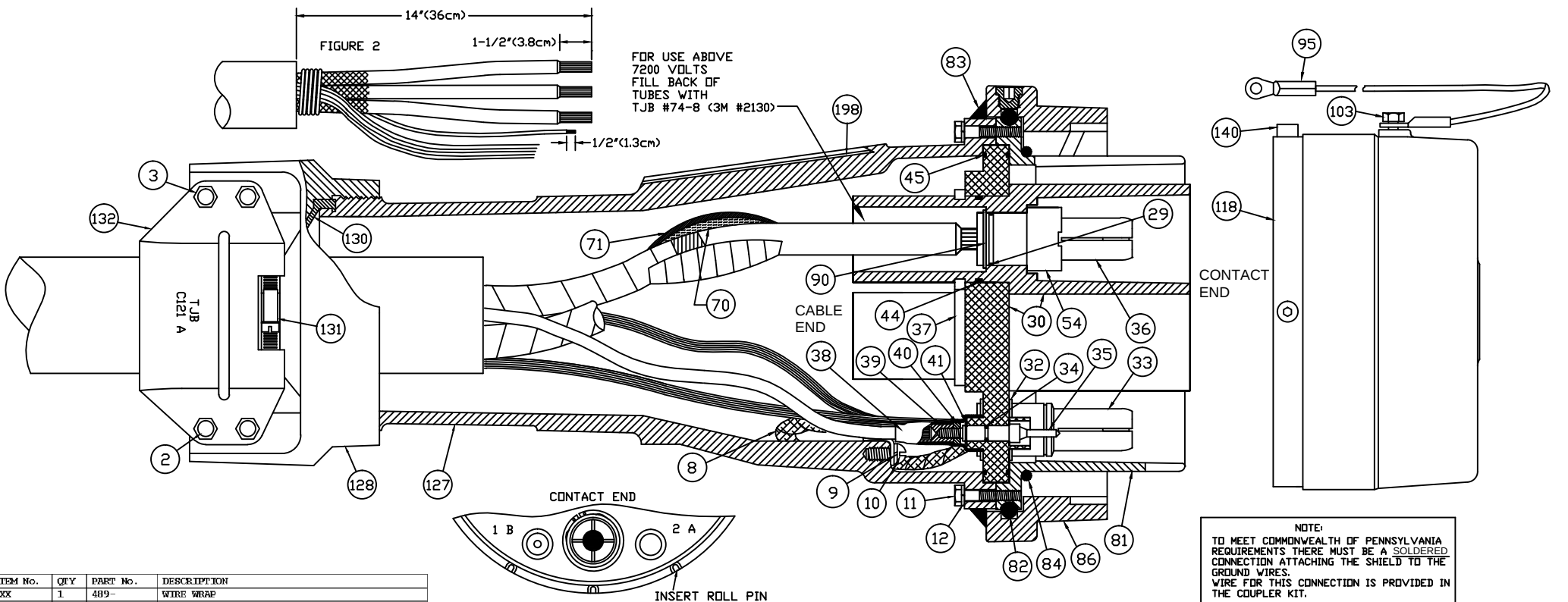




ITEM No.	QTY	PART No.	DESCRIPTION
XXX	1	409-	WIRE WRAP
2	4	167	3/8-16 X 3" HEX HEAD TAPP BOLT
3	4	168	3/8-16 HEX LOCKNUT
8	1	191	GROUND STRAP WITH TERMINAL
9	1	190A	5/16" LOCKWASHER
10	1	190	5/16-18 X 5/8" GROUND SCREW-BRASS
11	6	183	1/4-20 X 1-1/4" HEX HEAD CAPSCREW
12	6	202	1/4" LOCKWASHER
29	4	228	CONTACT O-RING
30	1	300-105T	MALE INSULATOR ASSEMBLY-PTFE TUBES
32	1	173S	1-1/4" STAINLESS STEEL RETAINING RING
33	1	B100Y	MALE GROUND CONTACT
34	1	519	GROUND CHECK O-RING
35	1	522	MALE GROUND CHECK CONTACT
36	3	B100Y-6	THREADED MALE PHASE CONTACT
37	3	574	INSULATOR TUBE RETAINING RING
38	1	180	3" GROUND CHECK INSULATOR TUBE
39	1	135	GROUND CHECK TERMINAL
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
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
86	1	217-THD	NO-THREAD RING - HEAVY DUTY TYPE
90	4	171	1-1/4" CONTACT RETAINING RING-PLATED STEEL
95	1	171D	2-1/2" COVER CABLE
103	1	181	1/4-20 X 5/8" HEX HEAD CAPSCREW
118	1	116C	NO-THREAD PLUG DUST COVER
127	1	111C2	END BELL (TO 4.25" CABLE DIAMETER)
128	1	139A	END CASTING C2 TYPE TO 4.25" CABLE DIAMETER
130	1	138A	CABLE SEAL C2 TYPE
131	1	187A	STAINLESS STEEL HOSE CLAMP
132	2	121-	LARGE CABLE CLAMP
140	3	185J	NO-THREAD PIN
193	1	368-4	MODEL TAG

- FIGURE 1
INSERT ROLL PIN INTO THIS SLOT
- Remove the end casting (128) from the end bell (127) and slide the end casting over the cable, followed by the hose clamp (131), the cable seal (130) 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) (provide 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"

- (1.3cm) past the stress tape then reverse the slant and tape until it is used up. The last turn should be applied un-stretched and pressed tight to seal.
- THESE ARE TWO TYPES OF CONTACT RETAINING RINGS PROVIDED. THE RING BAGGED SEPARATELY IS STAINLESS STEEL AND IS USED ON THE CONTACT END OF THE GROUND CONTACT.
 - Insert the plated steel retaining rings (90) into the ground and phase contacts in the groove closest to the cable end of the contact. Insert the o-rings (29) into the adjacent wider groove.
 - Slide the insulator over the phase contacts and thread the contact nuts (54) onto the contacts. Insert the ground contact into the insulator plate and apply the stainless steel retaining ring (32).
 - While holding the solder pot (39) in place, turn the ground check contact (35) from the front side threading it into the solder pot until the jam nut (40) is finger tight against the solder pot. Then tighten the nut (40) with a wrench while holding the solder pot with pliers. Slide the shrink tube over the ground check extension on the insulator plate. While shrinking it into place, with a heat gun or small flame, put slight downward 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.
 - Slide the end bell (127) forward far enough to attach the ground strap to the threaded hole inside the end bell and secure the strap using the plated brass screw (10) and lock washer (9) provided. Then, while feeding in the slack ground strap so that it lies against the inner surface of the bell, seat the end bell against the insulator, aligning the roll pin with the slot in the insulator assembly, as shown in figure 1. Align the roll pin in the plug body assembly with the same slot in the insulator and attach the plug body assembly to the end bell using the 1-1/4" bolts (11) and lock washers (12) provided.
 - Slide the cable seal (130) into position so that the lip fits into slot on the end bell. Thread the end casting (128) onto the end bell and hand-tighten. Loosely attach the cable clamps (132). Turn the hose clamp (131) so that the screw is accessible in the window on the cable clamp, and tighten the hose clamp on the cable seal to form a tight seal on the cable. Tighten the clamp bolts (2) and nuts (3) on the cable clamps so that the cable is centered in the bell and properly clamped. THE CLAMPS DO NOT HAVE TO BE TIGHTENED ALL THE WAY TO THE END CASTING!