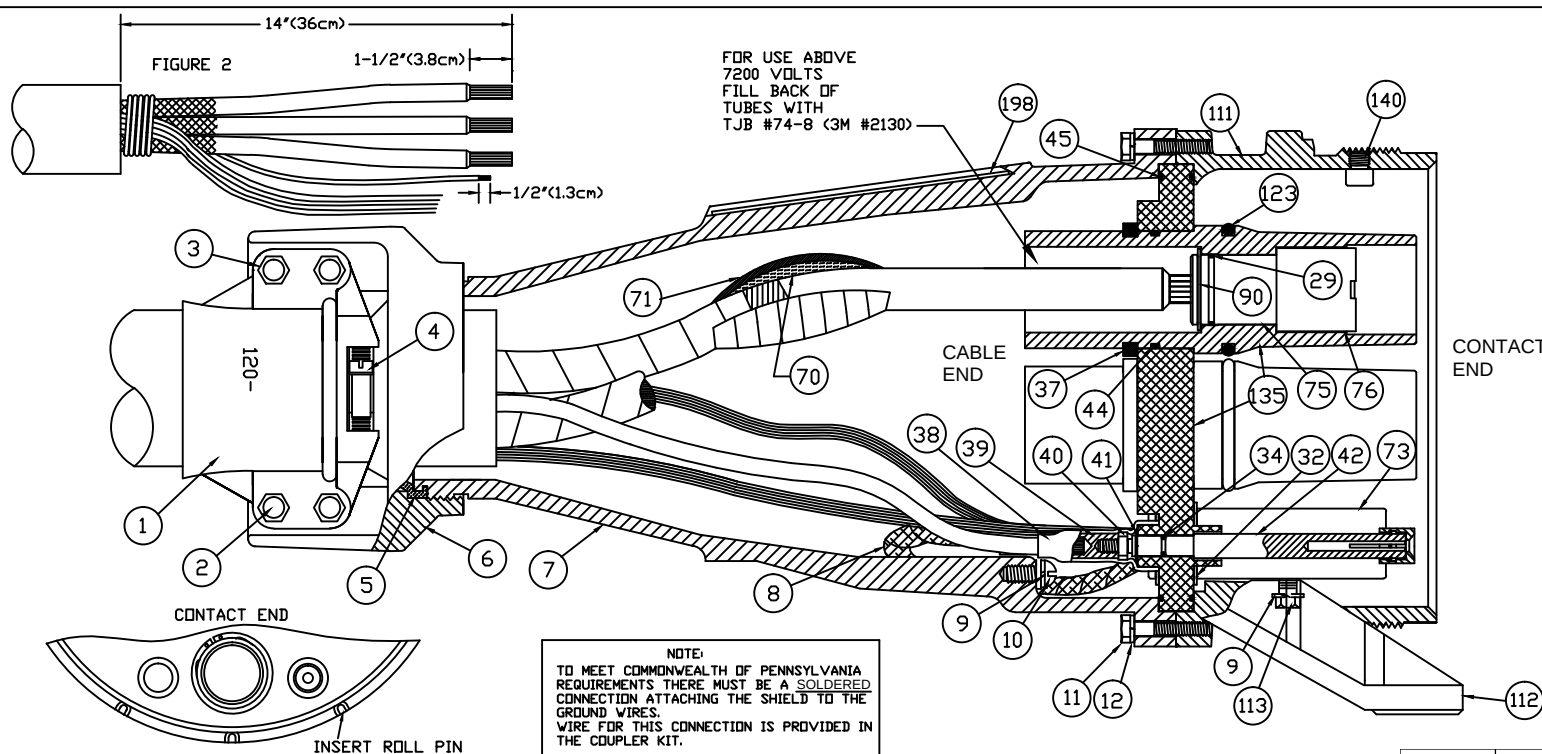


- Remove the end casting (6) from the end bell (7) and slide the end casting back over the cable, followed by the hose clamp (4), the cable seal (5) and finally the end bell.
- Remove 14" (36cm) of the cable jacket as shown in FIGURE 2. Be careful not to cut into the underlying conductors. Fold the ground and ground check wires back 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.
- DO NOT install the contact retaining rings before soldering (the heat will cause the ring to lose its tempering). Prior to soldering, apply Teflon tape to the grooves to prevent solder from filling in the grooves, or use an acid brush to remove solder from the grooves while the contact 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).
- Insert the cable ground wires and the ground strap (8) (provided in the coupler kit) into the ground contact (77) so that the ground strap will be positioned at the bottom of the coupler and solder attach them. Slide the heat shrink tubing (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 overlapping the factory applied cable shield by 1/2" (1.3cm) then, stretching the tape 10-15 percent (that would take the original 3/4" (1.9cm) width to 1 1/16" (1.74cm), wrap toward the contact for a length of 3" (7.6cm). 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. Reverse the slant and tape until it is used up. The last turn should be applied, un-stretched and pressed tight to seal.

- PLEASE NOTE: There are two different 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 groove on the cable end of the phase (75) and ground (77) contacts. Install the o-rings (29) into the adjacent wider groove on both the phase and ground contacts.
- Slide the insulator over the phase contacts and thread the nuts (76) onto the contacts. Then insert the ground contact (77) into insulator plate and attach 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 jam nut (40) is finger tight against the solder pot, then tighten the nut with a wrench while holding the 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 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 (7) 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). Align the roll pin in the socket body with the same slot on the insulator and attach the socket body to the end bell using the 1-1/4" bolts (11) and lock washers (12) provided.
- Seat the lip on the cable seal (5) into the slot on the end bell. Thread the end casting (6) onto the end bell and hand tighten. Slide the hose clamp (4) onto the cable seal and bolt the cable clamps (1) loosely onto the end casting. Position the hose clamp so that the screw is accessible from the window on the cable clamp. Tighten the hose clamp on the cable seal to form a tight seal on the cable. Tighten the bolts and nuts 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 (NOT SHOWN)
XX	1	101	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	107	STAINLESS STEEL HOSE CLAMP
5	1	123	CABLE SEAL
6	1	112A	END CASTING
7	1	111C1	END BELL
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	1	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" COVER CABLE
111	1	109B	8-PITCH SOCKET BODY
112	1	110AR/AL	SOCKET FEET-RIGHT AND LEFT
113	4	172	5/16-18 X 7/8 HEX HEAD CAPSCREW
120	1	113A	8-PITCH SOCKET DUST COVER
123	3	575	O-RING FOR TEFLON TUBE
135	1	300-104T	FEMALE INSULATOR ASSEMBLY-TEFLON TUBES
140	1	185J	AUTOLIGN PIN
198	1	368-4	MODEL TAG