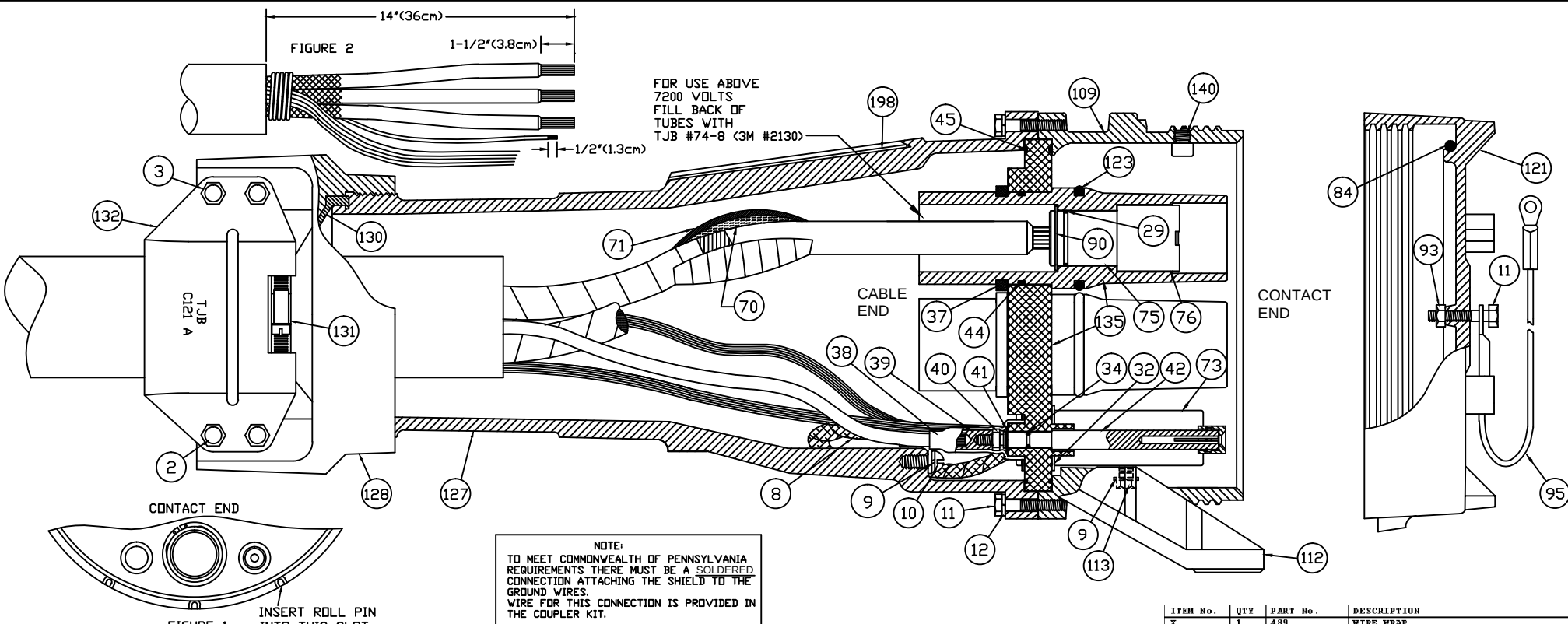




- Remove the end casting (128) from the end bell (127) and slide the end casting back over the cable, followed by the hose clamp (131), the cable seal (130) and finally the end bell.
- Remove 14" (36cm) of the cable jacket as shown in FIGURE 2. Be careful not to cut into the underlying conductors. Fold the ground and ground check wires back out of the way.
- Remove 9-1/2" (24CM) of the shield. 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 included.
- DO NOT install the ground retaining ring (90) before soldering (the heat will cause the ring to lose its tempering).
- Prior to soldering, apply Teflon tape to the grooves on the back of the ground contact to prevent solder from filling in the grooves, or use an acid brush to remove the solder from groove while the contact is still hot.
- Solder attach the phase conductors into the phase contacts (78) using (preferably) 50-50 solder. **DO NOT** cool the contact with water, as this may cause a cold solder joint (high resistance).
- Insert the cable ground wires and ground strap (8) (provided in the coupler kit) into the ground contact (77) and solder attach them with the strap positioned to be at the bottom of the coupler.
- With the liner side of the tape toward the insulation, apply the first wrap of stress relief tape, overlapping 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" (19cm) width to 11/16" (1.74cm)) wrap toward the contact for a length of 3" (76cm). The last wrap should be square/perpendicular with 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 insulating tape toward the 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 down tight with your thumb.

