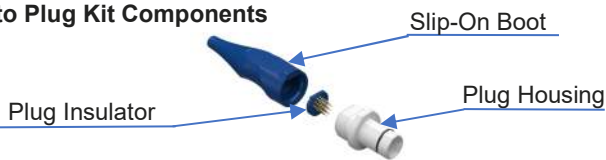


# Assembly Instructions

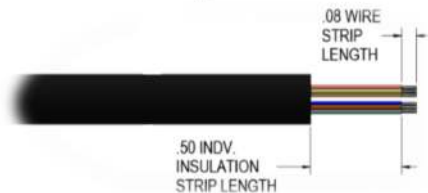
## Pluto® Plug Kit

### Pluto Plug Kit Components



### Assembly Instructions

1. Process the cable by stripping, twisting, and tinning wire ends following the recommended specifications



- a. Strip the cable to insulation strip length



- b. Strip the insulation to wire strip length



2. Slide the slip-on boot over the cable



3. Remove the pinned insulator from the plug housing

- a. Use caution so as not to push insulator too deeply into the housing

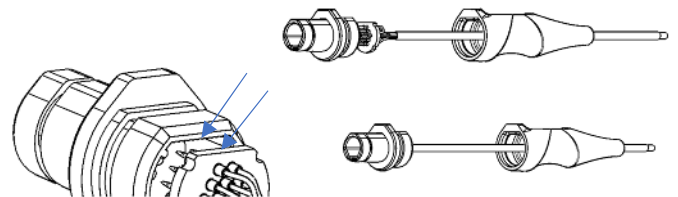


4. Solder wires to corresponding pin in insulator

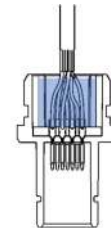
- a. If the cable is shielded, pull shield back before soldering the wires



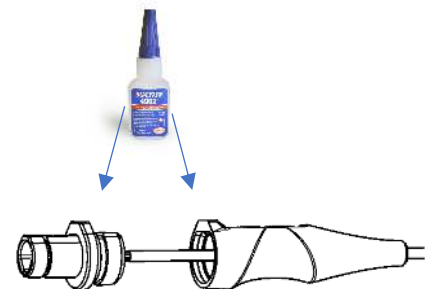
5. Install the pinned insulator into the plug housing by aligning the components along the flat edge at the top of their tear drop silhouettes



6. If applicable, back fill the back of the housing with epoxy.



7. Align the plug housing with the boot along their tear drop silhouettes and apply Loctite 4902 on the boot and housing mating interfaces



8. Press the housing onto the boot

