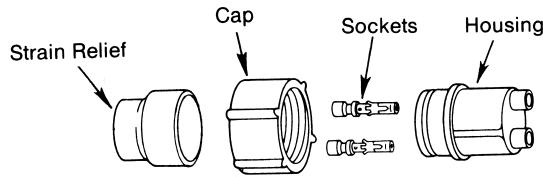
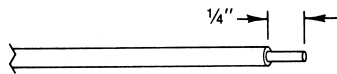


High-Voltage Plug Attachment

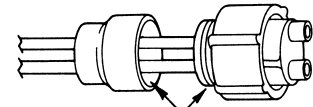


NOTE: Applies to 2, 4 and 7 pin high-voltage connectors.

Use Corona-Resistant High-Voltage Wire
 15KV Rating
 AWG #16 Max. Conductor
 .20 Max. Wire Insulation Diameter

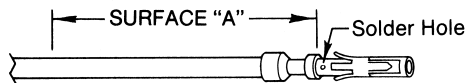


STEP 1 . . . Strip insulation back 1/4" from the end of all cables and pre-tin the conductor.

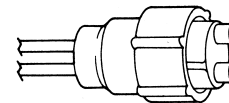


Apply cement at these locations

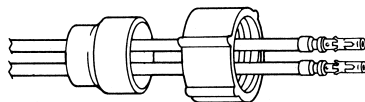
STEP 4 . . . Insert cable/socket assemblies in cavities of the housing until they lock into place, and moisture cure the "RTV-108" at 100% humidity and 140°F for 1 hour. This will seal cavities before final potting. Slip cap over housing and cement strain relief to the housing.



STEP 2 . . . Apply socket to the conductor by pushing it up against the insulation and solder onto the conductor. Clean SURFACE "A" (2 inches minimum) thoroughly with alcohol and apply a thin coating of "RTV-108" or equivalent.



STEP 5 . . . Once the strain relief is attached, pot the strain relief and housing with Hysol #4215 or equivalent by pouring through the strain relief. (Potting mixture to be 100 parts of Hysol #4215 to 15 parts Hardener #3561.)



STEP 3 . . . Clean the inner surfaces of the housing and strain relief thoroughly with alcohol. Slide the strain relief and the cap over cables.