

SPEC Pak™ High Power Inline Receptacle

Assembly Instructions For 2, 3 & 6 Position

SPEC Pak™ High Power Shell Kit:



Inline Receptacle
Included Component



Holder Set
Included Component



#8 x 5/8 Screw
Included Component



Gland Assembly
Optional Component

You will need: - Wire Stripping Tool - APP Crimp Tool, See Section 2 - Phillips Head Screw Driver - 8 Screws, Size #10 or M5

Step 1 Slide PG Gland assembly onto wires (See Figure 1)



Figure 1

Step 2 Cable and/or Wire Preparation

- Jacketed cable: Strip outer jacket. Strip insulation from discrete wires (See Table 1 & Figure 2)
- Discrete wires: Strip insulation from discrete wires (See Table 1 & Figure 2)

Caution: Do not damage copper conductors when stripping wires

Table 1

Powerpole® Contacts		PowerMod® Signal Contacts	
Outer Jacket – 4" [102 mm]		Outer Jacket – 1.7" [44 mm]	
Contact Series	"X"	Contact	Wire Insulation OD < Barrel ID
PP75	9/16" (14.5 mm)	Pins	0.18" (4.5 mm)
PP120	15/16" (24.0 mm)	Sockets	0.28" (7.0mm)
PP180	1-1/8" (28.6 mm)		

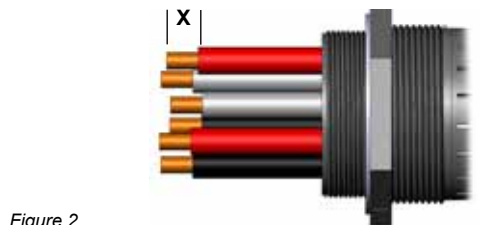


Figure 2

Step 3 Tighten body of PG Gland to Plug shell

- Hand tighten until snug, tighten additional 1/8 – 1/4 turn with wrench (See Figure 3)

Caution: Do NOT tighten Sealing Nut at this time

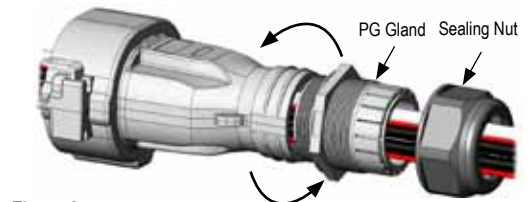


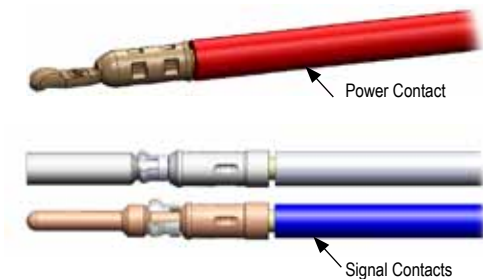
Figure 3

Step 4 Contact Termination

- Insert wire into crimp barrel to the full depth
- Visually verify that all strands are inserted into the barrel
- Follow the appropriate crimp instructions which are included with the crimp tools and/or at www.andersonpower.com

Caution: Keep all Powerpole® contacts parallel to each other while crimping jacketed cable.

Caution: Improper crimping may produce high resistance or contact distortion.



Tool PN	Tool Type	Contact Series	Contact
1309G4	Hand	PP75	5900, 5952 or 5915
1368	Die-less Hydraulic	PP120	1319, 1319G4, 1319G6, 1323G1, 1323G2
1368	Die-less Hydraulic	PP180	1328G1, 1328G2, 1347, 1348, 1382, 1383, 1384
PM1000G1	Hand	Auxiliary (PowerMod®)	PM16P12S30, PM16P1416S30, PM16P1620S30, PM16P2024S30, PM16S12S32, PM16S1416S32, PM16S1620S32 or PM16S2024S32

For additional tools see data sheet or www.andersonpower.com.

