

7	PLUG CASING		1	
6	EARTH PIN CAL.20		1	
5	4+E PIN MALE CONTACT CARRIER		1	
4	CABLE GLAND SEAL Ø100			
	CABLE GLAND SEAL Ø90			
3	AUXILIARY PIN CAL.4	2	19	
2	CABLE TERMINAL TO CRIMP OR SOLDER 300 ²		48	
	CABLE TERMINAL TO CRIMP OR SOLDER 240 ²		42	
1	PHASE PIN CAL.20	4		
Ind	Description	Reference	Cont.	Strip. A

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PRODUCT REFERENCE

899.AL8PM424S
899.AL8PM430S

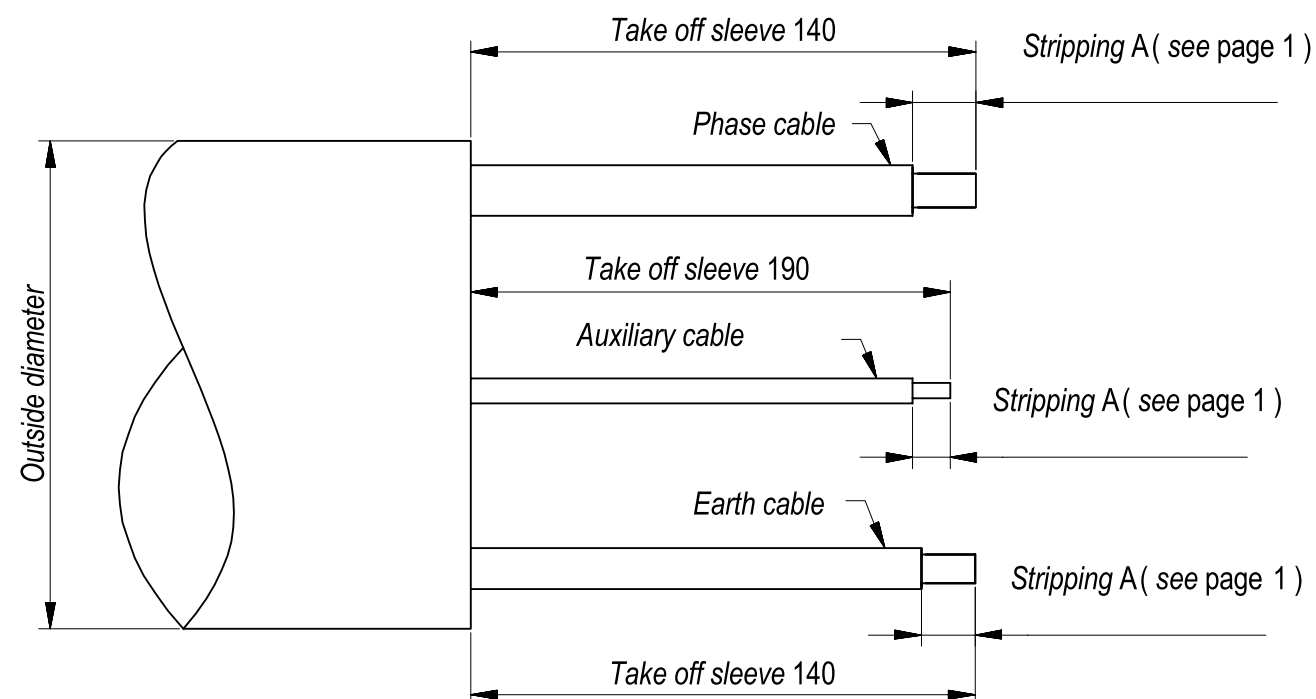
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ASSEMBLY INSTRUCTIONS

- 1- PREPARE THE CABLES AS SCHEME BELOW.
- 2- CRIMP OR SOLDER CABLE TERMINALS (2) ON PHASE CABLES AND EARTH CABLE [TOOL Nr 9 AND 10].
- 3- UNSCREW HANDLE (7.4) [TOOL Nr 8] AND CABLE GLAND (7.2).
- 4- IN THE ORDER, SLIDE CABLE GLAND (7.2), WASHER (7.3), CABLE GLAND SEAL (4), HANDLE (7.4), SEAL (7.5) AND PLUG CASING (7) OVER THE CABLE.
- 5- REMOVE SCREWS OF CONTACTS (3) [TOOL Nr 7], INTRODUCE CONTACTS IN FRONT OF PIN MALE CONTACT (5). INTRODUCE PILOT CABLES IN BACKSIDE OF CONTACTS AND PUT SCREWS IN CONTACTS THEN TIGHTEN [TOOL Nr 7].
- 6- INTRODUCE CONTACTS (1) IN FRONT OF INSERT (5). INTRODUCE EACH CABLE TERMINAL (2) AT THE BACKSIDE OF CONTACTS (1), THEN SCREW CONTACTS (1) (TORQUE 25Nm) [TOOL Nr 1, 2 AND 3] BLOCKING CABLE TERMINALS (2) IN GROOVE OF INSERT.
- 7- INTRODUCE PIN MALE CONTACT (5) IN BODY FRONT (7) AND THIGHTEN IT [TOOL Nr 6].
- 8- ENGAGE EARTH CONTACT (6) IN THE HOLE OF EARTH EAR IN THE MIDDLE OF PLUG CASING (7).
- 9- PLACE CABLE TERMINAL (2) OF EARTH CABLE AT THE BACKSIDE OF EARTH CONTACT (6), SCREW CONTACT, WHEN CABLE TERMINAL HEXAGON TOUCH EARTH EAR OF PLUG CASING (7), PUSH IT INSIDE OF EARTH EAR TO BLOCK IT, THEN TIGHTEN CONTACT (6) (TORQUE 25Nm) [TOOL Nr 1; 2 AND 3].
- 10- FIX SEAL (7.5) AND HANDLE (7.4) ON BODY FRONT (7) [TOOL Nr 8].
- 11- PLACE SEAL (4) AND WASHER (7.3) INTO HANDLE (7.4) THEN SCREW CABLE GLAND (7.2) TO BE WATERPROOF.
- 12- TIGHTEN SCREWS AND NUTS OF CABLE CLAMPS (7.1) ON CABLE TO BLOCK CABLE GLAND (7.2) [TOOL Nr 5].

LIST OF TOOLS *

- 1- TORQUE WRENCH FACOM REF: J.306A50
- 2- INCREASER 3/8" TO 1/2" FACOM REF: J.232
- 3- SOCKETS FACOM : 1/2" Nr30 REF: S.30LA
- 4- ANGLED SOCKET WRENCH OR OPEN END WRENCH 19mm 6- FLAT SCREWDRIVER Nr 6.5
- 5- FLAT SCREWDRIVER Nr 3
- 6- ALLEN KEY Nr 4
- 7- CRIMPING TOOL KLAUKE HK 120 U
- 8- KLAUKE CRIMPING JAW: 240² REF: HNFF 13/240
400² REF: HNF 13/400



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