FP334 PLUG TO BE USED WITH CROUSE-HINDS DVSQ 14133

DISASSEMBLY PROCEDURES FP334 PLUG

1. Hold plug (1) with contacts (2) (5) facing you and with opening in retaining ring (3) pointed upward. Remove copper plated ring (3) from front of plug (1) using screwdriver blade behind right hand end of spring (3) to pop end of spring loose and lift spring out of plug housing (1).
2. Remove insert and contact subassembly (4) from front of plug shell (1).
3. Using screwdriver disassemble all two piece contacts (2) except grounding contact (5).

ASSEMBLY PROCEDURE FP334 PLUG

1. Slide cable clamp (6), rubber grommet retaining ring (7), rubber grommet (8) of appropriate size, (use one that fits snugly on cable), and plug shell (1) over cable.
2. Strip cable sheath 2 inches.
3. Strip three power lead conductor sheaths 1/2 inch.
4. Cut 1/2 inch from grounding lead and then strip it 1/2 inch.
5. Solder three power leads into solder wells (9) in rear part of contacts (2). Use care to prevent excess solder from getting on contact surface and hardening, this may prevent clearance into respective contact silo recesses (10).
6. Insert soldered terminations into appropriate recesses, as follows:
   A. Nickel plated contact into well "N".
   B. Brass contacts into contact wells marked A and B respectively.
   C. Terminate ground lead in pressure lug well and tighten screw securely.
7. Place one fiber insulating washer (11) over each female contact (2). Small shoulder of fiber washer is to be towards threaded end of contact. Screw together three two piece contacts (2). Note that nickel plated contact is engaged in insert recess "N". Torque all contacts, including grounding contact, to 20-25 in./lbs.

MAINTENANCE RECOMMENDATIONS

A preventive maintenance program should be set up for FP plugs.
Plug contacts, plug bodies and cable clamps should be inspected before each use for signs of damage or overheating.

WARNING

If signs of these conditions exist DO NOT USE the plug. REPLACE IT immediately to prevent property damage possible personnel injuries.

8. Install wired insulator assembly (4) into plug shell noting notch (12) must engage polarizing rivet inside plug shell.
9. Seat insert assembly (4) and install copper plated insert retaining ring (3) into undercut of plug sleeve (1) installing left end first then pressing around toward right end until ring is seated in slot.
10. Slide rubber grommet (8), retaining ring (7) and cable clamp (6) towards plug. Tighten cable clamp (6) nut securely. Push inward on cable and tighten two cable clamp screws (13) securely. Tighten cable nut locking screw (14) securely. Plug is ready for use.

Figure 1

Figure 2

FP334 PLUG ASSEMBLY