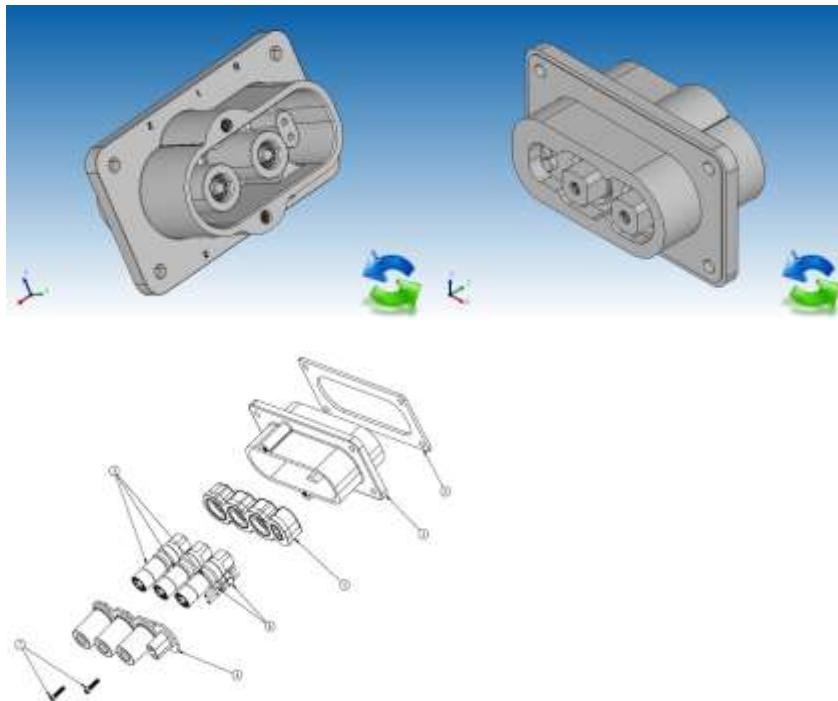


Assembly Process for the ePower 400A Receptacles and Plugs

Receptacle with Bus bar Termination: 10-643580-XXX



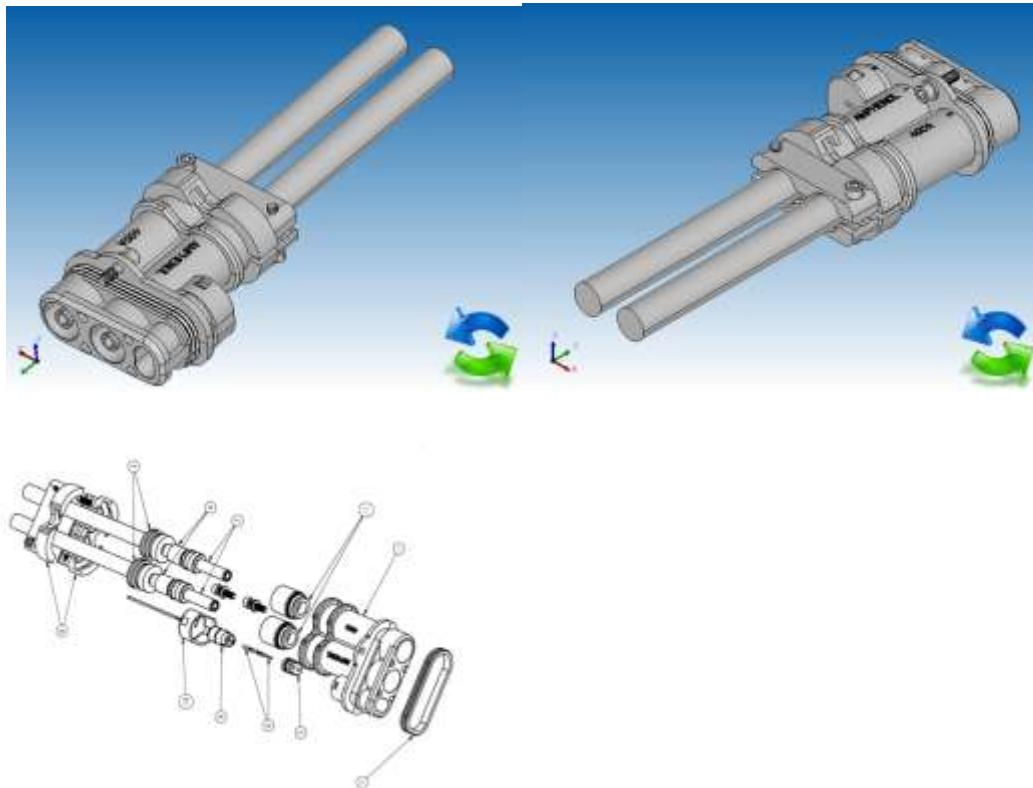
Exploded view depicted here is for explanatory purposes only, connectors are shipped assembled.

