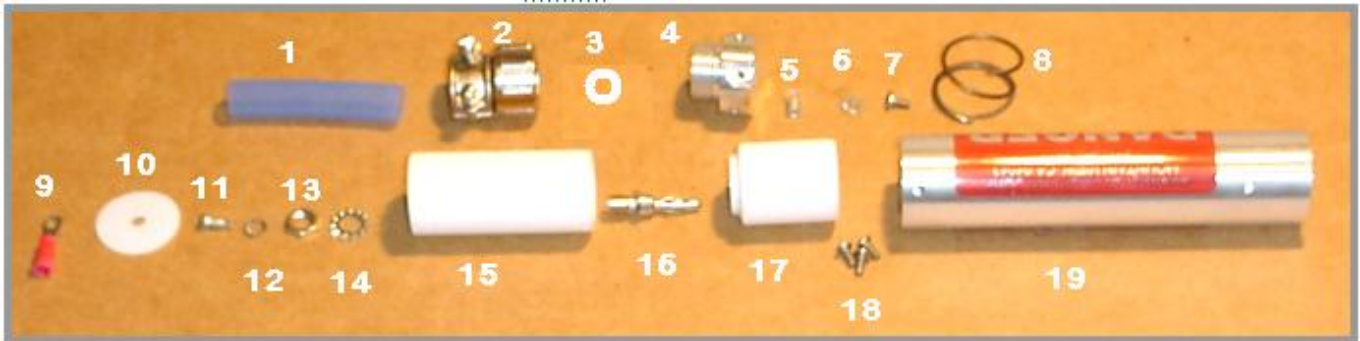


# Ion Pump Connector Kit Assembly Instructions

## V-100-X (Bakeable)



**Figure 1 – V-100-X Parts Kit**

**Parts List: Left to Right.**

**Top Row:**

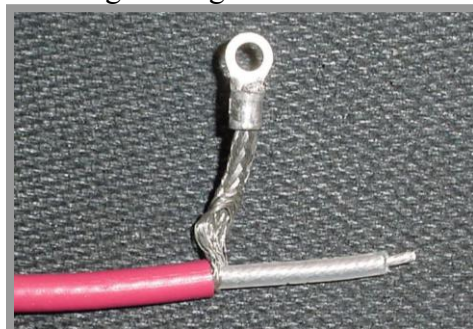
1. Silicone Boot (color may vary)
2. HV Cable Strain Relief Clamp
3. Washer – Tefzel – 11/16”
4. Threaded Aluminum Plug
5. #6 Spade Lug for HV Wire
6. Washer for Ground Braid Lug
7. Screw for Ground Braid Lug
8. Spring

**Bottom Row:**

9. #4 Stud Lug for Ground Braid
10. 1” Tefzel Washer
11. #6-32 Screw for HV Wire Lug
12. Flat Washer
13. Nut
14. Star Washer
15. Lower Ceramic Insulator
16. Banana Plug
17. Upper Ceramic Insulator
18. #4-40 Screws (3)
19. Aluminum Shield

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**Assembly Instructions:**

1. Thread the Shielded High Voltage Cable (Not included in Kit) through the Silicone Boot (1) and High Voltage Cable Strain Relief Clamp (2) and the Tefzel Washer 11/16” (3) and Threaded Aluminum Plug (4). Leave 8-10 inches of cable exposed for working room.
2. Prepare the cable end as shown in Figure 2, so as to have a separate braided grounding wire approximately 1-1/4” long and a high voltage wire with 1” of insulation and 1/4” of conductor.



**Figure 2 – HV Cable Prep**

3. Crimp the #4 Stud Lug (9) onto the end of the braided grounding wire.
4. Install the 1" Tefzel washer (10) over the insulated portion of the high voltage wire.
5. Remove the red insulating coating on the #6 Spade Lug (5) and crimp it onto the end of the high voltage wire. Bend the Spade lug 90 degrees away from the high voltage wire where the flat part meets the crimped portion.
6. Using the #4-40 screw (7) and the washer (6), fasten the braided grounding wire lug (9) to the only recessed threaded hole on the Threaded Aluminum Plug (4).
7. Install the Spring (8) over the High Voltage Wire between the Tefzel Washer (10) and the Threaded Aluminum Plug (4).



**Figure 3 - Assembly Through Step 7**

8. Install the Banana Plug (16) into the Lower Ceramic Insulator (15) using the Nut (13) & Star Washer (14)
9. Attach the High Voltage Wire Lug (5) to the Banana Plug (16) with the #6-32 Screw for HV Wire Lug (11) and the Flat Washer (12).
10. Insert the Upper Ceramic Insulator (17), large ID portion first, into the Aluminum Shield (19) through the end with the three holes.
11. Insert the assembled High Voltage Cable with Lower Ceramic Insulator (15) into the Aluminum Shield (19), being sure that the three threaded holes on the OD of the Threaded Aluminum Plug (4) line up with the three holes in the Aluminum Shield (19)..
12. Compressing the Spring (8), press the HV Cable Assembly into the Aluminum Shield (19), line up the three holes in the Aluminum Shield (19) and the Threaded Plug (4), and install the three remaining #4-40 Screws (18)..



**Figure 4**