

FOR USE ABOVE
7200 VOLTS
FILL BACK OF
TUBES WITH
TJB #74-8 (3M #2130)

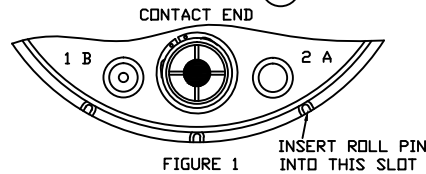
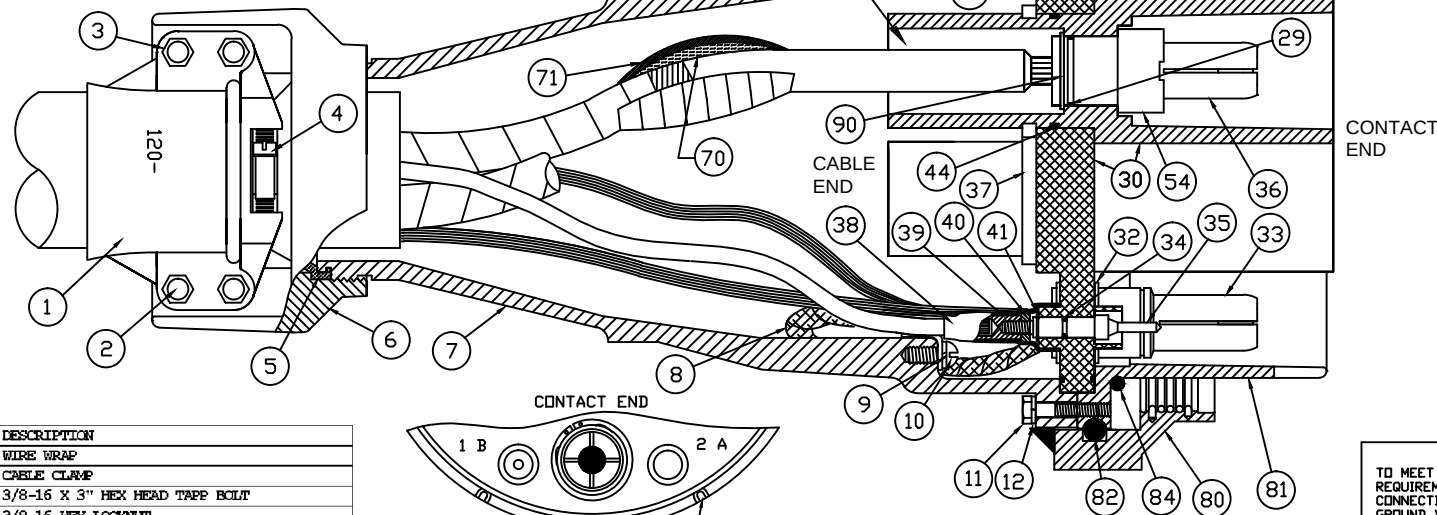


FIGURE 1
INSERT ROLL PIN
INTO THIS SLOT

ITEM No.	QTY	PART No.	DESCRIPTION
XXXX	1	489	WIRE WRAP
1	2	120-	CABLE CLAMP
2	4	167	3/8-16 X 3" HEX HEAD TAPP BOLT
3	4	168	3/8-16 HEX LOCKNUT
4	1	187	STAINLESS STEEL HOSE CLAMP
5	1	123	CABLE SEAL
6	1	112A	END CASTING
7	1	111CL	END BELL
8	1	191	GROUND STRAP WITH TERMINAL
9	1	190A	5/16" LOCKWASHER
10	1	190	5/16-18 X 5/8" GROUND SCREW-BRASS
11	6	183	1/4-20 X 1-1/4" HEX HEAD CAPSCREW
12	6	202	1/4" LOCKWASHER
29	7	228	CONTACT O-RING
30	1	300-105T	MALE INSULATOR ASSEMBLY-PTEE TUBES
32	1	173S	STAINLESS STEEL 1-1/4" RETAINING RING
33	1	BL00Y	MALE GROUND CONTACT
34	1	519	GROUND CHECK O-RING
35	1	522	MALE GROUND CHECK CONTACT
36	3	BL00Y-6	MALE THREADED PHASE CONTACT
37	3	574	INSULATOR TUBE RETAINING RING
38	1	180	3" GROUND CHECK INSULATOR 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 PHASE CONTACT NUT
70	1	216B	STRESS RELIEF TAPE
71	1	216A	INSULATING TAPE
80	1	1328S	8-PITCH THREADED RING
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	171	1-1/4" CONTACT RETAINING RING-PLAIN STEEL
95	1	171D	2-1/2" COVER CABLE
103	1	181	1/4-20 X 5/8" HEX HEAD CAPSCREW
117	1	116A	8-PITCH PLUG DUST COVER
198	1	368-4	MODEL TAG

