



NOTE:
 IN ORDER TO MEET COMMONWEALTH OF PENNSYLVANIA REQUIREMENTS THERE MUST BE A **SOLDERED** CONNECTION ATTACHING THE SHIELD TO THE GROUND WIRES. WIRE FOR THIS CONNECTION IS PROVIDED IN THE COUPLER KIT.

ASSEMBLY INSTRUCTIONS

- 1) REMOVE THE INSULATOR ASSEMBLY (929) FROM THE PLUG BODY (947) BY REMOVING THE INSULATOR RETAINING RING (103). THE RETAINING RING IS REMOVED BY PLACING A SCREWDRIVER UNDER THE END OF THE RING AND LIFTING IT OUT OF THE GROOVE.
 - 2) UN-BOLT THE END BELL (948) FROM THE PLUG BODY (947) AND SLIDE THE FOLLOWING PARTS OVER THE CABLE IN THE FOLLOWING ORDER: END CASTING (162), HOSE CLAMP (164), CABLE SEAL (163) END BELL (948) PLUG BODY O-RING (949) AND PLUG BODY (947).
 - 3) REMOVE 7-1/2" (190.5 mm) OF THE JACKET FROM THE CABLE. **DO NOT CUT INTO THE UNDERLYING CONDUCTORS**. FOLD THE GROUND AND GROUND CHECK LEADS BACK AND OUT OF THE WAY.
 - 4) REMOVE 6" [152.5mm] OF THE SHIELD AND 5-1/2" [140mm] OF THE SEMI-CON FROM THE PHASE CONDUCTORS. COVER THE ENDS OF THE BRAID AND THE SEMI-CON WITH TWO LAYERS OF INSULATING TAPE.
 - 5) REMOVE THE INSULATION FROM THE ENDS OF THE CONDUCTORS AS FOLLOWS: PHASE CONDUCTOR 1-1/2" (38mm), GROUND CONDUCTOR 1-7/8" [48mm], GROUND CHECK CONDUCTOR 3/4" (19mm).
 - 6) 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.
- 7) 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.

- 8) AFTER THE PHASE CONTACTS HAVE COOLED, REPLACE THE O-RINGS AND REINSTALL THE CONTACTS INTO THE INSULATOR. REPLACE THE CONTACT NUTS.
- 9) INSERT THE GROUND CHECK LEAD INTO THE GROUND CHECK (905) AND TIGHTEN THE SET SCREW (107).
- 10) 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.
- 11) 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 INDENTS IN THE PLUG BODY. REPLACE THE INSULATOR RETAINING RING.
- 12) INSERT THE END BELL ALIGNMENT PIN INTO THE UN-THREADED HOLE IN THE PLUG BODY AND REATTACH THE END BELL USING THE SIX 1/4-20 X 1" BOLTS (9) AND LOCK WASHERS (81) PROVIDED.
- 13) SEAT THE CABLE SEAL (163) ON THE REAR OF THE END BELL AND SCREW THE END CASTING (162) ONTO THE END BELL. **HAND TIGHTEN ONLY.**
- 14) POSITION THE HOSE CLAMP (164) SO THAT THE SCREW IS ACCESSIBLE FROM THE RECESS IN THE CABLE CLAMP AND TIGHTEN THE HOSE CLAMP ONTO THE CABLE SEAL.
- 15) CENTER THE CABLE ON THE END CASTING AND POSITION THE CABLE CLAMPS (112) SO THAT THE CABLE IS CENTRALLY POSITIONED AND TIGHTEN THE NUTS (111) AND BOLTS (110).

ITEM#	QTY.	PART NO.	DESCRIPTION
X	1	721	END BELL ALIGNMENT PIN (NOT SHOWN)
XX	1	489	WIRE WRAP (NOT SHOWN)
9	6	182	1/4-20 X 1" HEX HEAD CAPSCREW
80	1	316	1/4-20 X 1/2 PLATED BRASS SCREW
81	7	202	LOCK WASHER
82	1	184-40	NYLON BALL BEARING - SET OF 40
83	1	151	DUST SEAL
84	4	314-	BRONZE SET SCREW (SPECIFY SIZE)
85	1	333	INTERNAL GROUND LEAD ASSEMBLY
87	2	942M	GROUND CONTACT RETAINING RING
100	1	181	1/4-20 x 5/8 HHCS
101	1	171D	COVER CABLE ASSEMBLY
103	1	920	INSULATOR RETAINING RING
106	4	185J	N/T PIN
107	1	315	1/4-20 x 3/8 SET SCREW
110	4	167	3/8-16 x 3 HEX HEAD TAPP BOLT
111	4	168	3/8-16 LOCK NUT
112	2	121-	CABLE CLAMP
149	1	216A	INSULATING TAPE
162	1	139	END CASTING FOR LARGE CABLE
163	1	138A	CABLE SEAL
164	1	187A	HOSE CLAMP
901	1	944A-COMP	LVNIT PLUG NUT - 480KV- 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 RETAINING RING
912	1	926	COUPLING O-RING
923	1	823	LVNIT PLUG DUST COVER - 480V AND 5KV
929	1	971TM48-COMP	MALE INSULATOR ASSEMBLY - 480V
932	1	981	BALL BEARING ACCESS PLUG
947	1	825	PLUG BODY
948	1	912-1	LVNIT END BELL FOR LARGE CABLE
949	1	9101	PLUG BODY O-RING

NOTE: ALL HARDWARE IS STAINLESS STEEL UNLESS OTHERWISE SPECIFIED