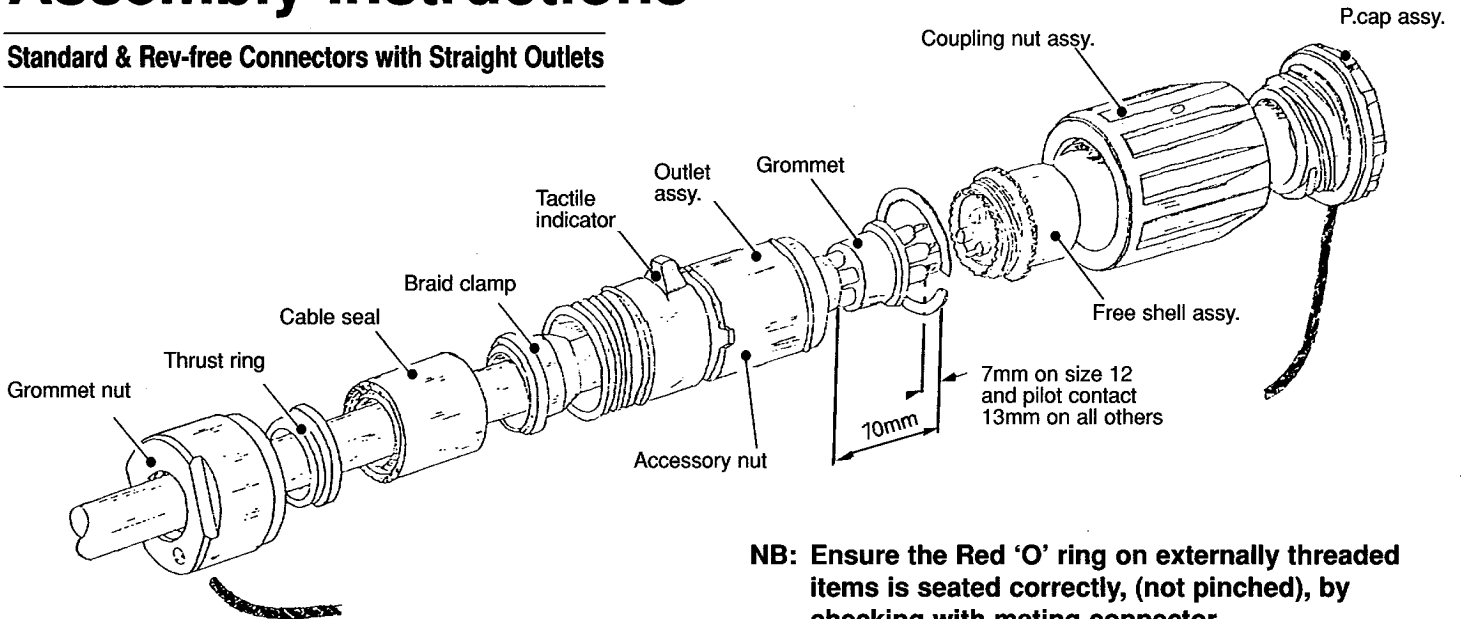


Assembly Instructions

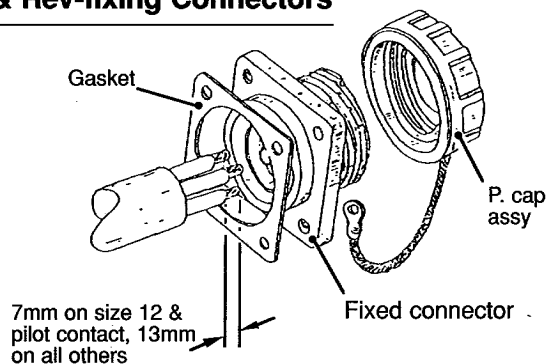
Standard & Rev-free Connectors with Straight Outlets



NB: Ensure the Red 'O' ring on externally threaded items is seated correctly, (not pinched), by checking with mating connector.

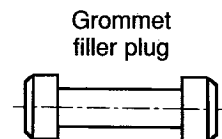
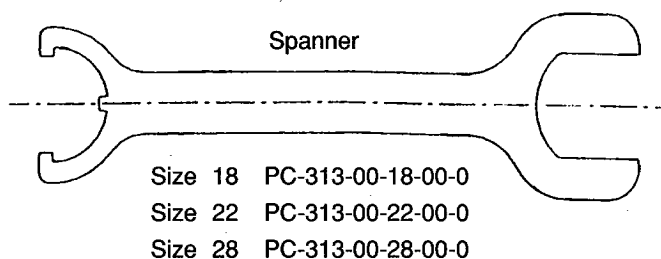
1. Strip cable to dimensions given and tin ends of cable.
2. Slide the following items onto cable in the following order, ensuring that they are fitted the correct way round **a. Grommet nut b. Thrust ring c. Cable seal d. Braid clamp e. Outlet Assy.**
3. Place individual conductors through grommet ensuring that each conductor is in correct hole. If pilot contact is not used a filler plug is required to seal hole slide grommet onto cable as far as possible (sleeve lubricant will ease this).
4. Feed conductors into their respective contacts and solder (ensuring that conductors are offered to their correct contact and are not twisted).
5. Slide grommet forward into the back of free shell (grommet will be face to face with rear of insert).
6. Offer free shell assembly into coupling nut assembly. Rotate to engage clicker spring. Locate circlip into position. Ensure circlip is fully located and expanded in groove (check coupling nut rotates).
7. Smear sleeve lubricant over outside of grommet and O rings on outlet. Tighten accessory nut onto free shell aligning tactile indicator (ensuring serrations on free shell and outlet fully mesh) with earth contact to a torque of 70 lbs/ins.
8. Slide **a. Braid clamp b. Cable seal c. Thrust ring** along cable onto outlet assembly.
9. Loosely screw grommet nut onto outlet push cable forward into outlet body to remove any strain from solder joints then tighten grommet nut to 70 lbs/ins.
10. If protective cap is to be fitted this must be threaded through hole in grommet nut and knot.

Standard & Rev-fixing Connectors



1. Cables may be soldered in bucket while inner shell is still in plastic housing.
2. Strip cables to dimensions given and tin ends.
3. Feed conductors into their respective contacts and solder.
4. **Gasket to be sandwich between panel and flange. Nuts to be tightened to 6 lbs/ins minimum to achieve panel sealing.**
5. If protective cap is fitted the terminal may be secured to any of the four mounting bolts.

Assembly Tool & Filler Plugs



- | | |
|---------|-------------------|
| Size 16 | PC-16-240-0-00-AC |
| Size 12 | PC-12-240-0-00-AC |
| Size 08 | PC-08-240-0-00-AC |
| Size 04 | PC-04-240-0-00-AC |