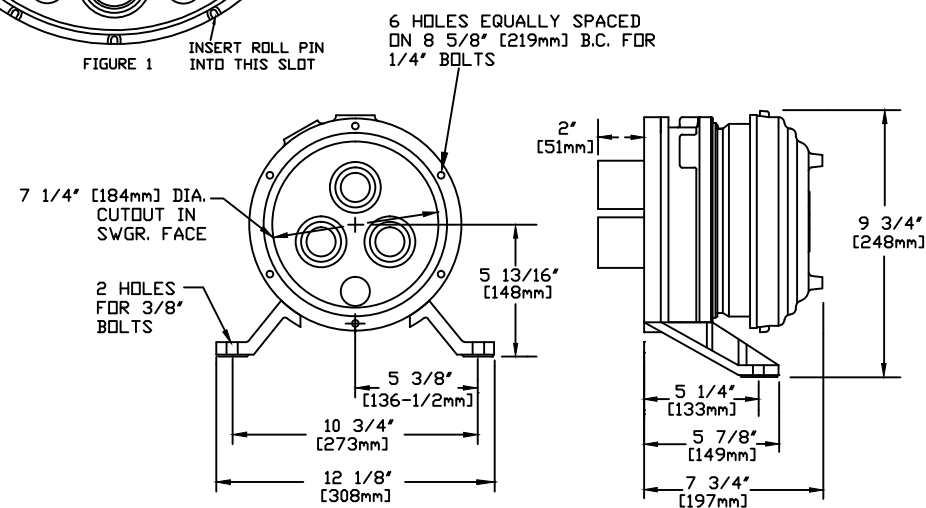
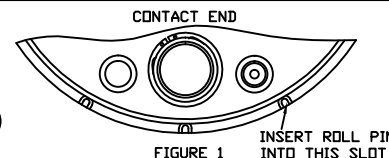
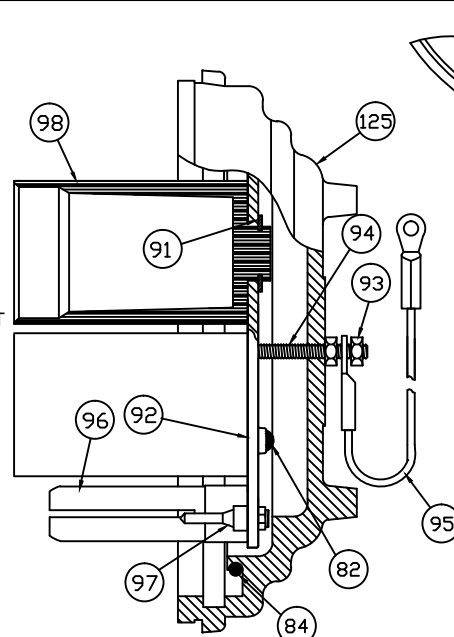
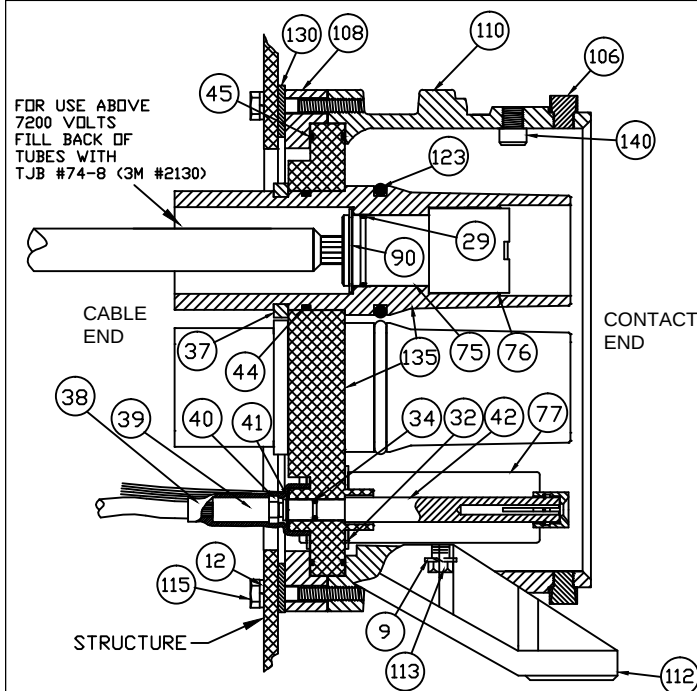




- Layout and drill the mounting holes as shown.
