



ITEM#	QTY.	PART NO.	DESCRIPTION
XX	1	342	COPPER SHIELDING TAPE
82	40	184-40	NYLON BALL BEARING - SET OF 40
83	1	151	DUST SEAL
87	2	742M	GROUND CONTACT RETAINING RING
100	2	181	1/4-20 x 5/8 HHCS
101	1	171D	COVER CABLE ASSEMBLY
103	1	920	INSULATOR RETAINING RING
106	3	185J	N/T PIN
107	1	315	1/4-20 x 3/8 SET SCREW
130	6	940	LOCK WASHER
166	6	147-A	3/8-16 x 1-1/4 HHCS
901	1	964A-COMP	LVNT PLUG NUT - 480V- 3 SLOT
903	3	937-COMP	MALE PHASE CONTACT ASSEMBLY
904	2	973A-COMP	MALE GROUND CONTACT ASSEMBLY
905	1	974A-COMP	MALE GROUND CHECK CONTACT ASSEMBLY
906	3	978-COMP	MALE PHASE CONTACT NUT ASSEMBLY
907	3	984	PHASE CONTACT O-RING
908	1	986	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 RET. RING
912	1	926	LVNT PLUG O-RING
923	1	823	LVNT PLUG DUST COVER - 480V AND 5KV
929	1	971TMG48-COMP	MALE INSULATOR ASSEMBLY - 480V
932	1	981	BALL BEARING ACCESS PLUG
933	1	826-COMP	LVNT SWITCHGEAR PLUG BODY

NOTE: ALL HARDWARE IS STAINLESS STEEL UNLESS OTHERWISE SPECIFIED

ASSEMBLY INSTRUCTIONS

THE INSULATOR ASSEMBLY MUST BE REMOVED FROM THE PLUG FLANGE FOR CONDUCTOR INSTALLATION

REMOVE THE INSULATOR ASSEMBLY (929) FROM THE PLUG FLANGE (933) BY REMOVING THE RETAINING RING (103) FROM THE GROOVE IN THE PLUG FLANGE. REMOVE THE RING BY PLACING A SCREWDRIVER UNDER THE END OF THE RING ("A" ON CONTACT END VIEW) AND LIFTING THE RING OUT OF THE GROOVE. THEN, REMOVE THE ASSEMBLY.

REMOVE THE INSULATION FROM THE ENDS OF THE CONDUCTORS AS FOLLOWS: PHASE AND GROUND CONTACTS 1-7/8" [48mm], GROUND CHECK 3/4" [19mm].

THE PHASE (903) AND GROUND (904) CONTACTS MUST BE REMOVED FROM THE INSULATOR FOR CONDUCTOR INSTALLATION. THE GROUND CHECK CONTACTS (905) CAN REMAIN IN THE INSULATOR. REMOVE THE PHASE CONTACTS BY UNSCREWING THE CONTACT NUTS (906) USING A TJB PART NO.992 CONTACT NUT WRENCH (NOT PROVIDED). REMOVE THE GROUND CONTACTS BY REMOVING THE RETAINING RINGS (87). BE CAREFUL TO KEEP FROM OVER BENDING THE RETAINING RINGS.

MAKE SURE THERE ARE NO O-RINGS ON THE CONTACTS BEFORE SOLDERING

SOLDER ATTACH THE CONDUCTORS INTO THE PHASE AND GROUND 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 CONTACTS HAVE COOLED, SLIDE THE INSULATOR RETAINING RING (103) OVER THE PHASE CONDUCTORS. THEN REMOVE THE ACRYLIC COMPOUNDING TUBES (117) FROM THE BACK (CABLE END) OF THE TEFLON INSULATOR TUBES AND SLIDE THEM OVER THE PHASE CONDUCTORS.

INSERT THE PHASE CONTACTS INTO THEIR RESPECTIVE INSULATOR TUBES AND THREAD THE CONTACT NUTS (906) TIGHTLY ONTO THE CONTACTS.

INSERT THE GROUND CONTACTS INTO THEIR RESPECTIVE INSULATOR HOLES AND REPLACE THE RETAINING RINGS.

INSERT THE GROUND CHECK WIRE INTO THE GROUND CHECK (905) AND TIGHTEN THE SET SCREW.

INSTALL THE INSULATOR O-RING (908) INTO THE GROOVE ON THE OUTSIDE DIAMETER OF THE INSULATOR PLATE. IN ORDER TO EASE INSERTION OF THE INSULATOR INTO THE PLUG FLANGE, APPLY A SMALL AMOUNT OF THE SILICONE GREASE PROVIDED TO THE O-RING (908) ON THE INSULATOR. LINE UP THE RECESS IN THE CABLE END OF THE INSULATOR PLATE WITH THE FLAT ON THE PLUG FLANGE AND INSERT THE INSULATOR ASSEMBLY INTO THE FLANGE.

RE-INSTALL THE INSULATOR RETAINING RING (103) INTO THE GROOVE IN THE PLUG FLANGE.

MAKE CERTAIN THAT THE RETAINING RING IS PROPERLY SEATED IN THE GROOVE

