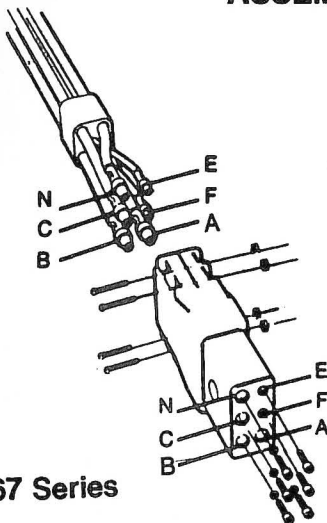


# ASSEMBLY INSTRUCTIONS FOR ATTACHABLE® CONNECTORS SERIES R67 PLUGS (MS25486)



## R67 Series

1. Identify conductor size being used and match the proper R67B assembly kit. Each kit includes crimp-type barrels for specific conductor sizes.
2. Strip outer jackets of power conductors 1 $\frac{3}{4}$ " and inner jackets 1 $\frac{1}{4}$ " (Strip off 1 $\frac{1}{4}$ " from 1-piece jackets). Crimp barrels on the wire using an MS25441 hydraulic crimping tool and appropriate MS90485 die. (Anderson Electric Corp. VC7 is acceptable substitute, make two crimps approx. 1/2" apart and 1/4" from the end of the barrel.) *The AN3427 standard tool may be used for crimping, however, the wire-size index on that tool must then be set for one size smaller than recommended, i.e., for 1/0 AWG wire the index should be set at 1 AWG wire position.*
3. For control conductors, strip outer jackets of two-conductor 12 AWG cable 1 $\frac{3}{4}$ " and inner jackets 1/2". Crimp to smaller barrels using an MS17776 hand-crimping tool. If control conductors are not used, strip ends of the 12 AWG jumper (supplied with each plug) 1/2" and crimp barrels as described.
4. For the *Power Conductors* cover crimp joints, exposed conductors, and jackets with *heat-shrink tubing* supplied. Use glass cloth electrical tape 3M #27 or equivalent to cover the crimp joint, exposed conductors and jackets of the control wires (#12 AWG).
5. Mount plug in vise just behind the contact area.

**NOTE:** The following steps require the use of Assembly Tool Kit 111239G2. The kit contains six threaded pull-rods, a contact holding tool, and a 3/8" drive socket fitted to a 5/32" hex rod permitting the use of a torque wrench (Snap-On Tool #FA-5L).

6. Insert threaded pull-rods through the E and F control contacts in front of the plug and screw them into appropriate barrels. Pull up barrels until they are seated in their sockets at rear of contacts. Where no control conductors are used proceed as above using the jumper prepared in Step 3 to jumper the E and F contacts.
7. Remove the pull-rods, insert 5/8" long socket head screws *without lockwashers* (E and F only) and hand tighten.
8. Insert a pull-rod through the A power contact in front of the plug and screw it into the barrel of the A conductor. Pull up the barrel until it is seated in the socket at rear of the contact. Remove the pull-rod, insert a 5/8" long socket head screw *with lockwasher*, and hand tighten.
9. Repeat Step 8 for the B, C, and N power conductors.
10. Push the contact holding tool into the A contact with the holding tool fin engaged with two of the slots in the contact cylinder. Using a torque wrench fitted to the 3/8" drive socket/hex rod, insert the hex rod through the holding tool opening; tighten the screw to 45 inch-pounds. Repeat this operation for the B, C, and N contacts tightening each to 45 inch-pounds. Tighten the screws for the E and F contacts to 45 inch-pounds, using the torque wrench/hex rod only.
11. Check the proper seating of the barrels by striking the plug on floor several times. Retighten as required (Follow Step 10).
12. Press cables through the slits of the rubber cable packing.
13. Using water only as a lubricant, force the cable packing into the rear of the plug, past the lip. If necessary, use a steel bar across the cable packing to seat it into its proper place.
14. Secure the cable packing at rear of the plug with screws and nuts provided; tighten until cable packing holds cable securely.
15. Rubber cement the red catalog-number button into a recess in the plug body.
16. Check all connections for continuity. Make sure that all cables are correctly wired to their respective contacts.
17. Band cables 12" from rear of the plug and every 24" thereafter.

## MAINTENANCE INSTRUCTIONS

Periodically, check the torque on contact screws and clean contacts using a 38-caliber wire bore brush and a small amount of neat's foot oil or petroleum jelly, and wipe clean.