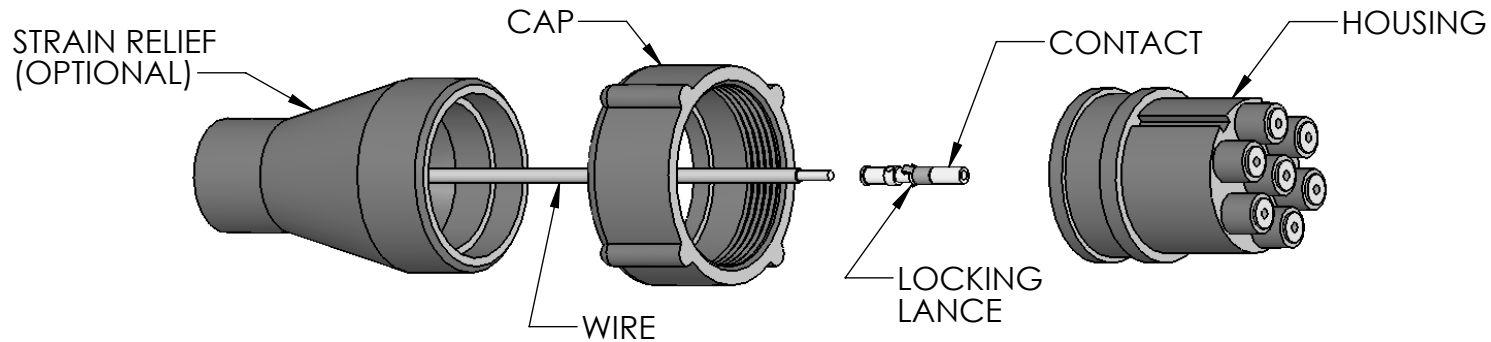
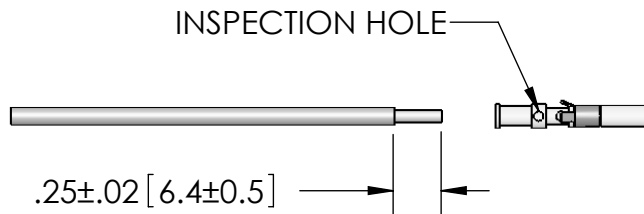


**FIG 1**

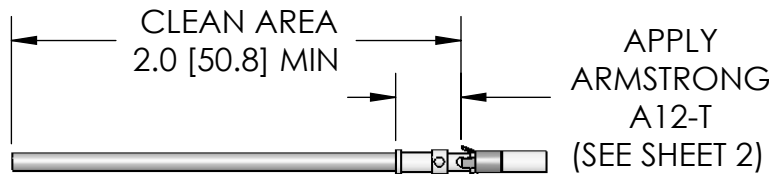


**FIG 2**



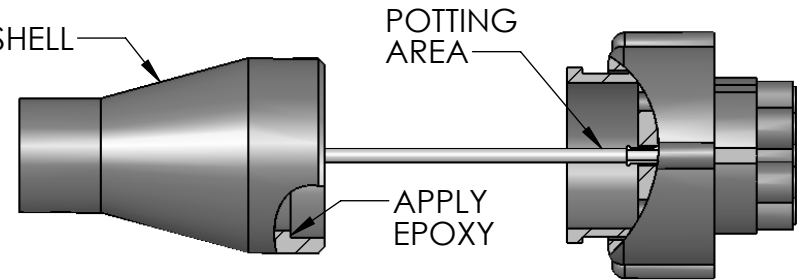
STRIP END OF WIRE TO DIMENSION SHOWN. INSERT WIRE INTO CONTACT. WIRE SHOULD BE VISIBLE IN INSPECTION HOLE. CRIMP WIRE TO CONTACT USING AMP CRIMPING TOOL 45098. CENTER CRIMP BETWEEN END OF CONTACT AND INSPECTION HOLE.

**FIG 3**



AFTER CRIMPING THE CONTACT, THOROUGHLY CLEAN THE SURFACE OF THE WIRE AND THE CONTACT (AS SHOWN ABOVE) WITH ALCOHOL.

**FIG 4**



ROUGHEN THE INNER SURFACE OF THE POTTING AREA OF THE PLUG AND STRAIN RELIEF (IF USED), BY ABRASIVE BLASTING. CLEAN ABRADED AREA THOROUGHLY WITH ALCOHOL AND **ALLOW TO DRY.**

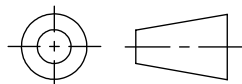
INSERT CONTACTS INTO CAVITIES OF HOUSING, MAKING SURE LOCKING LANCES OF CONTACTS ARE FULLY SEATED IN THE HOUSING. PULL BACK LIGHTLY ON EACH CONTACT TO MAKE SURE IT IS SEATED PROPERLY.

IF STRAIN RELIEF IS USED, ATTACH IT TO THE HOUSING BY APPLYING ARMSTRONG A12-T EPOXY TO THE LIP OF THE STRAIN RELIEF WHERE IT MAKES CONTACT. ALLOW TO CURE. INSTALL CAP ON HOUSING BEFORE ATTACHING STRAIN RELIEF.

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THIRD ANGLE PROJECTION



TITLE: **INSTRUCTION SHEET  
HIGH VOLTAGE AIR SIDE PLUG**



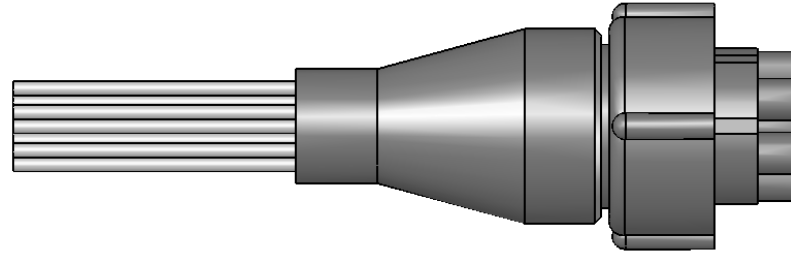
REV.	APP'D	DATE	SCALE 4:5	DIMENSIONS IN INCHES [mm]	DRAWN	JS	5/5/2009
A	MH	05/07/2009	NS15081-11		ENG APPR.	MH	05/07/2009

NUMBER:	NS15081
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REV:	A
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SHEET 1 OF 2

**FIG 5**



FILL THE HOUSING AND STRAIN RELIEF (IF USED), WITH HYSOL 4215 WHEN WIRE INSULATION IS TEFLON; USE GE RTV-511 OR RTV-21 WHEN WIRE INSULATION IS SILICONE. DO **NOT** INTRODUCE VOIDS.

WHEN POTTING WITH HYSOL 4215, CONTACT AND WIRE SUB ASSEMBLIES MUST BE BONDED WITH ARMSTRONG A12-T EPOXY TO SEAL CAVITIES. APPLY ADHESIVE TO AREA SHOWN IN FIG 3. ALLOW EPOXY TO CURE THOROUGHLY.

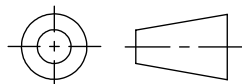
AFTER FILLING THE HOUSING AND STRAIN RELIEF (IF USED), ALLOW THE COMPOUND TO CURE **FULLY** BEFORE APPLYING VOLTAGE.

APPLIES TO:		
No. OF PINS	PLUG P/N	WIRE SIZE AWG
2	FA19088	18 TO 16
4	FA18481	
7	FA15081	

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A	MH	05/07/2009	NS15081-15		ENG APPR.	MH	05/07/2009	NS15081	A