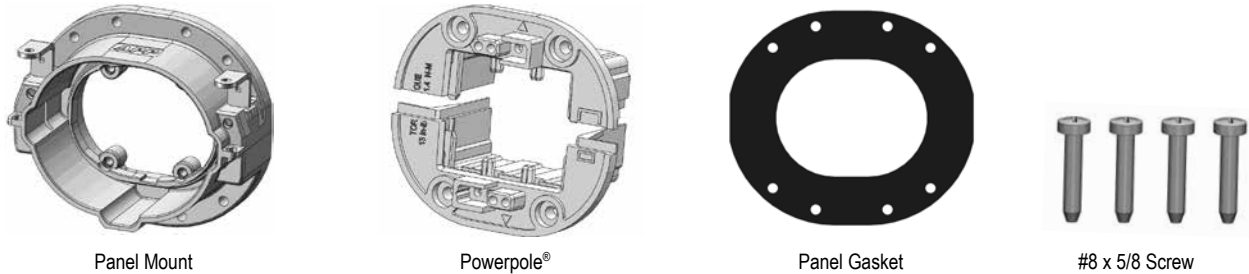


SPEC Pak® High Power Panel Mount Receptacle

Assembly Instructions For 2, 3 & 6 Position

SPEC Pak® High Power Shell Kit:



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

Step 1 Cable and Wire Preparation

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

Caution: Do not damage copper conductors when stripping wires

Table 1

Powerpole® Contacts		PowerMod® Signal Contacts	
Outer Jacket – 4" [102 mm]		Outer Jacket – 5.5" [139.7 mm]	
Contact Series	"X"	Contact	Wire Insulation OD < Barrel ID
PP75	9/16" (14.5 mm)	Pins	0.18" (4.5 mm) 0.24" (6.0 mm)
PP120	15/16" (24.0 mm)	Sockets	0.21" (5.5 mm) 0.28" (7.0mm)
PP180	1-1/8" (28.6 mm)		

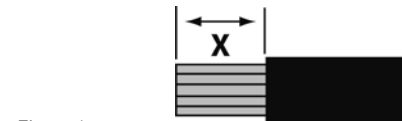


Figure 1

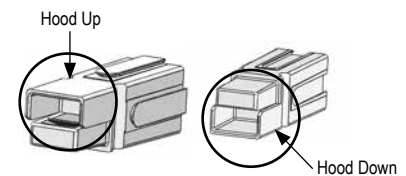


Figure 2

Step 2 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

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 3 Block Powerpole® housing together

- Orient Powerpole® housings with hoods up (See Figure 2)
- Block Powerpole® housings by interlocking dove tails to create individual rows (See Figure 3)
- If more than one row is required, block rows together by interlocking dove tails

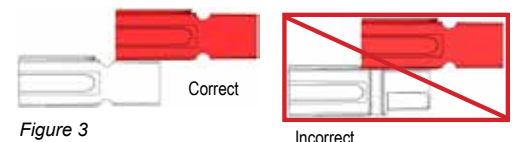


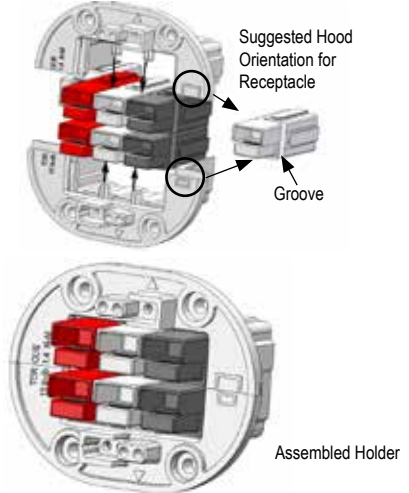


Figure 3

Step 4 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® holes (See Figure 4)
- Orient the remaining holder half with  on the right side (See Figure 4)
- Slide remaining half into the assembly, inserting the holder posts into the Powerpole® holes and aligning the tongues and grooves on the holder halves



Step 5 Install Receptacle housing on the panel:

- Clean and dry the panel surface thoroughly
- Orient housing with APP® logo facing up
- Sandwich panel mount receptacle gasket between the panel and the receptacle shell (See Figure 5)
- Secure the panel mount receptacle and gasket to the panel with size #10 or M5 screws (not included) in an alternating manner. Suggested Torque: 15-20 in-lbs (1.7-2.2 N-M)

Step 6 Install Crimped Signal Contacts into the Connector Housings


- Pull all wires through the panel
- Orient the insert holder with the  to the right (See Figure 6)
- 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 4

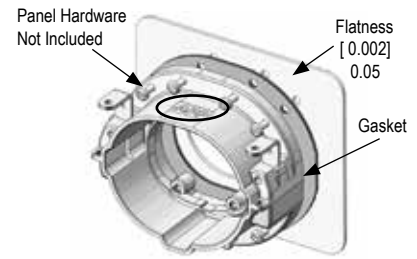



Figure 5

Step 7 Install Crimped Power Contacts into the Connector Housings

- Orient the insert holder with the  to the right (See Figure 6)
- 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

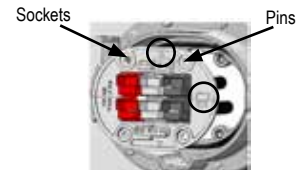


Figure 6

Step 8 Install insert holder into the receptacle shell

- Verify that the O-Ring is properly seated in the receptacle shell
- Secure insert holder to the panel mount receptacle by tightening the screws in an alternating manner. Torque: 13 in-lb (1.4 N-M)

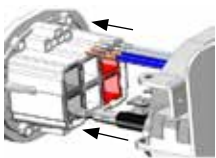


Figure 7

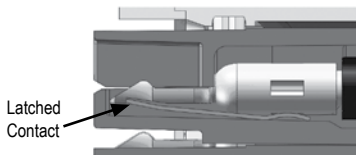
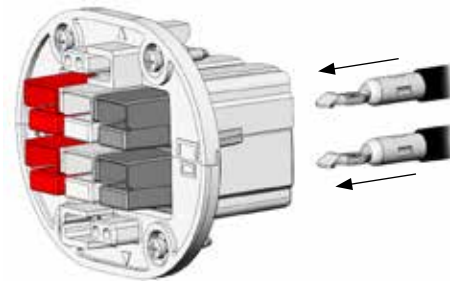


Figure 8



REGISTRATION

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PATENTS AND TRADEMARKS

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