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|-----|--|-----------|-------|----------|
| 7 | EARTH PIN CAL.20 | | 1 | |
| 6 | PLUG CASING | | 1 | |
| 5 | 3+E 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 | | 3 | |
| Ind | Description | Reference | Cont. | Strip. A |

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2013.10.22 14:42:59 +0200

PRODUCT REFERENCE

899.AS8PM324
899.AS8PM330

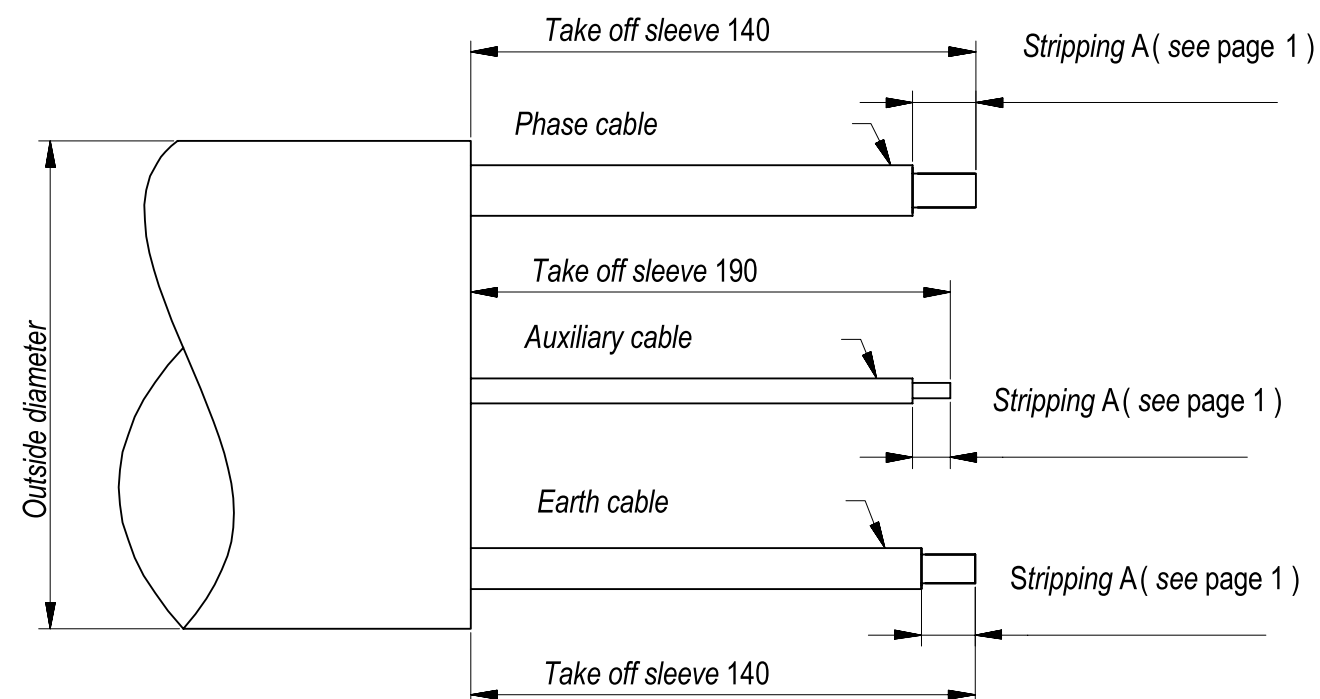
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ASSEMBLY INSTRUCTIONS

- 1- PREPARE THE CABLES AS SCHEME BELOW.
- 2- CRIMP OR SOLDER CABLE TERMINALS (2) ON PHASE CABLES AND EARTH CABLE [TOOL Nr 10 AND 11].
- 3- SEPARATE NUT (6.7) FROM FLANGE (6.4) [TOOL Nr 5].
- 4- UNSCREW HANDLE (6.6) [TOOL Nr 9] AND CABLE GLAND (6.2).
- 5- IN THE ORDER, SLIDE CABLE GLAND (6.2), WASHER (6.1), SEAL (4), FLANGE (6.4), SLIDING WASHER (6.5) AND HANDLE (7.3) OVER THE CABLE.
- 6- REMOVE SCREWS OF CONTACTS (3) [TOOL Nr 8], INTRODUCE CONTACTS IN FRONT OF CONTACT CARRIER (5). CONTACTS MUST GO OUT OF CONTACT CARRIER, IF NO RETURN CONTACT CARRIER. INTRODUCE PILOT CABLES IN BACKSIDE OF CONTACTS AND PUT SCREWS IN CONTACTS THEN TIGHTEN [TOOL Nr 8].
- 7- INTRODUCE CONTACTS (1) IN FRONT OF CONTACT CARRIER (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.
- 8- ENGAGE EARTH CONTACT (7) IN THE HOLE OF EARTH EAR IN THE MIDDLE OF PLUG CASING (6).
- 9- PLACE CABLE TERMINAL (2) OF EARTH CABLE AT THE BACKSIDE OF EARTH CONTACT (7), SCREW CONTACT, WHEN CABLE TERMINAL HEXAGON TOUCH EARTH EAR OF PLUG CASING (6), PUSH IT INSIDE OF EARTH EAR TO BLOCK IT, THEN TIGHTEN CONTACT (7) (TORQUE 25Nm) [TOOL Nr 1; 2 AND 3].
- 10- FIX CONTACT CARRIER (5) ON HANDLE (6.6) [TOOL Nr 7].
- 11- FIX PLUG CASING (6) ON HANDLE (6.6) [TOOL Nr 9].
- 12- PLACE SEAL (4) AND WASHER (6.1) INTO HANDLE (6.6) THEN SREW CABLE GLAND (6.2) TO BE WATERPROOF.
- 13- TIGHTEN SCREWS AND NUTS OF CABLE CLAMPS (6.3) ON CABLE TO BLOCK CABLE GLAND (6.2) [TOOL Nr 6].
- 14- PLACE NUT (6.7) ON PLUG CASING (6) THEN PLACE SLIDING WASHER (6.5) AND FLANGE (6.4), TIGHTEN ALL PARTS [TOOL Nr 5]. BE CAREFUL TO NOT CAUGHT SLIDING WASHER (6.5) BETWEEN FLANGE (6.4) AND NUT (6.7).

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 10mm
- 5- ANGLED SOCKET WRENCH OR OPEN END WRENCH 19mm
- 6- FLAT SCREWDRIVER Nr 6.5
- 7- FLAT SCREWDRIVER Nr 3
- 8- ALLEN KEY Nr 4
- 9- CRIMPING TOOL KLAUKE HK 120 U
- 10- KLAUKE CRIMPING JAW: 240° REF: HNFF 13/240
400° REF: HNF 13/400



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