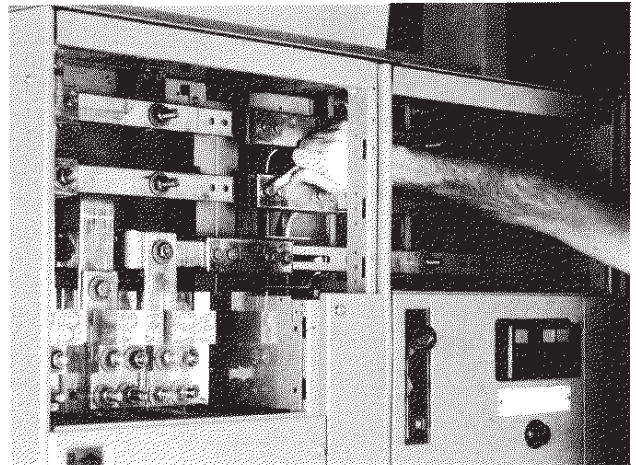

Power Bus Splicing

- I-13** Connect the power bus splice connections (repeat for all phases). On the integral splice assembly, located on the left side of each phase bus, the number of bus links is one

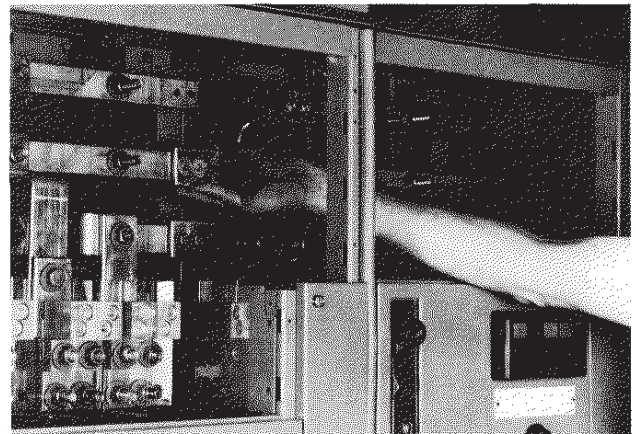
greater than the number of horizontal bus lamination in order to create a sandwich splice. The rear-most splice link contains the captive nut.

- I-13A** Remove the two left bolts. Loosen, but do not remove, the two right bolts on the splice assembly.

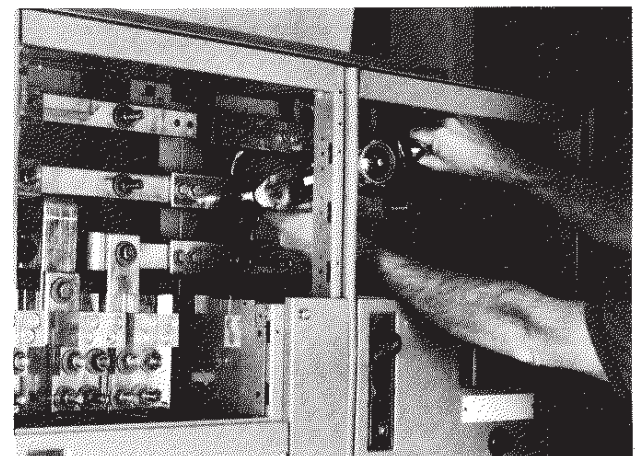
CAUTION: Do not remove the two right bolts from the splice assembly.



- I-13B** Grasping the bottom of the splice assembly, slide the bus links to the left until the two left holes are in line with the corresponding holes in the horizontal bus on the left section.

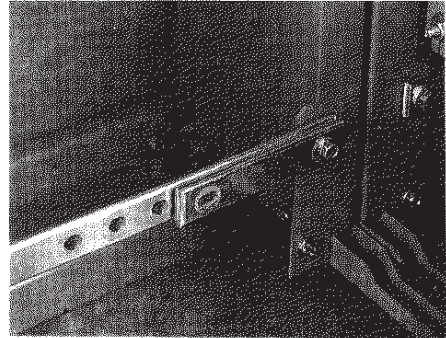


- I-13C** Re-install the two bolts, on the left, through the splice links, and into the horizontal bus being sure to use the original washers provided. Torque all bolts, on both ends, to 370-385 pound-inches.

