NOTES:
1. REMOVE ALL BURRS & SHARP EDGES.

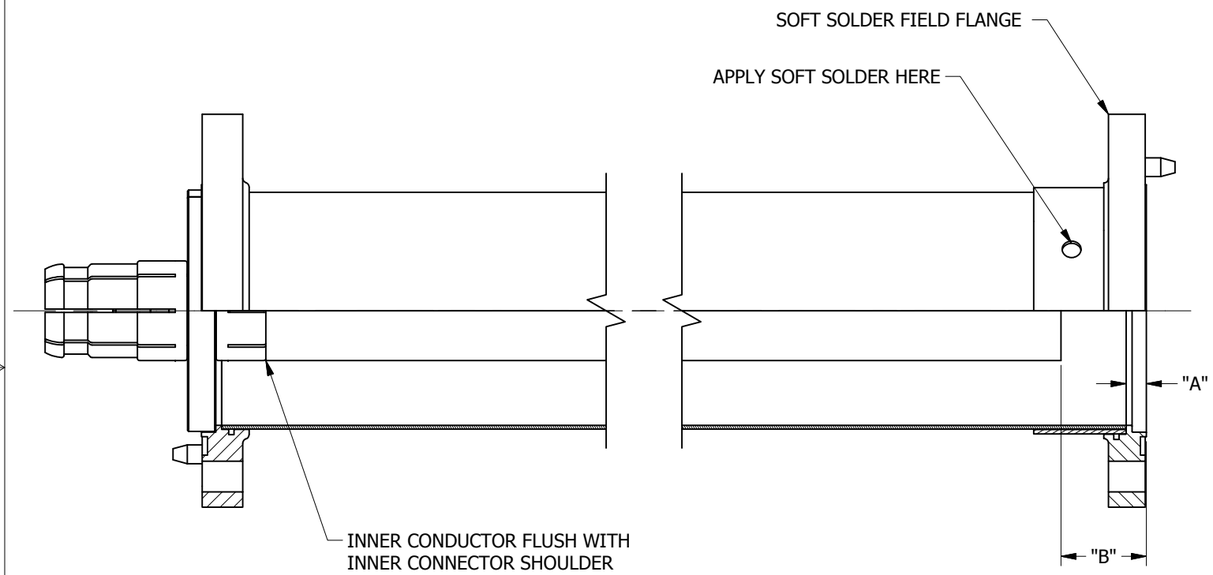

FIGURE 1

TABLE 1		
SOFT SOLDER FIELD FLANGE KIT	DIMENSION "A", in. (mm)	DIMENSION "B", in. (mm)
RLA000-37 (1560A)	11/64 (4.4)	3/4 to 13/16 (18.9 to 20.5)
RLA100-37 (1561A)	13/64 (5.2)	7/8 to 15/16 (22.0 to 23.6)
RLA300-37 (ACX350-37)	17/64 (6.7)	1-1/8 to 1-3/16 (28.6 to 30.2)
RLA400-37	3/8 (9.5)	1-1/2 to 1-9/16 (37.6 to 39.2)
RLA600B-37 (50 & 75 Ohm)	7/16 (11.1)	1-1/2 to 1-9/16 (38.1 to 39.2)
RLA700-37	11/32 (8.9)	1-19/32 to 1-21/32 (40.4 to 42.0)
RLA800B-37	1/2 (12.7)	1-27/32 to 1-29/32 (46.8 to 48.4)

Soft Solder Field Flange Kits

For Rigid Coaxial Transmission Lines

Types RLA000-, RLA100-, RLA300-, RLA400-, RLA600B-, RLA700-, & RLA800B-37

The Soft Solder Field Flange kits in this series are designed for use with Standard rigid coaxial transmission line. They may also be used with MACXLine®, but the cutback dimensions must be taken from MACXLine® Bulletins. The kit includes a fixed ring, a flange and rosin core solder or solder with flux.

