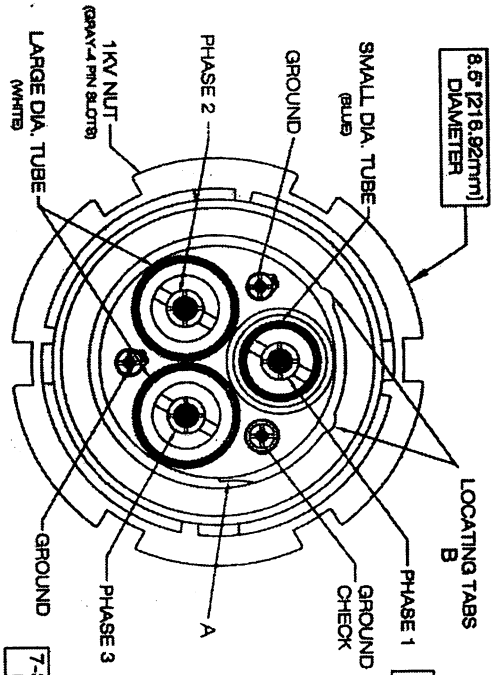
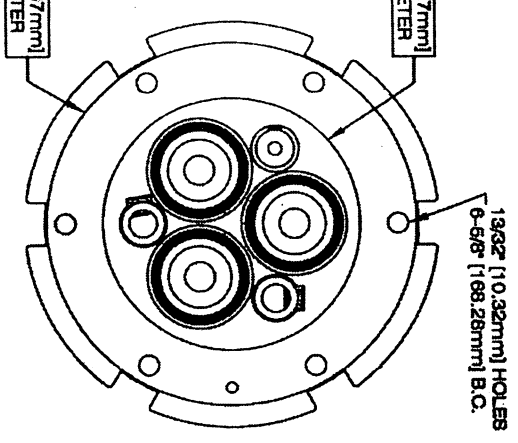


ITEM#	QTY.	PART NO.	DESCRIPTION
82	40	184-40	NYLON BALL BEARING - SET OF 40
83	1	151	DUST SEAL
84	10	314	SET SCREW - SPECIFY SIZE
87	2	342	COPPER SHIELDING TAPE
88	1	942M	GROUND CONTACT RETAINING RING
100	2	181	1/4-20 x 5/8 HCS - STAINLESS STEEL
101	1	171	COVER CABLE ASSEMBLY
103	1	327	INSULATOR RETAINING RING
106	4	185R-COMP	ROLLER PIN AND SLEEVE
107	1	315	1/4-20 x 3/8 SET SCREW - STAINLESS STEEL
130	8	94D	LOCK WASHER STAINLESS STEEL
166	8	424	3/8-18 x 1-1/4 SHCS STAINLESS STEEL
901	1	984D-COMP	LVNT PLUG NUT - 1KV - 4 SLOT
903	3	972-COMP	MALE PHASE CONTACT ASSEMBLY
904	2	973A-COMP	MALE GROUND CONTACT ASSEMBLY
905	1	974A-COMP	MALE GROUND CHECK CONTACT ASSEMBLY
908	3	978-COMP	MALE PHASE CONTACT NUT ASSEMBLY
907	3	984	PHASE CONTACT O-RING
908	1	988	INSULATOR O-RING
909	2	987	MALE GROUND CONTACT O-RING
910	1	988	MALE GROUND CHECK CONTACT O-RING
911	1	989	MALE GROUND CHECK CONTACT RETAINING RING
912	1	980	LVNT PLUG END BELL GASKET
923	1	980P4	LVNT PLUG DUST COVER - 1KV AND 3KV
925	1	368-11	LVNT MODEL TAG - 1KV
928	1	980P-1	WAVE SPRING
929	1	971M1-COMP	MALE INSULATOR ASSEMBLY - 1KV
932	1	981	BALL BEARING ACCESS PLUG FOR 984
933	1	985P99F	LVNT PLUG BODY



CONTACT END VIEW



CABLE END VIEW

TJB INC

CATALOG NO. - PMG1C

(2-4-05)

TJB INC

## ASSEMBLY INSTRUCTIONS

- 1) REMOVE THE INSULATOR ASSEMBLY (929) FROM THE PLUG BODY (933) BY REMOVING THE INSULATOR RETAINING RING (103). THIS IS A SPIRAL TYPE RETAINING RING AND CAN BE REMOVED BY PLACING A SCREWDRIVER UNDER THE THE END OF THE SPIRAL (A) AND LIFTING THE RING.
- 2) REMOVE THE INSULATION FROM THE ENDS OF THE CONDUCTORS AS FOLLOWS: PHASE AND GROUND CONTACTS 1-1/2" (38mm). GROUND CHECK CONTACT 3/4" (19mm). IN ORDER TO PREVENT THE STRANDS FROM FRAYING, FORM A CAP OVER THE ENDS OF THE CONDUCTOR STRANDING WITH THE COPPER TAPE PROVIDED IN THE KIT. THIS CAN BE DONE BY ROLLING A PIECE OF THE COPPER TAPE AROUND THE STRANDING TO FORM A CYLINDER, LEAVING 1/8" [3mm] TO 3/16" [5mm] OF THE CYLINDER EXTENDING OUT OVER THE STRANDING. FOLD OVER THE END OF THE CYLINDER AND TAP IT DOWN TIGHT TO FORM A THIMBLE-LIKE CAP.
- 3) THE PHASE CONTACTS (903) MUST BE REMOVED FROM THE INSULATOR TO INSTALL THE CONDUCTORS. THE GROUNDS (904) AND GROUND CHECK (910) CONTACTS CAN BE LEFT IN THE INSULATOR ASSEMBLY. REMOVE THE PHASE CONTACTS BY UNSCREWING THE THREE CONTACT NUTS (906).

### **IMPORTANT:**

**REMOVE THE O-RINGS (907) FROM THE PHASE CONTACTS BEFORE SOLDERING.**

SOLDER ATTACH THE PHASE CONDUCTORS INTO THE CONTACTS USING PREFERABLY 50-50 SOLDER. **DO NOT COOL THE CONTACTS WITH WATER.** QUENCHING THE CONTACTS CAN CAUSE A COLD SOLDER JOINT AND INCREASE RESISTANCE.

AFTER THE PHASE CONTACTS HAVE COOLED, REPLACE THE O-RINGS AND REINSTALL THE CONTACTS INTO THE INSULATOR. REPLACE THE CONTACT NUTS.

- 4) INSERT THE GROUND CHECK LEAD INTO THE GROUND CHECK (905) AND TIGHTEN THE SET SCREW.
- 5) THE TWO GROUND CONTACTS (904) HAVE BEEN ISOLATED FROM THE SHELL OF THE COUPLER. INSTALL THE GROUND LEADS AS DESIRED AND TIGHTEN THE SET SCREWS.
- 6) INSTALL THE INSULATOR O-RING INTO THE GROOVE IN THE O.D. OF THE INSULATOR PLATE AND APPLY A SMALL AMOUNT OF SILICONE GREASE (PROVIDED) TO THE O-RING TO EASE INSERTION OF THE INSULATOR INTO THE PLUG BODY. INSTALL THE INSULATOR. TAKE CARE TO ALIGN THE TWO LOCATING TABS (B) ON THE INSULATOR WITH THE NOTCHES PROVIDED IN THE PLUG BODY. REPLACE THE INSULATOR RETAINING RING.