Step 5 Block Powerpole® housing together

- Orient Powerpole® housings with hoods up (See Figure 4)
- Block Powerpole® housings by interlocking dove tails to create individual rows (See Figure 5)
- If more than one row is required, block rows together by interlocking dove tails

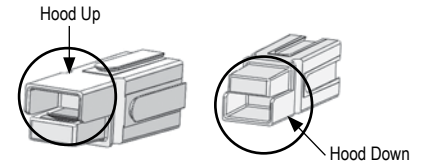




Figure 4

Step 6 Insert Powerpole® block into Powerpole® Holder

- With Hood up, slide Powerpole® block into the holder half marked with  on the right side, aligning the holder posts with the groove in Powerpole® (See Figure 6)
- Orient the remaining holder half with  on the right side (See Figure 6)
- Slide remaining half into the assembly, inserting the holder posts into the Powerpole® groove and aligning the tongues and grooves on the holder halves

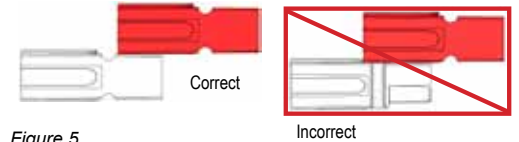



Figure 5

Step 7 Install Crimped Signal Contacts into the Connector Housings

- Orient the insert holder with the  to the right
- Snap the crimped signal contacts into the appropriate holes in the back of the holder halves (See Figure 7). A tactile snap will be felt when contact is latched.
- Repeat until all signal contacts have been installed into the housing

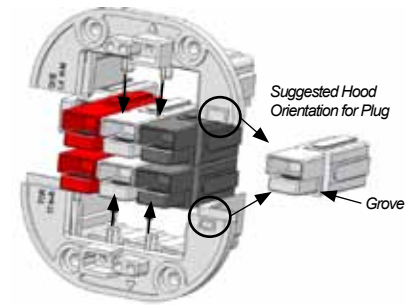



Figure 6

Step 8 Install Crimped Power Contacts into the Connector Housings

- Orient the insert holder with the  to the right
- Insert crimped power contacts into the appropriate Powerpole® housing until the contact lip snaps over the edge of the spring (See Figure 8)
- Repeat until all power contacts have been installed

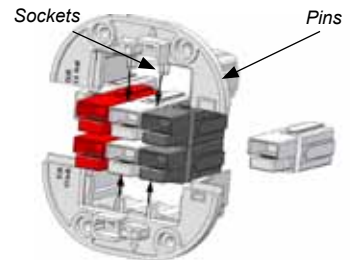


Figure 7

Step 9 Install insert holder into the Inline Receptacle shell

- Verify that the o-ring is properly seated in the receptacle shell
- Secure insert holder to the Inline Receptacle by tightening the screws in an alternating manner. Torque: 13 in-lb (1.4 N-M) (See Figure 9)

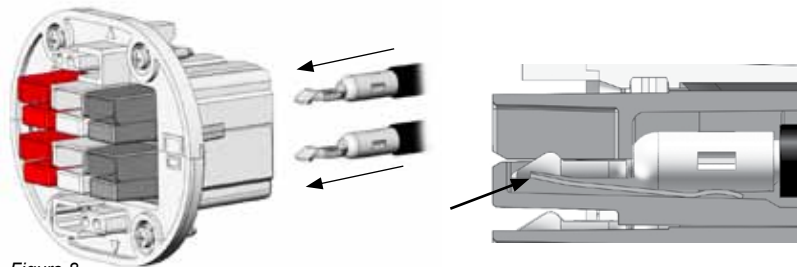


Figure 8

Step 10 Tighten Sealing Nut on Gland

- Hand tighten until snug, tighten additional 1/2 - 3/4 turn with a wrench (See Figure 10)



Figure 9

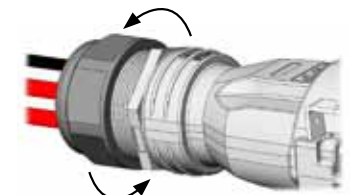


Figure 10

REGISTRATION

"Anderson Power Products", "APP" are registered U.S. and foreign trademark of Anderson Power Products®, 213 Pratts Junction Road, Sterling, MA 01564-2305 USA www.andersonpower.com

PATENTS AND TRADEMARKS

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