

**Installation Instructions for KDR-610 Series (Primary Connector Kit - Resin Type)**

**Important:**

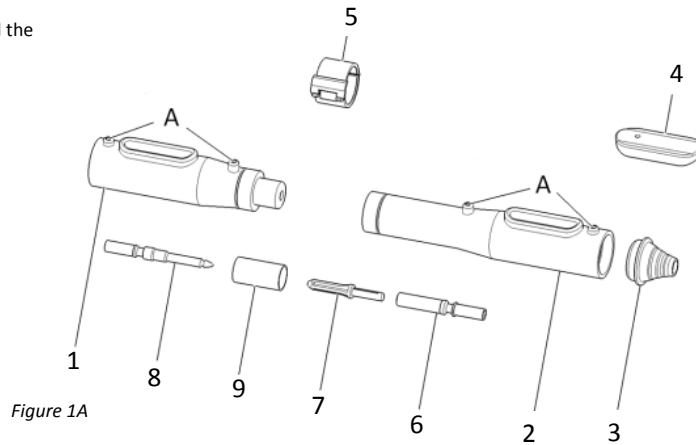
- A. Check that all components are in the plastic bag as per Figure 1A below.
- B. Read carefully through the Safety Instructions baled on the resin bag and prepare yourself accordingly.
- C. Do not open the aluminum bag until after Step 4 of these installation instructions.
- D. In case the resin containing aluminum bag is damaged, has cuts/holes or it is swollen - do not use the resin. Check that the resins last date of use has not expired (mm/yyyy at top right).
- E. Check [www.efla.net](http://www.efla.net) for possible updates of installation instructions.
- F. Note: Installation temperature range is +5 C to +45 C. Stacking temperature range is +10 C to +40 C.

Disconnect voltage supply and ground all circuits. *FAA advisory circulars standards: latest AC150/5340-26 and AC150/5370-10.* In case of non-compliance do not install.

EFLA type (Screened Cable)	EFLA type (Unscreened cable)	FAA L-823	Conductor Size Options	Cable Diameter
KDR600	KDR610	Style 3, Style 10	6mm <sup>2</sup> (AWG 8., up to 19 strands)	9 – 19mm
KDR600.2	KDR610.2	Style 3, Style 10	6mm <sup>2</sup> (AWG 6, 16mm <sup>2</sup> stranded)	9 – 19mm

**Contents:** Resin Bag (resin + hardener), Gloves, Sandpaper, Installation instructions, 2 strips of self-vulcanizing tape and the components labeled in figure 1A below.

- 1. Plug elastomer housing (male)
- 2. Receptacle elastomer housing (female)
- 3. End cap (x2)
- 4. Protective cap (x2)
- 5. Locking device
- 6. Socket
- 7. Guiding pin (plastic)
- 8. Metal pin
- 9. Plastic gauge
- A. Air holes

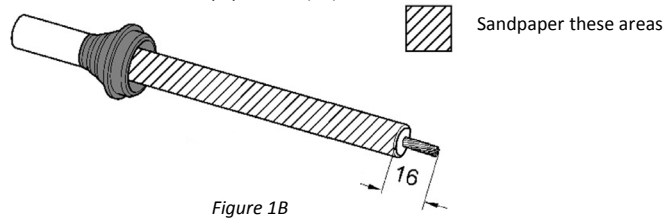


**KDR600 ASSEMBLY**

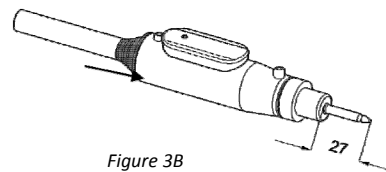
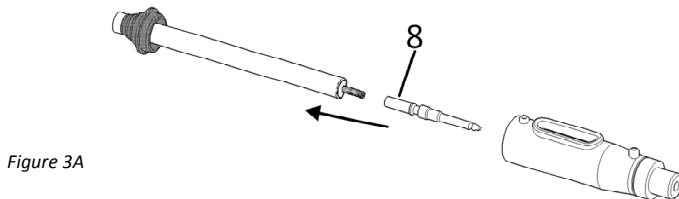
**Step 1:** Cut cable and pass it through the end cap component. See ABCD dimensions table (1A) for cutting options. Strip cable shield layers by dimensions shown in figure below (1B) and for proper resin adhesion, roughen cable insulation with sandpaper as in (1B).

Table 1A

LETTER	CABLE Ø mm
A	8,00 – 10,50
B	10,30 – 13,00
C	13,00 – 15,50
D	15,50 – 19,00



**Step 2:** Use tool e.g. Elpress 4099 and crimp the metal pin to the cable's conductor with a proper crimping tool (3A). Place assembled piece inside the plug elastomer housing and secure end cap to housing (3B). Make the inner surfaces of the two housings free from foreign particles and moisture before pouring the resin (Step 4). Verify the nominal dimension 27 mm using the plastic gauge, tolerance area 26,6 – 27,3 mm in figure 3B.



**Liability for defects**

This product will perform within the recommended operational ratings when installed and operated in accordance with these instructions.

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**Step 3:** Repeat similar procedure of **Steps 1 and 2** above for the other half of the cable. Afterwards, crimp the socket to the cable's core conductor as seen below (4A). Connect plastic guiding pin onto socket before placing assembled piece inside the receptacle elastomer housing. Socket shall be at same level as the bottom of the socket housing; see detail on Fig. 5A. Secure end cap to housing (4B). Verify socket placement using the plastic gauge. Take plastic guiding pin away after assembling.