- Remove the end casting (6) from the end bell (7) and slide the end casting over the cable, followed by the hose clamp (4), the cable seal (5) and the end bell.
- Remove 14" (36cm) of the cable jacket as shown in figure 2. Be careful not to cut into the underlying conductors. Fold the ground and ground check wires back and out of the way.
- Remove the shield for 9-1/2" (24cm). Unwrap and remove the semi-con for 1/2" (1.3cm) less.
- Remove 1-1/2" (3.8cm) of the insulation from the end of the phase conductors. Clean the surface of the insulation up to the edge of the semi-con with the solvent and cloth provided.
- PLEASE NOTE: DO NOT install the retaining rings (90) before soldering as the heat will cause the ring to lose its tempering. DO NOT use water to cool the contacts as this could cause a cold solder joint (high resistance). When soldering be careful not to overflow the solder or, prior to soldering, apply Teflon tape to the grooves on the cable end of the contacts to prevent the solder from filling the grooves.
- Solder attach the phase conductors into the phase contacts (36) using (preferably) 50-50 solder.
- Insert the cable ground wires and ground strap (8) (provided in the coupler kit) into the ground contact (33) and solder attach it with the strap positioned so as to be at the bottom of the coupler.
- Slide the heat shrink tube (38) back over the ground check conductor. Strip 1/2" (1.3cm) of insulation from the ground check conductor, and solder attach it to the solder pot (39).
- With the liner side of the tape toward the insulation, apply the first wrap of stress relief tape, over-lapping the factory applied cable shield by 1/2" (1.3cm). Then while stretching the tape 10-15 percent (that would take the original 3/4" (1.9cm) width to 11/16" (1.7cm) wrap toward the contact for a length of 3" (7.6cm). The last wrap should be perpendicular to the conductor. Reverse the slant of the taping and apply a second half-lapped layer back to the starting point. Cut off any excess tape.
- Starting on the cable shield, wrap the insulating tape toward the phase contact using half-lapped wraps pulling the tape tightly. Tape to 1/2"

- Remove the end casting (6) from the end bell (7) and slide the end casting over the cable, followed by the hose clamp (4), the cable seal (5) and the end bell.
- Remove 14" (36cm) of the cable jacket as shown in figure 2. Be careful not to cut into the underlying conductors. Fold the ground and ground check wires back and out of the way.
- Remove the shield for 9-1/2" (24cm). Unwrap and remove the semi-con for 1/2" (1.3cm) less.
- Remove 1-1/2" (3.8cm) of the insulation from the end of the phase conductors. Clean the surface of the insulation up to the edge of the semi-con with the solvent and cloth provided.
- PLEASE NOTE: DO NOT install the retaining rings (90) before soldering as the heat will cause the ring to lose its tempering. DO NOT use water to cool the contacts as this could cause a cold solder joint (high resistance). When soldering be careful not to overflow the solder or, prior to soldering, apply Teflon tape to the grooves on the cable end of the contacts to prevent the solder from filling the grooves.
- Solder attach the phase conductors into the phase contacts (36) using (preferably) 50-50 solder.
- Insert the cable ground wires and ground strap (8) (provided in the coupler kit) into the ground contact (33) and solder attach it with the strap positioned so as to be at the bottom of the coupler.
- Slide the heat shrink tube (38) back over the ground check conductor. Strip 1/2" (1.3cm) of insulation from the ground check conductor, and solder attach it to the solder pot (39).
- With the liner side of the tape toward the insulation, apply the first wrap of stress relief tape, over-lapping the factory applied cable shield by 1/2" (1.3cm). Then while stretching the tape 10-15 percent (that would take the original 3/4" (1.9cm) width to 11/16" (1.7cm) wrap toward the contact for a length of 3" (7.6cm). The last wrap should be perpendicular to the conductor. Reverse the slant of the taping and apply a second half-lapped layer back to the starting point. Cut off any excess tape.
- Starting on the cable shield, wrap the insulating tape toward the phase contact using half-lapped wraps pulling the tape tightly. Tape to 1/2"

NOTE:
TO MEET COMMONWEALTH OF PENNSYLVANIA
REQUIREMENTS THERE MUST BE A SOLDERED
CONNECTION ATTACHING THE SHIELD TO THE
GROUND WIRES.
WIRE FOR THIS CONNECTION IS PROVIDED IN
THE COUPLER KIT.