1. After determining the exact length of transmission line required, deduct the "A" dimension to allow for the flange. This is the cut length. Twice the flange allowance should be deducted if both ends of the transmission line are to be flanged. Remove the inner conductor to protect it from damage. Refer to Figure 1 and Table 1.
2. Scribe a line completely around the outer conductor tubing at the cutting point to help make a square cut. Wrap a sheet of straight-edged paper around the tubing at the cutting point to aid in scribing or use a hose clamp as a guide.
3. Cut the tubing with a hacksaw. Do not use a tube or pipe cutter, as the cut edge of the tubing will be forced inward and become unsatisfactory electrically. Make certain that the cut is square to permit the fixed ring of the flange adapter to seat properly. A plumber's cutting box, if available, should be used to guide the hacksaw. After cutting, remove all burrs and clean the end of the tubing with garnet cloth (non-carbon sandpaper). Do not use emery cloth or steel wool. Keep all foreign matter from entering the tubing. Note: Fill the inside of tube with rags prior to cutting and remove after cleaning the cut edge.
4. Place the flange adapter onto the tube. Add rosin flux to the cleaned area of tubing and inside the flange adapter. Fit the adapter over the tubing, making certain the flange shoulder is flush against the end of the tubing.
5. Use soft solder and suitable flame-type heat source. Solder the flange adapter to the tubing with even heat the around the adapter to permit even flow of solder. Wipe away any solder that may appear inside the tubing. After soldering and cooling, clean all excess flux from the assembly with hot water. Then clean the assembly with garnet cloth and finish with a solvent wipe.
6. The inner conductor must be "B" dimension shorter than the outer conductor when the inner conductor is fully seated on the inner connector on the far end of the line section and the fixed ring has been installed on the near end. The "B" dimension allows for thermal expansion. See Table 1 and Figure 1. After cutting the inner conductor to the proper length, using the scribing, cutting and cleaning procedure in the previous steps, replace the inner conductor and assemble the transmission line.

NOTICE

The installation, maintenance, or removal of antenna systems requires qualified, experienced personnel. Antenna systems should be inspected once per year by qualified personnel to verify proper installation, maintenance, and condition of equipment. ERI DISCLAIMS LIABILITY OR RESPONSIBILITY FOR THE RESULTS OF IMPROPER OR UNSAFE INSTALLATION PRACTICES.

For Technical Support contact ERI at 877 ERI-LINE (toll-free), +1 812 925-6000 (international), or www.eriinc.com (online).

All designs, specifications, and availabilities of products and services presented in this publication are subject to change without notice.

AISC CERTIFIED FABRICATOR

THIRD ANGLE PROJECTION

MATERIAL

FINISH

TOLERANCES
OVERALL-NOT CUMULATIVE
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND APPLICABLE AT 20°C (68°F)
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994

1 PLACE DECIMAL ± .1
2 PLACE DECIMAL ± .03
3 PLACE DECIMAL ± .010
ANGULAR ± .5°
FRACTIONAL ± 1/16"

PROJECT NO.		
ERI APPROVAL	NAME	DATE
DRAWN BY	DLB	12/9/2015
DRAFTING	K. SCHARP	12/9/2015
DESIGN MGR.	B. HARLAND	12/9/2015
ENG.		
MANUF.		
EXT. APPROVAL		
SUPERSEDES PART NO.		
FILE NAME: II23006-SS1.idw		

ELECTRONICS RESEARCH INC.
ESTABLISHED 1943
7777 GARDNER Rd.
CHANDLER, IN
47610-9219
PHONE: (812) 925-6000
FAX: (812) 925-4030

TITLE:
FIELD FLANGE KIT
SOFT SOLDER
RIGID COAXIAL TRANSMISSION LINES

SIZE	CAGE CODE	DWG NO.	REV.
B	OZNS1	II23006-SS1	

SCALE :	WEIGHT:	SHEET:
AS NOTED	N/A	1 OF 1