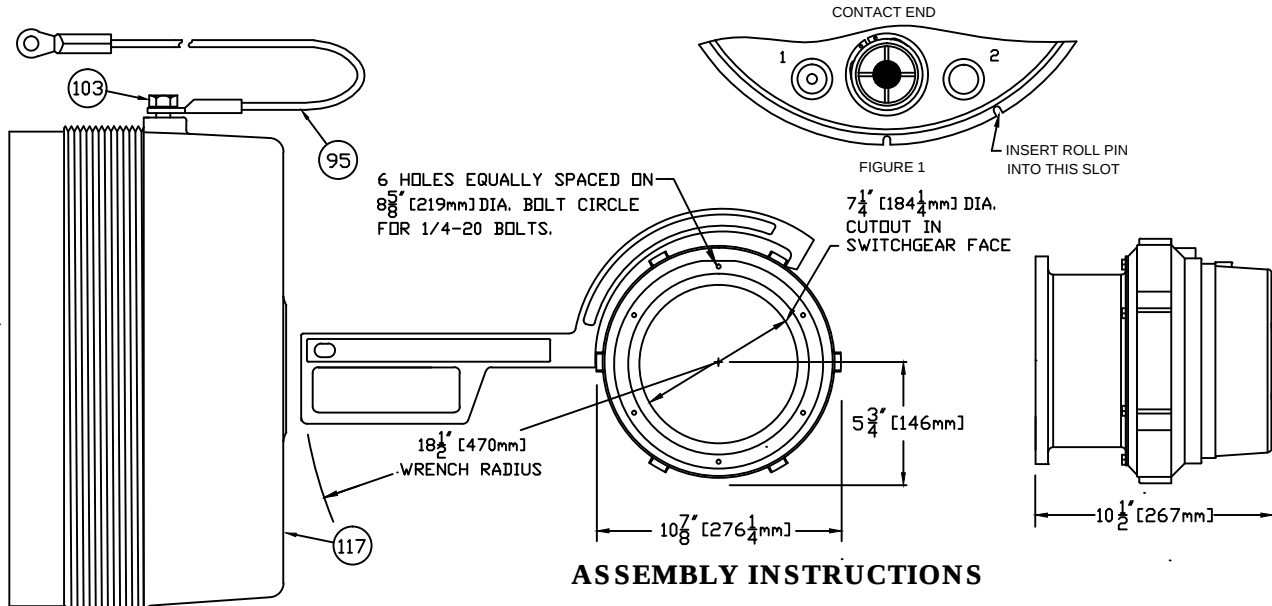
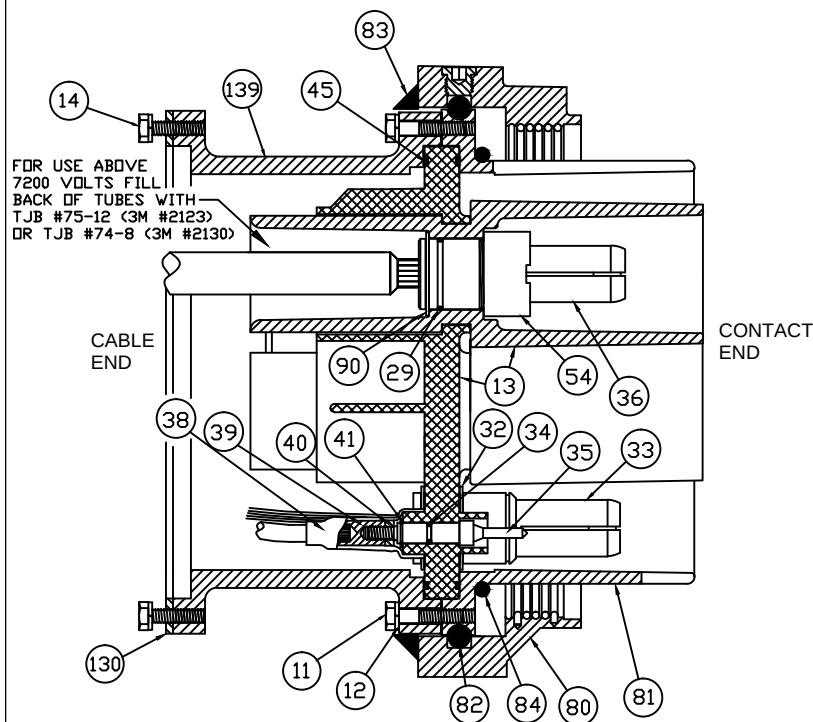




