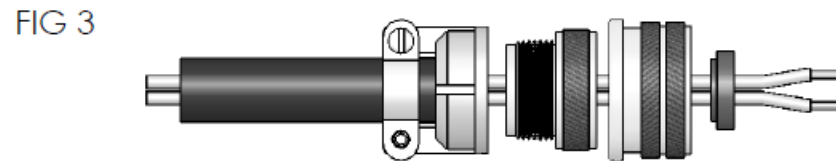
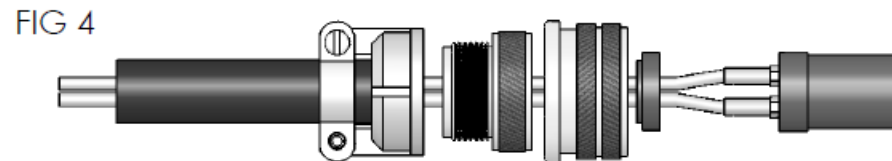


REMOVE BACK SHELL AND COUPLER FROM PLUG. SLIDE CABLE CLAMP, BUSHING, BACK SHELL, AND COUPLER OVER WIRES. STRIP EACH CONDUCTOR TO "A" DIMENSION, SEE TABLE BELOW.



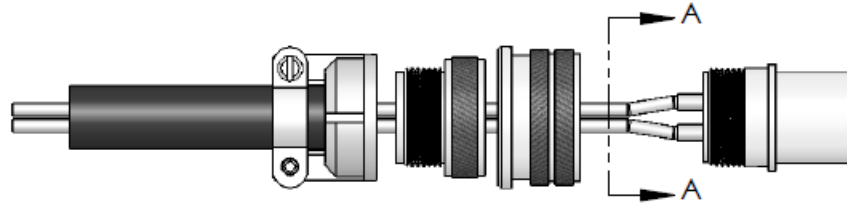
REMOVE RETAINING RING FROM FRONT SHELL. DISASSEMBLE INSERTS AND CONTACTS FROM FRONT SHELL. SLIDE WIRES THROUGH BACK INSERT. (LETTERS ON INSERT FACING TOWARDS CABLE CLAMP) 60-40 TIN LEAD SOLDER EACH CONDUCTOR.



INSERT WIRES INTO CONTACTS AND SOLDER IN PLACE. INSERT CONTACTS INTO FRONT INSERT. ALIGNMENT SLOTS AND LETTERS ON FRONT AND BACK INSERTS SHOULD BE IN LINE.

RECEPTACLE PIN DIAMETER	WIRE SIZE AWG	CONTACT SIZE	"A"
.062 [1.57]	16-20	16	.250 [6.35]
.094 [2.39]	12-14	12	.312 [7.92]
.142 [3.61]	8-10	8	.625 [15.88]

FIG 5



SLIDE THE FRONT AND BACK INSERTS TOGETHER AND INSERT THEM INTO THE FRONT SHELL. MAKE SURE TO ALIGN INSERT LETTERS AND SLOT TO FRONT SHELL SLOT AS SHOWN IN "FIG 6". SECURE INSERTS IN PLACE BY INSTALLING THE RETAINING RING.

FIG 6
VIEW A-A

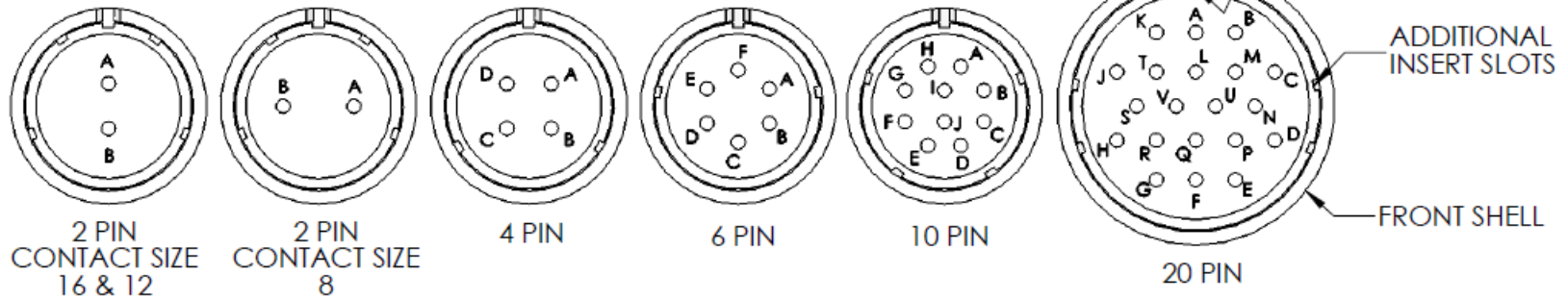
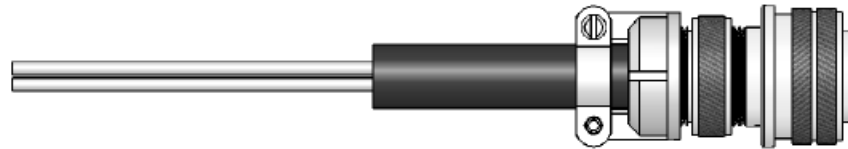


FIGURE ABOVE SHOWS CORRECT ALIGNMENT OF INSERT LETTERS AND SLOT TO FRONT SHELL SLOT.

FIG 7



SLIDE COUPLER OVER FRONT SHELL. THREAD BACK SHELL ONTO FRONT SHELL AND TIGHTEN. THREAD CABLE CLAMP ONTO THE BACK SHELL AND TIGHTEN. MODERATELY TIGHTEN CABLE CLAMP SCREWS TO PROVIDE ADEQUATE STRAIN RELIEF TO WIRES AND CONTACTS.