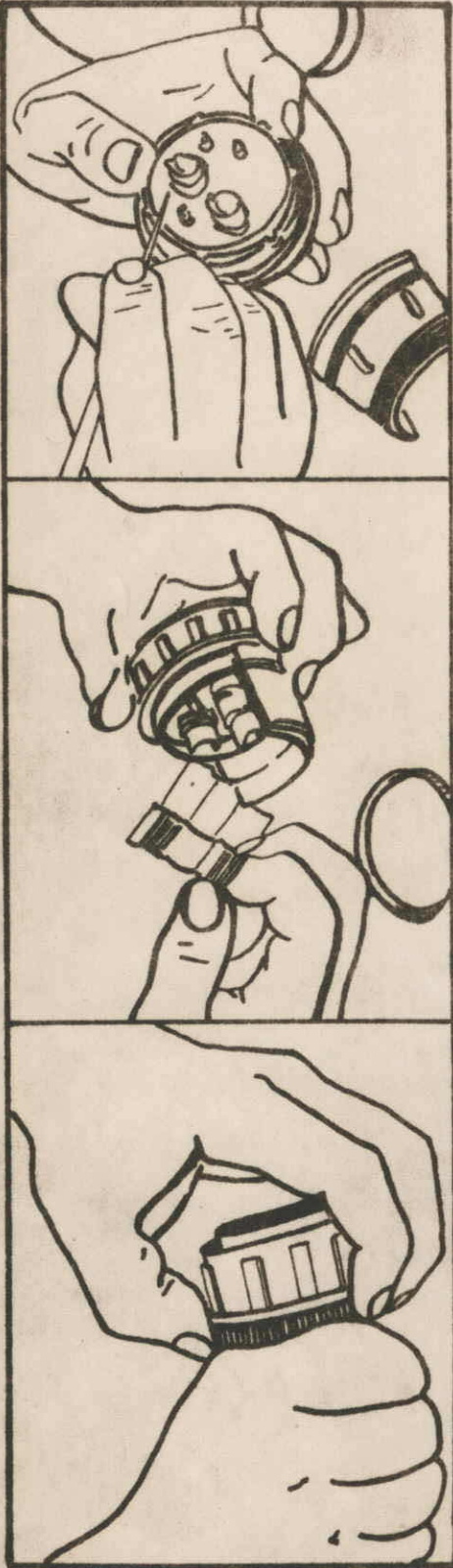
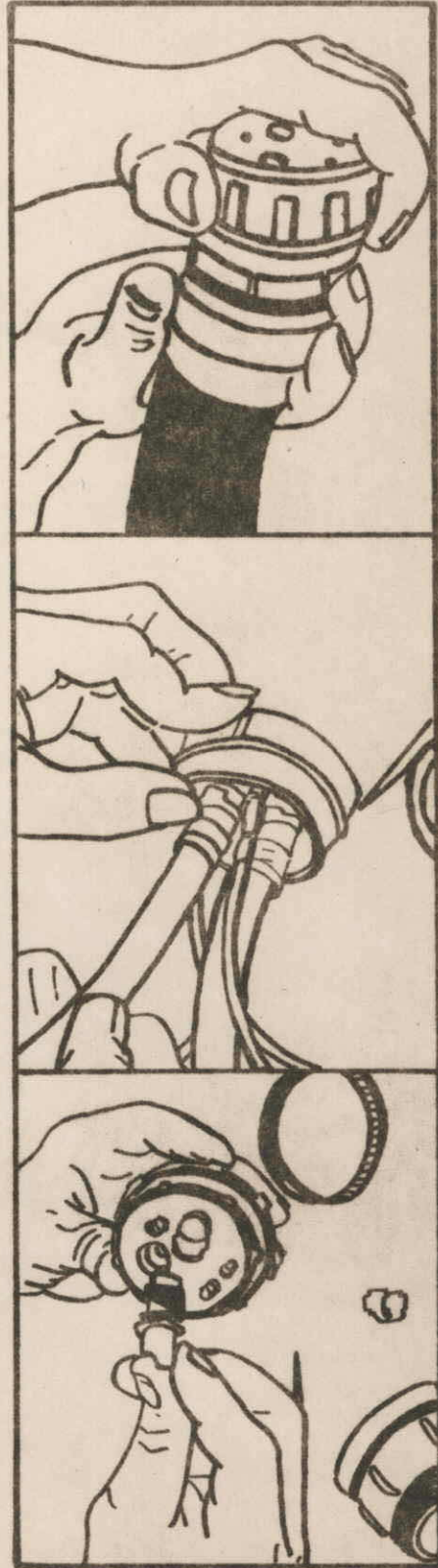




1. When disassembling connectors, grasp the split end bell firmly over the bosses while unscrewing assembly ring.

2. With assembly ring removed, both halves of end bell are lifted off, exposing terminal ends as shown below.

3. The spring clip which locks large terminals in place in the insert is pried up and slipped off.



4. Large contacts are then given a quarter-turn and lifted out of the phenolic insert. They are then ready to solder.

5. Replace large contacts in insert after soldering and give quarter-turn; replace clip and slip forward through insert disk.

6. Both halves of end bell are replaced and locked together by coupling nut. Cable is supported by cable clamp.

When soldering wires into lugs, it is necessary to **TIN THE FLEXIBLE LEADS ALL THE WAY THROUGH BEFORE** soldering into lugs. **AFTER SOLDERING**, use a wiping cloth with water or solvent and **REMOVE ALL FLUX**.