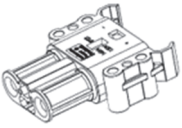
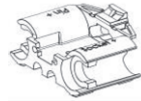


A Series Female Connector Assembly Instructions

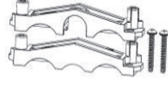
Base Kit Components:



SOCKET HSG.



CONTACT HOLDER



CABLE CLAMPS



LOWER AUX. SUPPORT



GREY OR GREEN
VOLTAGE PIN

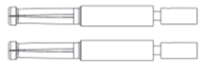
Tools Required:

- Crimp or solder tool
- #2 Phillips head screwdriver
- Torque wrench
- Small flat screwdriver
- *Aux Contacts are solder only

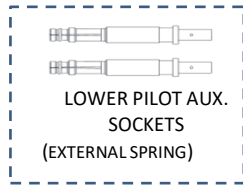
Optional Kit Components:



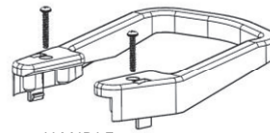
SOCKETS



UPPER AUX. SOCKETS
(NO EXTERNAL SPRING)



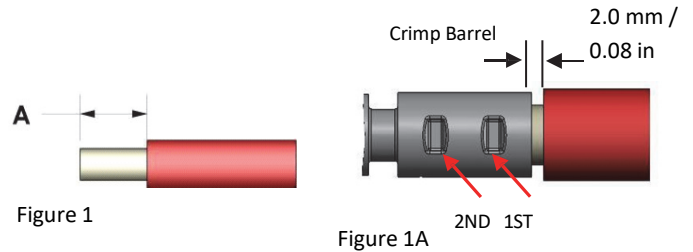
LOWER PILOT AUX. SOCKETS
(EXTERNAL SPRING)



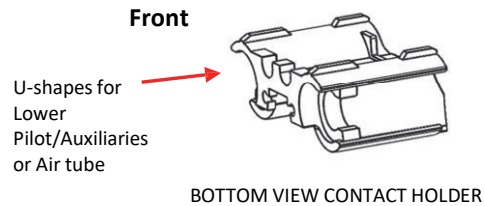
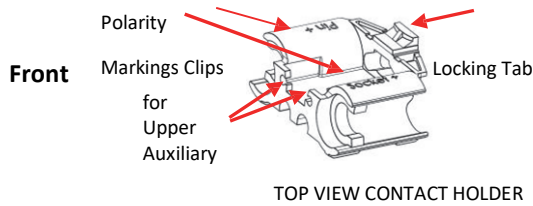
HANDLE

1. Strip wire per length specified in the table below (Figure 1)

Contact Type	Wire Size	Dim. A
Power Contact	1/0 – 2/0	20 mm / 0.8 in
Power Contact	3/0 – 4/0	25 mm / 1 in
Auxiliary Contact	#18 - #12	8.5 mm / 0.5 in



2. Insert wire into contact crimp barrel until wire bottoms in barrel. Solder or crimp contacts. Note: It is recommended to double-crimp when using wire sizes of 20mm-sq or greater. As shown in Figure 1A make the outer crimp first, then the inner crimp.
3. Pick up the holder and locate the Top and Bottom sides based on the diagrams below.



4. For Use of Lower Pilot/Auxiliaries (Installed on bottom side):
 - a. Orient lower pilot/auxiliaries as shown in (Figure 2)
 - b. Line up contact grooves to U-shapes in holder
 - c. Press on each contact until the groove *snaps into the U-shape*
 - d. Slide contacts into lower auxiliary support (Figure 3).

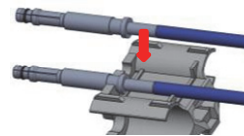


Figure 2

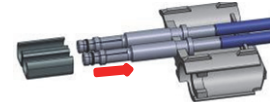


Figure 3

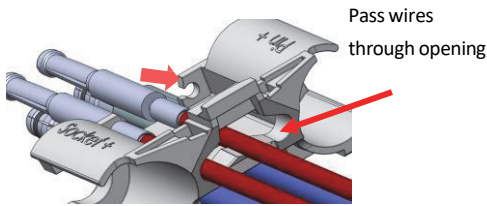


Figure 4

5. Install the upper auxiliary contacts on the top of the holder (Figure 4):

- Pass the upper auxiliary leads through the opening in the top of the holder as indicated
- Snap the groove of each contact into the retention feature by pushing from the center outward
- The contacts should hold securely in the retention feature