ASSEMBLY INSTRUCTIONS

- 1) LAYOUT AND DRILL THE MOUNTING HOLES AS SHOWN.
- 2) REMOVE 1-1/2" (3.8cm) FROM THE END OF THE PHASE CONDUCTOR INSULATION.
- 3) **PLEASE NOTE: DO NOT INSTALL THE CONTACT RETAINING RINGS BEFORE SOLDERING. WHEN SOLDERING, DO NOT COOL THE CONTACTS WITH WATER AS THIS CAN CAUSE A COLD SOLDER JOINT (HIGH RESISTANCE).**
WHEN SOLDERING BE CAREFUL TO AVOID OVERFLOWING THE SOLDER OR, PRIOR TO SOLDERING, WRAP TEFLON TAPE OVER THE GROOVES ON THE CONTACTS TO PREVENT THE SOLDER FROM GETTING IN THE GROOVES OR USE AN ACID BRUSH TO REMOVE THE SOLDER FROM THE GROOVES WHILE THE CONTACT IS STILL HOT.
- 4) SOLDER ATTACH THE PHASE CONDUCTORS INTO THE PHASE CONTACTS (36) USING (PREFERABLY) 50-50 SOLDER.
- 5) SOLDER ATTACH THE GROUND CONDUCTOR INTO THE GROUND CONTACT (33).
- 6) STRIP 1/2" (1.3cm) OF INSULATION FROM THE GROUND CHECK WIRE AND SOLDER IT INTO THE GROUND CHECK TERMINAL (39) (SOLDER POT).

PLEASE NOTE: THERE ARE TWO TYPES OF CONTACT RETAINING RINGS PROVIDED. THE RING BAGGED SEPARATELY IS STAINLESS STEEL AND IS USED ON THE FRONT (CONTACT END) OF THE GROUND CONTACT.

- 7) INSERT THE PLAIN STEEL RETAINING RINGS (90) INTO THE GROOVE CLOSEST TO THE CONDUCTOR ON BOTH THE PHASE AND GROUND CONTACTS. THEN INSERT THE O-RINGS (29) INTO THE ADJACENT WIDER GROOVE.
- 8) SLIDE THE INSULATOR OVER THE PHASE CONTACTS AND SCREW THE CONTACT NUTS (76) ONTO THE CONTACTS. INSERT THE GROUND CONTACT (33) INTO THE INSULATOR PLATE AND INSTALL THE STAINLESS STEEL RETAINING RING INTO THE GROOVE ON THE CONTACT.
- 9) SLIDE THE SHRINK TUBE (38) BACK OVER THE GROUND CHECK WIRE, THEN WHILE HOLDING THE SOLDER POT IN PLACE, TURN THE GROUND CHECK CONTACT (42) FROM THE FRONT SIDE, THREADING IT INTO THE SOLDER POT UNTIL THE BRASS JAM NUT (40) IS FINGER TIGHT AGAINST THE SOLDER POT. TIGHTEN THE JAM NUT (40) WITH A WRENCH WHILE HOLDING THE GROUND CHECK WITH PLIERS.
- 10) SLIDE THE SHRINK TUBE OVER THE GROUND CHECK EXTENSION ON THE INSULATOR PLATE. THEN, WHILE MAINTAINING SLIGHT PRESSURE ON THE TUBE TO KEEP IT TIGHT AGAINST THE INSULATOR, SHRINK IT INTO PLACE WITH A HEAT GUN OR SMALL FLAME. THE SHRINK TUBE CONTAINS A SEALANT TO PREVENT MOISTURE CONTAMINATION OF THE JOINT.
- 11) WHEN ASSEMBLING THE INSULATOR (13), PLUG BODY (85) AND PLUG FLANGE (139) MAKE SURE TO INSERT THE 1/8" ROLL PINS IN THE PLUG BODY AND ADAPTER FLANGE INTO THE SLOT IN THE INSULATOR AS SHOWN IN FIGURE 1.

ITEM#	QTY.	PART NO.	DESCRIPTION
11	6	183	1/4-20 X 1-1/4" HEX HEAD CAPSCREW
12	12	202	1/4" LOCKWASHER
13	1	200-105BH	MALE INSULATOR ASSEMBLY - RUBBER TUBES
14	6	182	1/4-20 X 1" HEX HEAD CAPSCREW
29	4	228	CONTACT O-RING
32	1	173S	1-1/4" RETAINING RING - STAINLESS STEEL
33	1	B100Y	MALE GROUND CONTACT
34	1	519	GROUND CHECK O-RING
35	1	522/COMP	MALE GROUND CHECK
36	3	B100Y-6	MALE THREADED PHASE CONTACT
38	1	180	3" GROUND CHECK SHRINK TUBE
39	1	135	GROUND CHECK TERMINAL (SOLDER POT)
40	1	177	1/4-20 BRASS JAM NUT
41	1	517	3/8" GROUND CHECK RETAINING RING
45	2	520	INSULATOR O-RING
54	3	240	MALE PHASE CONTACT NUT
80	1	132-SS	PLUG NUT WITH STAINLESS STEEL INSERT
81	1	114-A	PLUG BODY
82	1	184	NYLON BALLS (SET OF 80)
83	1	151	EXTRUDED DUST SEAL
84	1	169	O-RING
90	4	173	1-1/4" RETAINING RING - PLATED STEEL
95	1	171	DUST COVER CABLE
103	1	181	1/4-20 X 5/8" HEX HEAD CAPSCREW
117	1	116A	PLUG DUST COVER
130	1	126S	NEOPRENE GASKET
139	1	211F	SWITCHGEAR FLANGE

NOTE: ALL HARDWARE IS STAINLESS STEEL UNLESS OTHERWISE SPECIFIED

TJB INC.

CATALOG NO. PMG - FH5D

(7-18-13)

TJB INC.