Item 1	Receptacle shell
Item 2	Flange Gasket
Item 3	3x Power Sockets 11.1mm
Item 4	Insulation
Item 5	Backcap
Item 6	2x 16 awg HVIL Sockets
Item 7	2x M3 x .5 – 14mm Long Screws

1. Place flange gasket over rear of receptacle
2. Prepare the customer supplied 16 awg HVIL wires by removing wire jacket 5/16 inches from cut end
3. Crimp wire into socket using M22520/1-01 crimp tool and Daniels TH29-1 or equivalent turret
4. Insert crimped socket assembly into HVIL section of insert
5. Repeat process with second HVIL socket assembly
6. Pull two or three wires with crimped lugs through opening in panel depending on number of positions purchased

7. Attach to rear of power socket using M6x1.0 screws (customer provided) Torque value to be not less the 5.5 NM
8. Attached Receptacle to panel using customer provided and customer specified screws.

Plug with Crimp Pin Termination: 10-643579-XXX



Item 1	Plug Shell
Item 2	3x Power pins - 11.1mm
Item 3	3x Power Cable Grommet
Item 4	3x Contact Heat Shrink Tubing
Item 5	HVIL Contact Insert
Item 6	2x 16awg HVIL Contacts
Item 7	Barrel Seal
Item 8	Cable Clamps
Item 9	HVIL Contact Grommet
Item 10	HVIL Contact Grommet Cover
Item 11	3x Power Pin Insulation
Item 12	2x M6x1.0, 20mm Long Hex Head Screw
Item 13	2x M6x1.0, 30mm Long Hex Head Screw
Item 14	2x M6 Lock washers

1. Prepare 50mm² / 70mm² power wire according to *Customer Reference* (page 3) on drawing 10-643579

a. Crimp conductor wire into power pin using a Greenlee HK06FT 4 indent or similar crimp tool

- b. Slide grommet over cut power wire and roll back exposed wire shielding over grommet
 - c. Position heat shrink tubing over contact crimp joint and heat evenly until tight. The heat shrink tube is positioned directly in front of the shielding to prevent electrical conductivity from contact to shielding.
2. Insert pin insulators (3) within the plug shell contact bores until completely seated
3. Insert power pin assemblies individually into the plug shell until firmly seated within pin insulators seated
4. Prepare the customer supplied 16 awg HVIL wires by removing wire jacket 5/16 inches from cut end
5. Crimp wire into HVIL 16 awg pins using an M22520/1-01 crimp tool and a Daniels TH29-1 or equivalent turret
6. Install HVIL insert and then grommet into plug shell
7. Insert crimped pin assembly (one at a time) through HVIL grommet until pin is firmly seated in HVIL contact insert
8. Install grommet cover over HVIL assembly
9. Slide barrel seal over front of plug shell
10. Position clamp bars above and below rear most rib on plug shell insuring cable end is in contact with the three power cables
11. Tighten clamp bars using the two screws (M6x1.0, 30mm long hex head screws), in opposite driving direction to one another, using a 5mm hex head wrench and torque until cables are securely held while keeping both clamps parallel to each other.
12. Attach plug to receptacle after mating, using two M6 lock washers and two M6x1.0, 20mm long, hex head screws using a 5mm hex wrench. Screws are supplied with the assembly. Torque to 20 foot lbs.