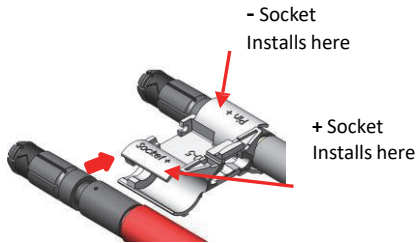


Figure 5

6. Install terminated power contacts into the contact holder:

CAUTION: Observe proper polarity. The positive and negative socket sides are indicated in Figure 5.

- Line up the groove in the socket with the retention feature
- Push the contact towards the center until the contact snaps into place
- Repeat with the other socket on the opposite side

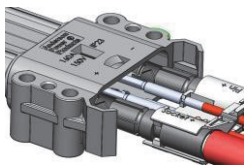


Figure 6

7. Install the fully assembled contact holder into the socket housing (Figure 6):

- Orient both the holder and the housing with polarity markings facing up.
- Slide the holder into the housing, lining up all contacts with their respective openings
- Push from the back of the holder until the holder locking tab snaps into the rectangular opening (Figure 7)

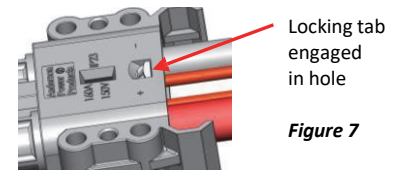


Figure 7

8. Install the voltage pin into the housing: The pin installs in the hex shaped opening in the front.

- Orient the pin for the desired voltage. The inner numbers correspond to the socket housing voltage.
- Push the pin forward, verifying that the key is in the right orientation.
- Once the front of the pin is equal with the front of the housing, use a screwdriver to push the pin further until it snaps in place. (Figure 8)

Note: Yellow universal pins are not used with female connectors



Figure 8

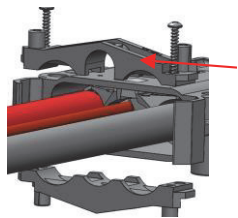


Figure 9

	320 Series Clamp Tightening Torque			
	min.		max.	
Contact Size	N-m	in-lb	N-m	in-lb
50mm-sq	0.79	7	0.9	8
70 and 95mm-sq	0.68	6	0.79	7

Torque values are used with all wire sizes listed for that contact.

9. Secure the power cables using the cable clamps and self-tapping screws:

- Line up the top and bottom clamp with open pillars at the cable side of the housing (note the upper clamp has a larger "U" and should be on the side with polarity markings).
- Install the two screws in the open holes on the upper clamp.
- Hold the two clamps tight to the cable while tightening the screws. Auxiliary wires will pass through "U" and are not to be grabbed by the clamp. (Figure 9)
- Tighten per table.

10. Install the optional handle on the top (polarity mark side) of the housing (Figure 10):

- Align the four posts on the underside of the handle with the four outer holes on the housing.
- Push down on the handle until the snap protrusions grab on the bottom of the housing
- Use the two self-tapping screws to secure the handle. Tighten to .7 to 1.0 N-M [6 – 9 in-lb] of torque.

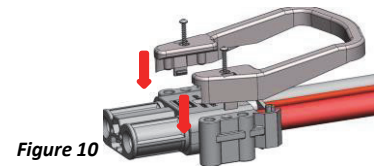


Figure 10

If necessary to disassemble the connector, follow these instructions (Figure 11):

- Turn off all power sources
- Remove the top and bottom cable clamps (optional handle does not need to be removed)
- Slide a small flat screwdriver in through the back of the housing near the holder catch
- Carefully rotate the screwdriver towards the back of the housing. The blade must wedge between the catch and the inside top of the housing, forcing the catch down.
- Grasp both power wires and pull back until the holder is clear of the housing. This may require some force.

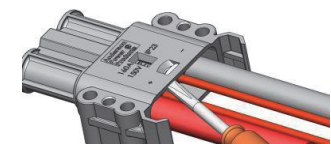


Figure 11