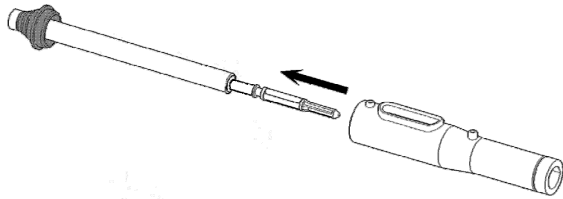


Figure 4A

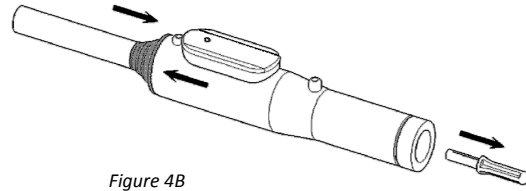


Figure 4B

**Step 4:** Mix resin and hardener according to the illustrated drawings 1 - 7 on the side of the silver resin bag. Take note of "Pot Life" instructions. Place both elastomer housings separately on a horizontally flat surface and completely fill each opening slowly with the mixed resin until resin penetrates through the air holes (5A). Place the protective caps over each filling area with screen conducting wires through each protective cap's hole. WAIT 6 HOURS FOR RESIN TO CURE (HARDEN). Do not bend and make sure that the whole assembly is free from any strain during the 6 hours curing stage.

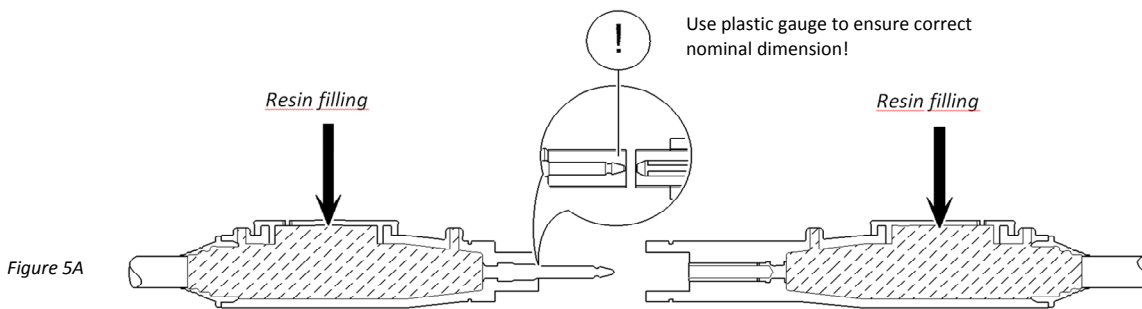


Figure 5A

**Step 5:** After 6 hours curing, connect elastomer housings together and ALWAYS INSTALL THE LOCKING DEVICE (5) in order to avoid separation or bending. (6A) To disconnect, remove the locking device and firmly pull the connectors apart. The plastic guiding is left out of the assembly (6B).

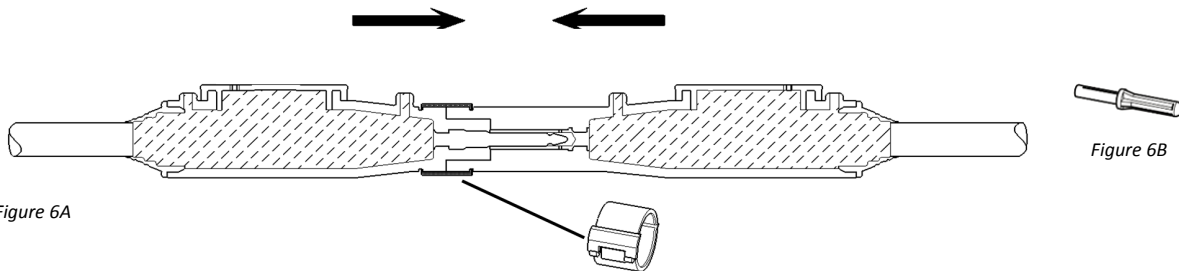


Figure 6A

Figure 6B

The complete assembly is shown below. (6C)

- 10. Cables
- 11. Resin filled areas

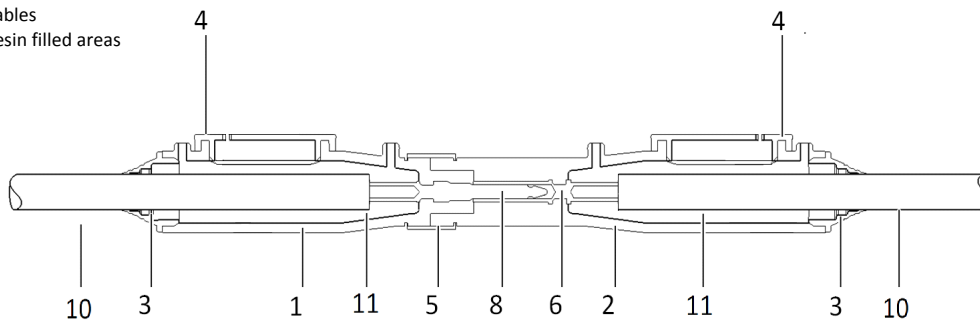


Figure 6C

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