- Remove 1-1/2" (38mm) of the insulation from the end of the conductor.
- DO NOT INSTALL THE RETAINING RINGS BEFORE SOLDERING**
- When soldering be careful not to overflow the solder.** Prior to soldering, apply Teflon tape to the grooves on the back of the contacts to prevent solder from filling in the grooves, or use an acid brush to remove the solder from the groove while the contact is still hot.
- Solder attach the phase conductors into the phase contacts (75) using (preferably) 50-50 solder. **DO NOT** cool the contact with water as this may cause a cold solder joint (high resistance).
- Solder attach the ground lead into the ground contact (77).
- Strip 1/2" (13cm) of insulation from the ground check conductor and solder attach it to the solder pot (39)
- On all three phases and the one ground contact, install the plated steel retaining rings (90) into the groove closest to the conductor, then insert the o-rings (29) into the second wider groove.
- Slide the insulator over the phase contacts and thread the nuts (76) onto the contacts. Next insert the ground contact (77) into the insulator plate and install the stainless steel retaining ring (32).
- Slide the heat shrink tubing (38) over the ground check conductor, 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 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 solder pot and the ground check extension 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.
- Make sure while installing the insulator assembly into the socket body, that the 1/8" roll pin in the socket body is aligned with the slot in the insulator plate as shown in figure 1.

| ITEM No. | QTY | PART No. | DESCRIPTION                             |
|----------|-----|----------|-----------------------------------------|
| X        | 1   | 204      | 1/4-20 X 1 FLAT HEAD SCREW              |
| XX       | 2   | 181      | 1/4-20 X 5/8 HEX HEAD CAPSCREW          |
| 9        | 4   | 190A     | 5/16 LOCKWASHER                         |
| 12       | 7   | 202      | 1/4" LOCKWASHER                         |
| 29       | 4   | 228      | CONTACT O-RING                          |
| 32       | 1   | 173S     | 1-1/4" RETAINING RING - STAINLESS STEEL |
| 34       | 1   | 519      | GROUND CHECK O-RING                     |
| 37       | 3   | 574      | RETAINING RING-INSULATOR TUBE           |
| 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        |
| 42       | 1   | 523/COMP | FEMALE GROUND CHECK ASSEMBLY            |
| 44       | 3   | 584      | COMPOUND O-RING                         |
| 45       | 2   | 520      | INSULATOR O-RING                        |
| 75       | 3   | 101-6    | FEMALE THREADED PHASE CONTACT           |
| 76       | 3   | 241      | FEMALE PHASE CONTACT NUT                |
| 77       | 1   | 143      | FEMALE GROUND CONTACT                   |
| 82       | 3   | 184      | NYLON BALLS                             |
| 84       | 1   | 169      | O-RING                                  |
| 90       | 4   | 173      | 1-1/4" RETAINING RING-PLATED STEEL      |
| 91       | 3   | 581      | C-CLIP                                  |
| 92       | 1   | 582      | INTERLOCK PLATE FOR PTFE CUPS           |
| 93       | 2   | 194      | 1/4-20 HEX STEEL LOCKNUT                |
| 95       | 1   | 171D     | COVER CABLE                             |
| 96       | 1   | 129      | MALE INTERLOCK GROUND CONTACT           |
| 97       | 1   | 140      | MALE INTERLOCK GROUND CHECK CONTACT     |
| 98       | 3   | 580      | PTFE INTERLOCK CUPS                     |
| 106      | 4   | 185R     | NO-THREAD PIN ROLLING TYPE              |
| 108      | 1   | 122      | SOCKET SWITCHGEAR FLANGE                |
| 110      | 1   | 109C     | NO-THREAD SOCKET BODY                   |
| 112      | 1   | 110AR/AL | SOCKET FEET-RIGHT AND LEFT              |
| 113      | 4   | 172      | 5/16-18 X 7/8 HEX HEAD CAPSCREW         |
| 115      | 6   | 174A     | 1/4-20 X 1-3/4 HEX HEAD CAPSCREW        |
| 123      | 3   | 575      | O-RING FOR INSULATOR TUBE               |
| 125      | 1   | 215-I    | N/T SOCKET INTERLOCK COVER              |
| 126      | 1   | 625      | 1/4-20 X 2-1/2 BUTTON HEAD SCREW        |
| 130      | 1   | 126S     | NEOPRENE GASKET                         |
| 135      | 1   | 300-104T | FEMALE INSULATOR ASSEMBLY-PTFE TUBES    |
| 140      | 1   | 185J     | AUTOLIGN PIN                            |