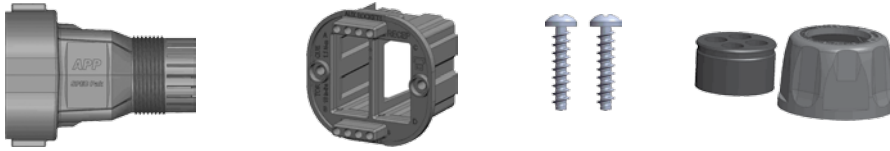


Mid Power SPEC Pak® Inline Receptacle Assembly Instructions

Inline Receptacle Shell Kit:



Tools you will need:

- Wire Lubricant
- Crimp Tool(s)
- Philips Head Screw Driver
- 44mm Wrench

1. Wire Protection

- Strip approximately 2 ¾ inches (69.8 mm) from the outer cable jacket, if applicable.
- Lubricate individual wires using IDEAL® Wire Pulling Lubricant that is compatible with nylon and polyester.
- Slide approximately 8 inches (203.2 mm) of wires through wire protection nut, wire protection seal (with the groove facing the wire protection nut) and inline receptacle shell. (See figure 1)
- Insert wire protection seal into shell (See figure 2)

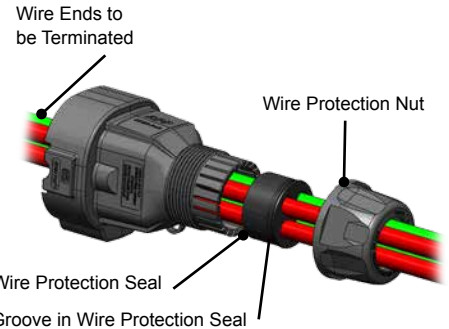


Figure 1

2. Prepare Wires

- Strip individual wire(s) taking care not to damage the copper conductor. (See Table 1)

Table 1 (See figure 3)

APP Contact Part Number	Amps	"X" Inches	"X" mm	For more details, see document:
1307	75	9/16"	14.5	1S1072
5953				
PM16S2024S32	5	Wire Insulation OD < crimp barrel ID		1S6420
PM16S1620S32		0.21" (5.5mm)		
PM16S1416S32		----		
PM16S12S32		Wire Insulation OD > crimp barrel ID		
		0.28" (7.0mm)		



Figure 2

3. Crimp Contacts

- Crimp contacts per crimp tool instructions. (See Table 2). **WARNING:** Crimping with non-APP recommended tools may product high resistance or contact distortion resulting in improper seating of the contact in the Powerpole® housing and may effect UL & CSA approval.
- Keep all contacts parallel to each other while crimping. (See figure 3)
NOTE: This will ensure that contacts remain in proper position for mating and un-mating once installed into the Powerpole® housings. It will also make installation into Powerpole® holder easier.

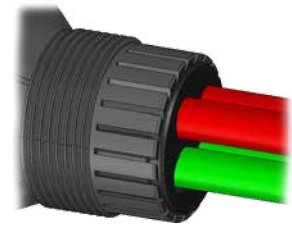


Figure 3


Table 2

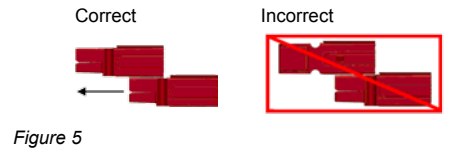
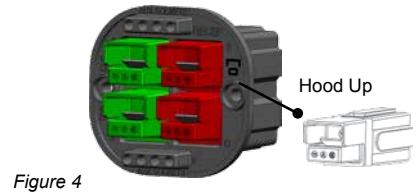
APP Contact PN	Wire Size	Hand Tool PN	Instruction Sheet PN	Please inquire for additional tooling options:
1307	6 AWG 13.30 mm ²	1309G4	1S6373	Pneumatic
5953	10 – 12 AWG 5.30 – 3.30 mm ²			
PM16S2024S32	24 – 20 AWG 0.25 – 0.50 mm ²	PM1000G1	1S6497	Pneumatic
PM16S1620S32	20 – 16 AWG 0.50 – 1.30 mm ²			
PM16S1416S32	16 – 14 AWG 1.30 – 2.10 mm ²			
PM16S12S32	12 AWG 3.30 mm ²			

Mid Power SPEC Pak® Inline Receptacle

Page 2

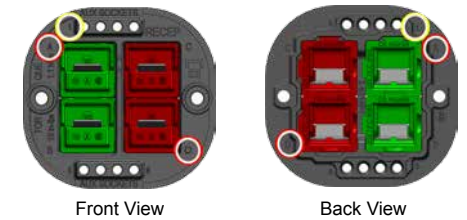
4. Populate Powerpole® holders

- Orient Powerpole® housing with hood up. (See figure 4)
- Block Powerpoles® by interlock dovetails. The Powerpole® housing will be stacked one (1) wide and two (2) high. (See figure 5)
- Orient Powerpole® holder with  on the right.
 - Positions for the power contacts are labeled A thru D with A being in the upper left corner as you are looking at the front of the holder or upper right corner as you are looking at the back of the holder. (See figure 6)
 - Positions for the auxiliary (PowerMod®) contacts are labeled with 1 and 8. 1 is located in the upper left corner and 8 located in the lower right corner as you are looking at the front of the holder. (See figure 6)
- Insert first set of 1x2 blocked Powerpole® from the rear. Hood is up.
NOTE: You feel them snap into place when fully inserted.
- Insert second set of 1x2 blocked Powerpole® from the rear, if applicable. Hood is up.
NOTE: You feel them snap into place when fully inserted.



5. Power contact installation


- Orient the Powerpole® housing with hood up. (See figure 4)
- Insert contact, from the back, into the Powerpole® holder per your configuration. (See figure 7) Contacts will snap into place. **NOTE: The contact will slip under the internal barrier and snap over the internal retaining pin.** (See figure 8)
- Repeat Step 5b as necessary.

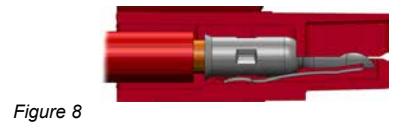
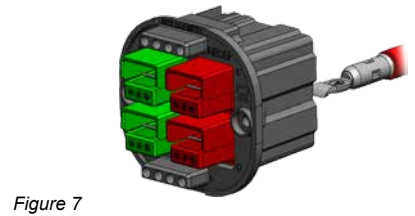


6. Auxiliary contact installation, if applicable

- Insert socket, from the back, into the Powerpole® holder per your configuration. Contacts will snap into place. (See figure 9)

7. Final Assembly

- Orient shell with APP SPEC Pak® up.
- Orient Powerpole® holder with  on the right.
- Slide holder into shell. (See figure 10) **NOTE: The holder will only go in one way.**
- Using two(2) M3.5 x 15mm Phillips head screws, secure the holder to the shell.
- Gently pull on the wires to remove excess slack in the wires.
- Hand tighten wire protection nut.
- Using a 44 mm wrench or strap wrench, tighten wire protection nut $\frac{3}{4}$ to 1 turn.



8. Assembly is complete, (See figure 11).



Figure 11



Figure 9

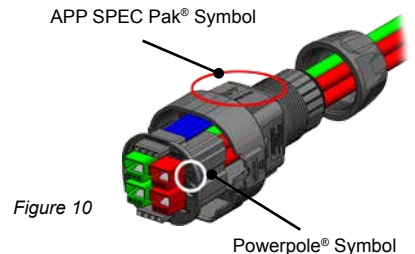


Figure 10