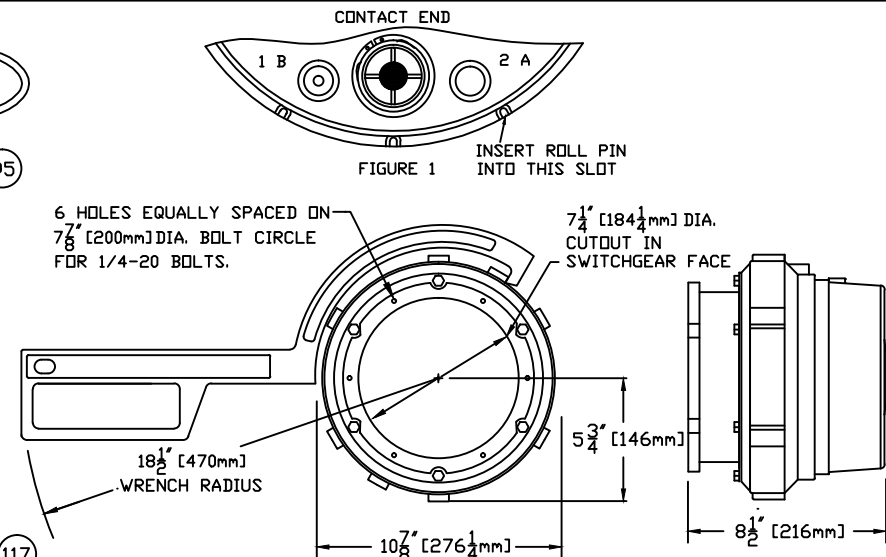
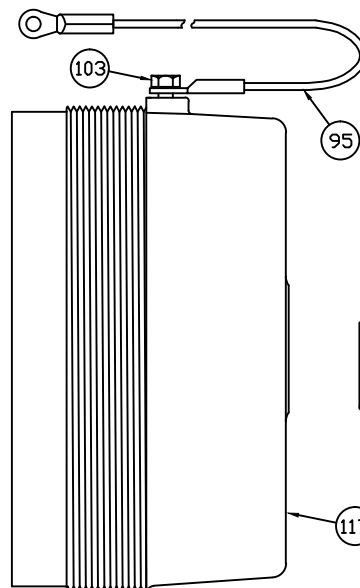
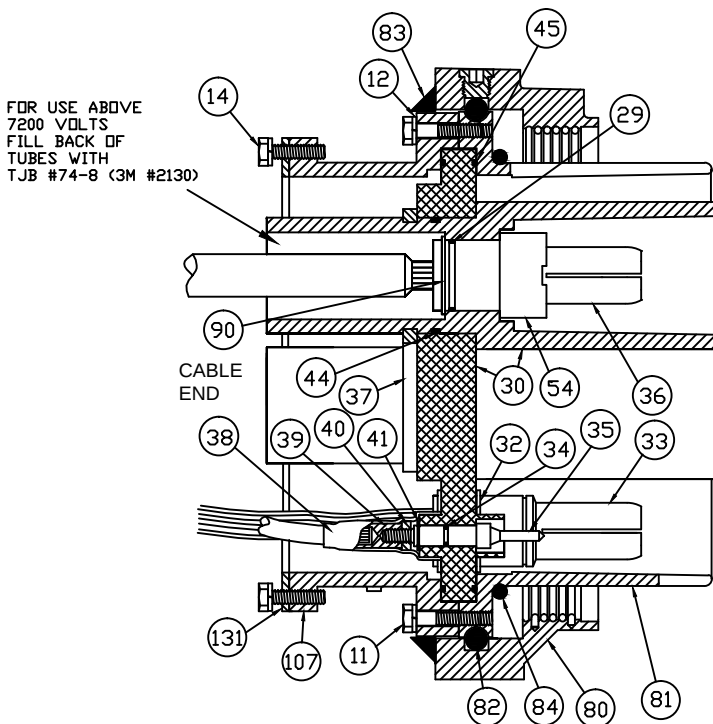




1. Layout and drill the mounting holes as shown.
2. Remove 1-1/2" (38cm) of the insulation from the end of the phase conductor.
3. **DO NOT** install the retaining rings before soldering, the heat will cause the ring to lose its tempering. Prior to soldering, apply Teflon tape to the retaining ring grooves on the back of the contacts to prevent solder from filling in the grooves. An acid brush also can be used to remove solder from the groove while the contact is still hot.
4. Solder attach the phase conductors into the phase contacts (36) using (preferably) 50-50 solder. **DO NOT** cool the contact with water as this may cause a cold solder joint (high resistance).
5. Solder attach the ground lead into the ground contact (33).
6. Strip 1/2" (12.7mm) of insulation from the ground check conductor and solder attach it to the solder pot (39).
7. NOTE: There are two different types of retaining rings provided. The plated steel rings are for use on the cable end of all the contacts. The ring bagged separately is stainless steel and is used on the contact end of the ground contact.
8. On all of three phase contacts and the one ground contact, insert the plated steel retaining rings (90) into the groove nearest the conductor. Then install the o-rings (29) into the wider adjacent groove.
9. Slide the insulator over the phase contacts and thread the contact nuts (54) onto the contacts. Next, insert the ground contact (33) into the insulator plate and install the stainless steel retaining ring (32).
10. Slide the heat shrink tubing (38) back over the ground check conductor. Then while holding the solder pot in place, turn the ground check contact (35) from the front side threading it into the solder pot until the brass nut (40) is finger tight against the solder pot. Tighten the nut (40) with a wrench while holding the solder pot with pliers.
11. Slide the shrink tube forward to seat it over the extended ground check seat on the insulator plate. While shrinking it into place with a heat gun or small flame, put slight pressure on the shrink tube to keep it seated on the insulator plate. The shrink tube contains a sealant to prevent moisture contamination of the joint.
12. Make sure while installing the insulator assembly into the plug body assembly, that the 1/8" roll pin is aligned with the offset slot in the insulator plate as shown in figure 1.

ITEM No.	QTY	PART No.	DESCRIPTION
12	12	202	1/4" LOCKWASHER
14	6	182	1/4-20 X 1" HEX HEAD CAPSCREW
29	4	228	CONTACT O-RING
30	1	300-105T	MALE INSULATOR ASSEMBLY-PITE TUBES
32	1	173S	1-1/4" STAINLESS STEEL RETAINING RING
33	1	E100Y	MALE GROUND CONTACT
34	1	519	GROUND CHECK O-RING
35	1	522	MALE GROUND CHECK CONTACT
36	3	E100Y-6	THREADED MALE PHASE CONTACT
37	3	574	RETAINING RING-INSULATOR TUBE
38	1	180	GROUND CHECK HEAT SHRINK TUBE
39	1	135	GROUND CHECK TERMINAL (SOLDER POT)
40	1	177	1/4-20 HEX BRASS JAM NUT
41	1	517	3/8" GROUND CHECK RETAINING RING
44	3	584	COMPOUND O-RING
45	2	520	INSULATOR O-RING
54	3	240	MALE CONTACT NUT-PHASE
80	1	132-SS	THREADED RING 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" CONTACT RET. RING-PLATED STEEL
95	1	171D	2-1/2 FOOT COVER CABLE
103	1	181	1/4-20 X 5/8" HEX HEAD CAPSCREW
107	1	118	PLUG SWITCHGEAR FLANGE
117	1	116A	8-PITCH PLUG DUST COVER
131	1	126P	NEOPRENE GASKET