GLENAIR ASSEMBLY PROCEDURE (GAP134)

Cage Code: 06324	Set Screw Adjustment Procedure for Glenair, Inc. Composite Hex Tools 600-091 and 600-157	Document #: GAP134 Revision: A Page 1 of 4 Bid File #: 18-4008

Table 1: Corresponding Hex Coupling Tool per Backshell Shell Size

Coupling Nut Shell Size		Hex Size Ref	Hex Wrench 600-091	Hex Pliers 600-157
8	9	0.750	600-091-08	600-157-08
10	11	0.875	600-091-10	600-157-10
12	13	1.000	600-091-12	600-157-12
14	15	1.125	600-091-14	600-157-14[1]
16	17	1.250	600-091-16	600-157-16[1]
18	19	1.375	600-091-18	600-157-18[1]
20	21	1.500	600-091-20	600-157-20[1]
22	23	1.625	600-091-22	600-157-22[1]
24	25	1.750	600-091-24	600-157-24[1]
28	-	2.000	600-091-28	-
32	-	2.250	600-091-32	-
36	-	2.500	600-091-36	-
44	-	3.000	600-091-44	-

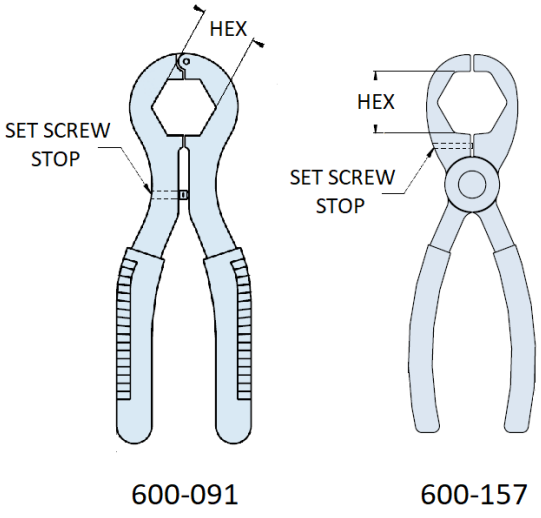

Figure 1: Set Screw Location for 600-091 Hex Wrench and 600-157 Hex Pliers (size 8-12 only)

(1) Set Screw Not Applicable on 600-157 sizes 14-24

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The following procedure shall be followed to correctly set the screw stop on Glenair's 600-091 and 600-157 (if applicable) hex coupling nut installation tools.

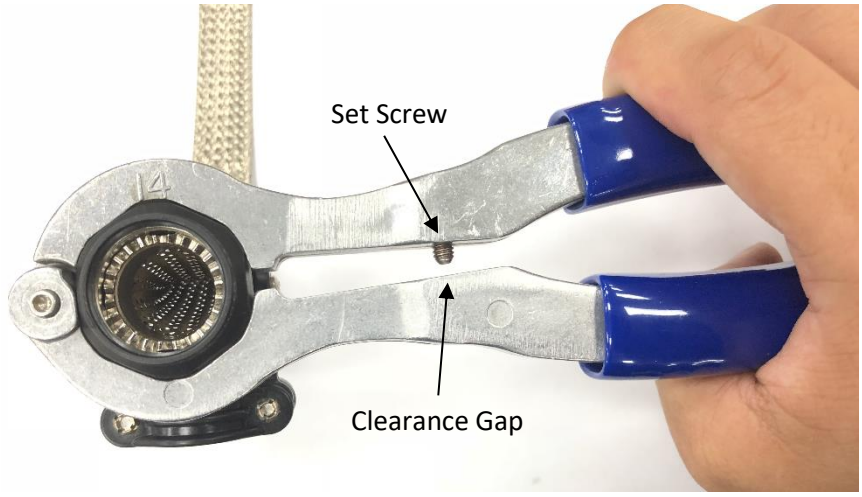
WARNING: FAILURE TO SET TOOL'S SCREW STOP MAY RESULT IN DAMAGE TO BACKSHELL COUPLING NUT DURING INSTALLATION

Tools Required:

- Corresponding backshell for hex tool size
- Hex key (Allen wrench)
  - 600-091 = 5/64"
  - 600-157 – 1/16"
- Medium duty thread locking compound
- Tamperproof thread match marker (recommended)

Procedure:

1. Close tool around hex coupling nut of applicable shell size. Hold backshell in place by applying light pressure to hex tool handles. If necessary, back set screw out to allow for slight gap between hex tool handle using applicable hex key (Allen wrench).



2. If set screw spins freely, apply additional thread locking compound by backing set screw out enough to expose internal threads. Wipe excess threadlocking compound from tool.
   Caution: Do no let threadlocking compound come in contact with backshell coupling nut.

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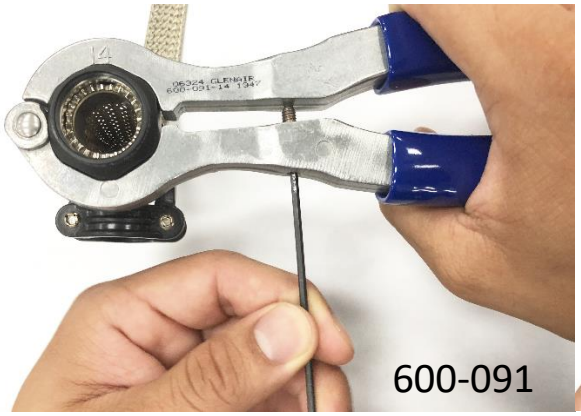
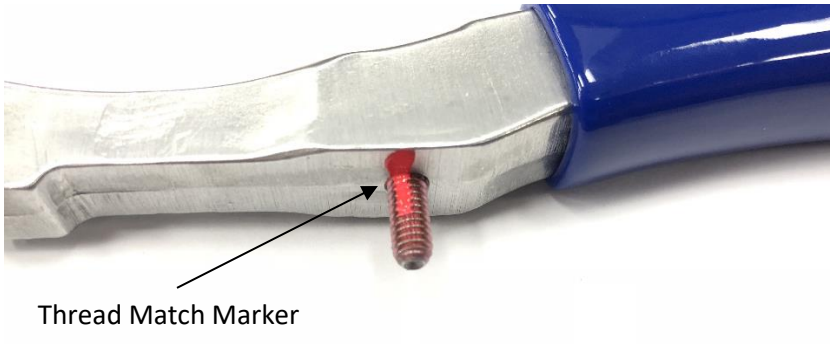
3. While lightly holding backshell in hex portion of tool, slowly spin set screw in towards adjacent tool half. When set screw contacts adjacent half, apply additional quarter turn of set screw to relieve portion of preload.



4. Inspect tool for proper adjustment:
   a. When handles are firmly gripped, tool shall cause no deformation of coupling nut. If deformation occurs, increase set screw depth one quarter turn at a time.
   b. Tool shall exhibit no gaps between tool and backshell on hex gap surface. If gaps are present, back set screw out and restart procedure. If hex flat on tool does not lay flat against coupling nut hex flat, tool shape is excessively worn and should be replaced.
   c. If tool handles exhibit excessive play, rivet joint is worn and tool should be replaced.

5. (Recommended) Apply tamperproof thread match marker to set screw to ensure no changes are made to screw setting during assembly. Tool shall be inspected per Step 4 regularly to verify proper tool setting.



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Revision Record

Revision Status	Description of Change	Date	Approval
A	Released	08/14/18	Z. Taylor