

IMPORTANT:
CERTIFIED INSTALLATION REQUIRES A MINIMUM 2 INCHES OF TJB P/N 75-12 (3M P/N 2123) COMPOUND IN THE BACK OF THE INSULATOR TUBES

IMPORTANT:
CERTIFIED INSTALLATION REQUIRES A MINIMUM ONE (1) INCH OF TJB P/N 74-8 (3M P/N 2130) COMPOUND IN THE BACK OF THE PLUG FLANGE

CERTIFIED MOUNTING REQUIRES 7-5/16" HOLE IN ENCLOSURE, WELD IN A-324-2B FLANGE BY CONTINUOUS GAS TIGHT WELD INSIDE AND OUTSIDE PER AWS. STANDARDS.

ITEM#	QTY.	PART NO.	DESCRIPTION
XX	1	342	COPPER SHIELDING TAPE (NOT SHOWN)
83	1	74-8	INSULATING COMPOUND (3M P/N 2130)
84	10	314 -	SET SCREW - SPECIFY SIZE
100	1	181	1/4-20 x 5/8 HHCS
101	1	171	COVER CABLE ASSEMBLY
103	1	327	INSULATOR RETAINING RING
107	1	315	1/4-20 X 3/8 SET SCREW
117	3	417	ACRYLIC COMPOUNDING TUBE
119	1	75-12	INSULATING COMPOUND (3M P/N 2123)
901	1	498	PLUG NUT
902	1	326	PLUG NUT RETAINING RING
903	1	492	1/4-20 X 1/2 CUP POINT SET SCREW
907	3	984	PHASE CONTACT O-RING
908	1	986	INSULATOR O-RING
909	2	987	GROUND CONTACT O-RING
910	1	988	GROUND CHECK CONTACT O-RING
911	1	989	GROUND CHECK CONTACT RETAINING RING
918	1	425T	XPT PLUG FLANGE
919	1	318	PLUG DUST COVER
925	1	368-A	MODEL TAG
929	1	971M5-COMP	MALE INSULATOR ASSEMBLY - 5KV
930	3	972-COMP	MALE PHASE CONTACT ASSEMBLY
931	2	973A-COMP	MALE GROUND CONTACT ASSEMBLY
932	1	974A-COMP	MALE GROUND CHECK CONTACT ASSEMBLY
933	3	978-COMP	MALE PHASE CONTACT NUT ASSEMBLY
934	1	385-1	PORON DUST COVER GASKET
935	1	324-2B	WELDING FLANGE
940	2	942M	GROUND CONTACT RETAINING RING

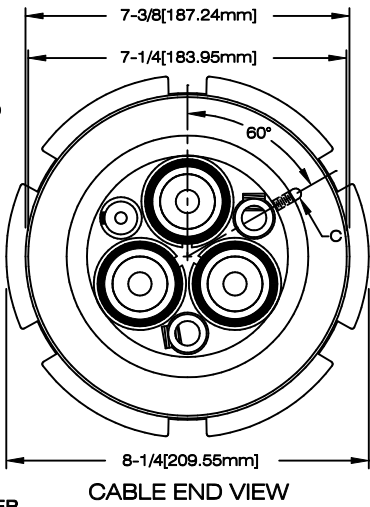
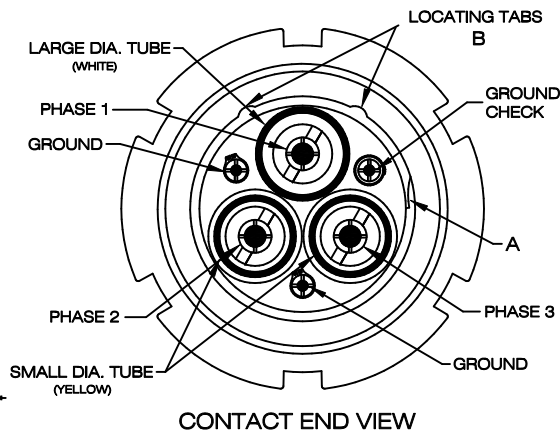
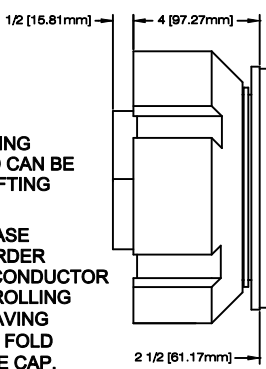
NOTE: ALL HARDWARE IS STAINLESS STEEL UNLESS OTHERWISE SPECIFIED

