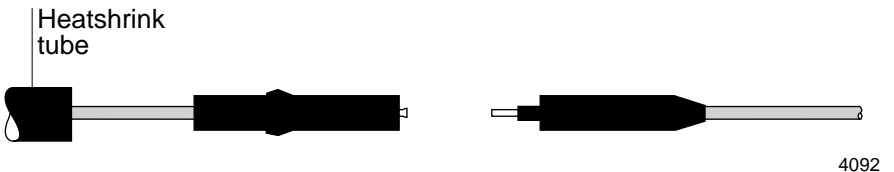
1. Prepare cable; install connector.

Prepare cable and install connector per manufacturer's instructions.



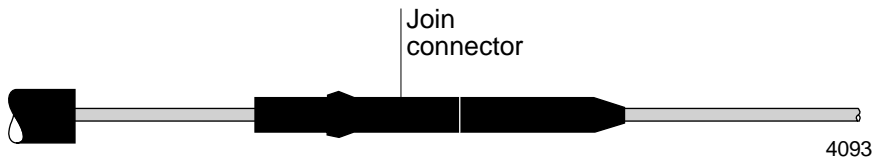
2. Position tube.

Slide tube over one lead and position as shown.



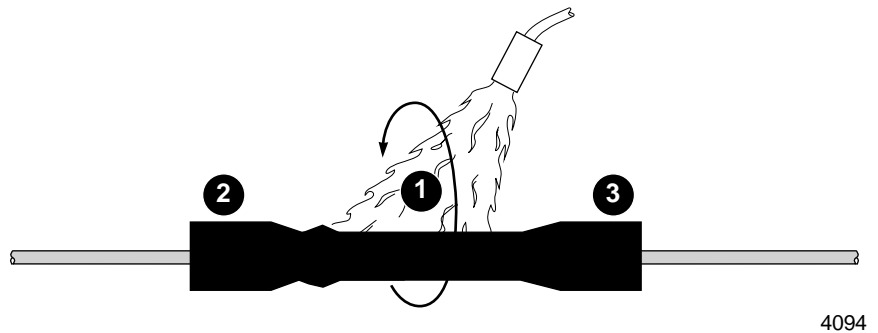
3. Join connector halves.

Connect connector halves as shown.



4. Position tube and shrink.

Shrink tube using a heat gun or torch. Center tube over splice. Working the torch with a smooth brushing motion around the tube, begin shrinking at the center of the tube (1). After center area shrinks, work torch as before toward one end (2), then to the opposite end (3) until completely recovered.



Apply heat until the heat-sensitive paint is completely converted.

5. Inspect completed splice.

Properly installed tube will be smooth and conform to the connection. Adhesive will be visible at both ends.

