

# AIRCRAFTPLUGS®

## 400 Hz 115V CONNECTOR – 6 POLES RUBBER ASSEMBLY INSTRUCTIONS



ASSEMBLY INSTRUCTION FOR AIRCRAFTPLUGS® 400 hz 115V 6 poles rubber , P/N ACP6P1

### Content of packaging :

- 1 Aircraftplugs 6 poles connector.
- 1 Cable grommet.
- 4 Silver plated main contacts cable lugs
- 2 Silver plated E & F cable lugs.
- 6 Stainless steel bolts M5 x 60
- 6 M5 stainless steel nuts, with washers
- 2 M5 x 25 hexa-key bolts, with washers.
- 2 M4 x 25 hexa-key bolts, with washers
- 1 Optional cable insert tools.

### Instruction - procedure :

Strip 45 mm (1 3/4 inch) insulation from the outer jacket of each main wire  
Slide the rubber grommet over the cable ends (about 80 cm or 30 inches for easy working).  
Insert the conductor stranding into the crimp lug, (Take care not to damage the conductor stranding.)  
Crimp the cable lugs on the wire (die markings are made onto the lugs).  
Proper attachment of lugs is a must, as they must take a lot of power, and because they are at the ends of the leads, they also take strain from all the movement they will see during their life time.  
Aircraftplugs® hydraulic tool and die available. Make 2 crimps for safety.  
Soldering lugs are available.  
If using the soldering procedure, allow solder to flow into the wires for secure durable contact.  
Perform above procedure for E & F contact.  
Cover the crimp joints  
Conductor insulation or heat shrink is available from aircraftplugs®  
Insert the Aircraftplugs® threaded pull-rods through the control contact in front of the 6 poles connector and screw them into the appropriate terminals using the M5 bolt.  
Tighten the screw with a torque of 5 Nm (45 inch/lbs) for the power contacts.  
Slide the rubber grommet inside the 6 poles connector and secure by using the 6 stainless steel bolts and nuts.  
Do a continuity check to confirm all cables, lugs are connected to the correct terminal.  
Recheck the torque on the bolts.  
Band cable every 30 cm (12 inches) from the rear of the 6 poles and then every 60 cm (24 inches).  
Check frequently the torque on the contact metric 5 screws and clean the contact frequently.  
If the 6 poles rubber is damaged replace the connector

Pictures and data are non binding and can be changed by the manufacturer without notice

### **Aircraftplugs®**

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