COMPOUND GEL TIME CHART
NOTE: GEL TIMES WILL INCREASE AS TEMPERATURE DECREASES

TJB NO. 74-8 (3M NO. 2130)	TYP. MINIMUM GEL TIME	70° F (23° C) — 15 MINUTES
TJB NO. 75-12 (3M NO. 2123)	TYP. MINIMUM GEL TIME	70° F (23° C) — 62 MINUTES

ASSEMBLY INSTRUCTIONS

- 1) REMOVE THE INSULATOR ASSEMBLY (929) FROM THE PLUG FLANGE (918) BY REMOVING THE INSULATOR RETAINING RING (103). THIS IS A SPIRAL TYPE RETAINING RING AND CAN BE REMOVED BY PLACING A SCREWDRIVER UNDER 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 1-3/4" [45mm], 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 MUST BE REMOVED FOR CONDUCTOR INSTALLATION. THE PHASE CONTACTS (930) ARE REMOVED BY UNSCREWING THE CONTACT NUTS (933) USING A TJB PART NO. 992 CONTACT NUT WRENCH (NOT PROVIDED). **DO NOT REMOVE THE TEFLON TUBES FROM THE INSULATOR PLATE.** THE GROUND AND GROUND CHECK CONTACTS DO NOT HAVE TO BE REMOVED FROM THE INSULATOR PLATE. INSERT THE CONDUCTORS INTO THE PHASE CONTACTS AND TIGHTEN THE SET SCREWS (84) USING AN ALLEN WITHOUT ADDITIONAL LEVERAGE.
- 4) INSERT THE GROUND CHECK LEAD INTO THE GROUND CHECK (932) AND TIGHTEN THE SET SCREW.
- 5) BOTH GROUND CONTACTS (931) HAVE BEEN ISOLATED FROM THE SHELL OF THE COUPLER. INSTALL THE GROUND WIRES AS DESIRED AND TIGHTEN THE SET SCREWS.
- 6) INSTALL THE "O"- RING (908), PROVIDED IN THE COUPLER KIT, INTO THE GROOVE ON THE INSULATOR PLATE AND APPLY A SMALL AMOUNT OF SILICONE GREASE (PROVIDED) TO THE "O"- RING AND INSTALL THE INSULATOR INTO THE PLUG FLANGE. REPLACE THE INSULATOR RETAINING RING.
MAKE CERTAIN THAT THE RETAINING RING IS COMPLETELY SEATED IN THE GROOVE.



- 7) POSITION THE COUPLER SO THAT THE ACRYLIC TUBES (117) ARE VERTICAL AND CENTER THE CONDUCTORS IN THE TUBES BEFORE COMPOUNDING.
- 8) MIX THE 75-12 (3M #2123) COMPOUND (119) (AS PER COMPOUND INSTRUCTIONS) AND FILL THE ACRYLIC TUBES TO A MINIMUM DEPTH OF TWO (2) INCHES EACH.
- 9) MIX THE 74-8 (3M #2130) COMPOUND (AS PER COMPOUND INSTRUCTIONS) AND FILL THE BACK OF THE PLUG FLANGE TO A MINIMUM DEPTH OF ONE (1) INCH.
- 10) SECURE THE A-324-2B THREADED STEEL WELDING FLANGE (935) INTO THE SWITCHGEAR USING A CONTINUOUS GAS TIGHT WELD, INSIDE AND OUTSIDE, AS PER AWS. STANDARDS. MAKE CERTAIN THE SLOT (C) IN THE WELDING FLANGE IS IN THE 2 O'CLOCK (60°) POSITION WHILE LOOKING AT THE CABLE SIDE OF FLANGE.
- 11) AFTER THE COMPOUND HAS CURED (SEE COMPOUND GEL TEMP. CHART), SCREW THE COUPLER ASSEMBLY INTO THE WELDING FLANGE (935) UNTIL IT BOTTOMS, THEN BACK IT OFF UNTIL THE SET SCREW (903) LINES UP WITH THE SLOT (C) IN THE WELDING FLANGE. TIGHTEN THE SET SCREW INTO THE SLOT.