

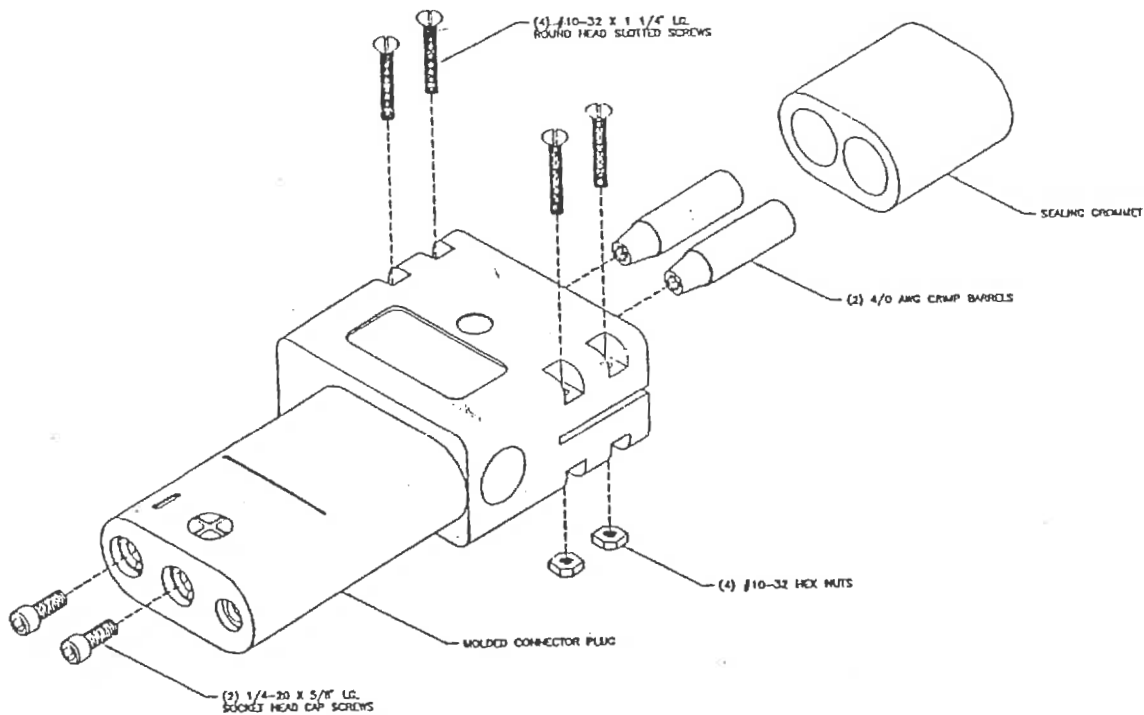
**Assembly Instructions For
AeroPlug Attachable Plug
Part Number CP1765**

STEP

1. If repairing an existing assembly complete Step 1. If making a new assembly start at Step 2. Remove the damaged plug from the cable assembly by cutting off the conductors 1" from the rear of the damaged plug. Ends of cut off conductors must be even. If there is a clamping band within 15" of rear of damaged plug, remove and discard it.
2. Strip the conductor insulation from both 4/0 AWG conductors 1-1/4 inches back from the end of the conductor. Do not damage the conductor stranding.
3. Install the 4/0 AWG crimp barrels supplied with the kit onto the prepared conductors. Double crimp them onto the conductors using an MS25441 Hydraulic Tool and 4/0 MS90485 Die (or equivalent). The first crimp should be 1/8 to 3/16 inches in from the cable entry end of the crimp barrel. The second crimp should be spaced 1/8 to 1/4 inches from the first crimp.
4. Cover both crimp joints, the exposed conductor between the insulation and the crimp barrel and 1/2" to 3/4" of the conductor insulation with glass cloth electrical tape, 3M #27 or equivalent.
5. Install the 4/0 AWG sealing grommet onto the 4/0 AWG conductors. Temporarily position it about 6 inches back from the ends of the crimp barrels.
6. Mount the plug in a vise just behind the contact area.
7. If repairing an existing assembly orientate the "+" and "-" conductors to the "+" and "-" marked positions on the plug. Orientation is not a factor for a new assembly.
8. Grasp both the 4/0 AWG conductors and insert them into the rear cavity of the plug.
9. Guide one of the 4/0 AWG crimp barrels into the rear of the corresponding socket contact and seat into position. While holding the conductor into the rear of the contact, insert one 1/4-20 x 5/8" socket head cap screw into the front of the socket contact and hand tighten using a 3/16" hex rod.

(OVER)

10. Repeat step 9 for the second 4/0 AWG conductor.
11. Slide the sealing grommet (step 5) along the conductors, using alcohol if necessary as a lubricant, into the rear cavity of the plug past the lip. If necessary use a steel bar across the sealing grommet to seat it into place.
12. Reposition plug in vise to close slits at rear of plug. Install and tighten four 10-32 x 1-1/4" bolts and 10-32 hex nuts. Remove plug from the vise.
13. Using torque wrench and appropriate hex rod, torque cap screws on the two power contacts to 60 inch-pound min.
14. Perform a continuity check to assure all conductors are correctly connected to their respective contacts.



PERIODICALLY CHECK THAT SETSCREWS ARE TORQUED TO 45-50 INCH LBS.

DO NOT OVER TIGHTEN