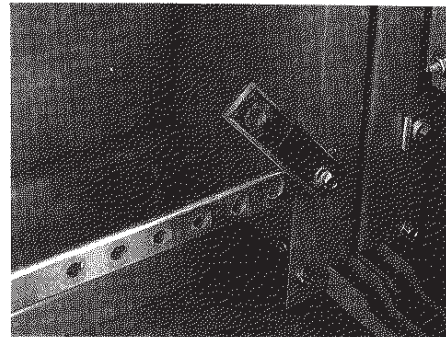


Ground Bus Splicing

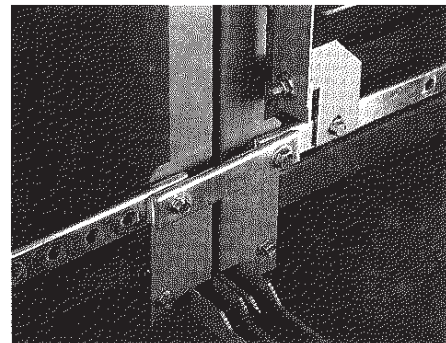
I-14A Remove the ground bar bolt from section R and loosen the bolt in section L.



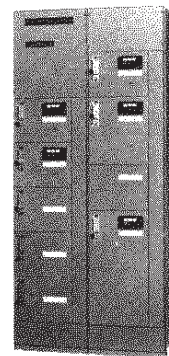
I-14B Rotate the ground splice bar into section R, aligning the mounting holes.



I-14C Replace the ground bar bolt and tighten both bolts to 60-75 pound-inches.



I-15 Replace all covers and barriers and close doors.



Conductor Entry

I-16A Access to the main lug, main breaker, or main switch compartment is gained through a hinged door and, in some cases, removal of the horizontal wire trough cover. The top plates (and closing plates in bottom, if present) are removable for convenience in wiring and cutting conduit openings.

If the cable is brought into the top of the motor control center, the cable can be supported at the point of entry and the top plate by a 5" or smaller conduit, SQUARE-Duct® wireway, or a grommet centered over terminal L2.

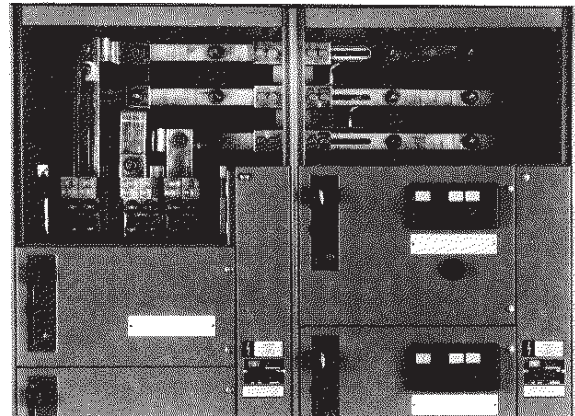
When the entrance of cables is at the bottom and the cables are required to go to lugs at the bottom of the section, the incoming line cables can be supported at the point of entry by a 5" or smaller conduit centered on the L2 terminal.

Additional wiring space can be gained with the addition of a pullbox. **NOTE: FOR MAXIMUM AVAILABLE FAULT CURRENT THE INCOMING POWER WIRING MUST BE SUPPORTED AND RESTRAINED BY THE CUSTOMER WHEN SPECIFIED. REFER TO THE LABEL INSIDE THE MAIN COMPARTMENT DOOR.**

For available fault currents over 42,000 amperes RMS symmetrical, further support can be added by restraining cables with a tight lacing of 3/8" hemp rope or a material of equal strength. Begin lacing cables together as close as possible to lug connection points in the incoming line compartment and continue lacing to the conduit entry point. The first and last ties should be anchored securely to the motor control center frame to prevent slipping. The label inside the main compartment door specifies the spacing to be used for any required lacing.

Where more than one main lug compartment is furnished for required ampacity, refer to Article 310-4 of the National Electrical Code to assure equal division of total current between all incoming line cables involved.

MAIN LUG COMPARTMENTS			
Socket Size Across Flats (Inches)		Torque in Pound - Inches	
3/8		375	
MAIN & BRANCH FEEDERS			
Frame Size	Ampere Rating	Torque in Pound-Inches Pound-Feet	
FA	15-30A	35	3
	35-100A	80	7
	20-30A	35	3
FC	40-100A	65	5
	70-225A	250	21
	110-250A	250	21
KA KC LA	125-400A	200	17
	200-400A	300	25
	450-1000A	300	25
PA	800-2000A	300	25



Load and Control Wiring

I-16B The top and bottom horizontal wire troughs and the vertical wire trough provides a convenient area to run load and control wires. Openings between sections permit the wire to pass through from one section into the next for interwiring.

Because of the intersection of the vertical and horizontal wire troughs, wires may be routed without the use of fish tapes.

Control and load wires are routed to each unit via wire ports. These ports open into the vertical wire trough permitting control and load wiring to enter easily. After wires are installed, the wires should be tied down with the wire ties provided in the vertical wire trough.