- Slide the heat shrink tubing (38) over the ground check conductor. Strip 1/2" (1.3cm) of the insulation from the ground check conductor, and solder attach it to the solder pot (39).
- PLEASE NOTE: THERE ARE TWO DIFFERENT TYPES OF RETAINING RINGS IN THE COUPLER KIT. THE PLATED STEEL RINGS (90) ARE FOR USE ON THE CABLE END OF THE INSULATOR. THE OTHER ONE IS STAINLESS STEEL AND IS FOR USE ON THE CONTACT END OF GROUND CONTACT.**
- Install the plated steel retaining rings (90) into the groove on the cable end of the phase and ground contacts. Insert the o-rings (29) in the adjacent, wider groove on all the contacts.
- Slide the insulator over the phase contacts and thread the contact nuts (76) onto the contacts. Insert the ground contact (77) into the insulator plate and install the stainless steel retaining ring (32).
- While holding the solder pot (39) in place, turn the ground check contact (42) from the front side, threading it into the solder pot until the nut (40) is finger tight against the solder pot. Tighten the nut with a wrench while holding the solder pot with pliers. Slide the shrink tube (38) forward and seat it over the extension on the insulator plate. While shrinking it into place with a heat gun or small flame, put slight pressure on shrink tube to keep it seated on the insulator plate. The shrink tube contains a sealant to prevent moisture contamination of this joint.
- Slide the end bell (127) forward far enough to attach the ground strap to the threaded hole inside the end bell 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 bell against the insulator aligning the roll pin with the slot in the insulator that is off center as shown in FIGURE 1. Position the socket body by aligning the pin in the same slot and insert and tighten the six screws (11) and lock washers (12).
- Slide the cable seal (130) into position so that the lip fits into the slot on the end bell. Thread on the end casting (128) and hand-tighten. Loosely attach the cable clamps (132). Turn the hose clamp (131) so that a screwdriver can be used to tighten it. Tighten the hose clamp on the cable seal (130) to seal it on the cable. Tighten the cable 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 DOWN ALL THE WAY TO THE END CASTING!**

ITEM No.	QTY	PART No.	DESCRIPTION
X	1	489	WIRE WRAP
XX	1	181	1/4-20 X 5/8 HEX HEAD CAPSCREW
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
8	1	191	GROUND STRAP WITH TERMINAL
9	5	190A	5/16 LOCKWASHER
10	1	190	5/16-18 X 5/8 GROUND SCREW-BRASS
11	7	183	1/4-20 X 1-1/4 HEX HEAD CAPSCREW
12	6	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	TEFLON TUBE RETAINING RING
38	1	180	3" GROUND CHECK INSULATOR 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
42	1	523/COMP	FEMALE GROUND CHECK ASSEMBLY
44	3	584	COMPOUND O-RING
45	2	520	INSULATOR O-RING
70	1	216B	STRESS RELIEF TAPE
71	1	216A	INSULATING TAPE
75	3	101-6	FEMALE THREADED PHASE CONTACT
76	3	241	FEMALE PHASE CONTACT NUT
77	1	143	FEMALE GROUND CONTACT
84	1	169	O-RING
90	4	173	1-1/4" RETAINING RING-PLATED STEEL
93	1	194	1/4-20 HEX STEEL LOCKNUT
95	1	171	2-1/2" FOOT COVER CABLE
109	1	109D	4-PITCH SOCKET BODY
112	1	110AR/AL	SOCKET FEET-RIGHT AND LEFT
113	4	172	5/16-18 X 1/8 HEX HEAD CAPSCREW
121	1	113D	4-PITCH SOCKET DUST COVER
123	3	575	O-RING FOR TEFLON TUBE
127	1	111C2	END BELL (TO 4.25" CABLE DIAMETER)
128	1	139A	END CASTING C2 TYPE TO 4.25" CABLE DIAMETER
129	1	139B	END CASTING C2 TYPE TO 3" CABLE DIAMETER
130	1	139A	CABLE SEAL C2 TYPE
131	1	187A	STAINLESS STEEL HOSE CLAMP (3" TO 4.25")
132	2	121-	LARGE CLAMP
135	1	300-104T	FEMALE INSULATOR ASSEMBLY-TEFLON TUBES
140	1	185J	AUTOLIGN PIN
198	1	368-4	MODEL TAG