



INFORMATION SHEET FOR EC213  
PLUG RECEPTACLE KIT  
FOR EC1000, EC2000, EC3000, EC4000 & WTT1000

Kit includes the following parts:

- |                                      |                                |
|--------------------------------------|--------------------------------|
| 1 - Locking Receptacle               | 1 - Plug Housing               |
| 3 - Gold Plated Male Crimp Pins      | 3 - Tin Plated Male Crimp Pins |
| 1 - Crimp Screw Terminal             | 1 - Cord Guard                 |
| 6 - Color Coded Leads with Terminals |                                |

CAUTION: DISCONNECT POWER CORD BEFORE ATTEMPTING TO REPLACE RECEPTACLE.

POWER UNIT:

1. Remove bottom cover from power unit.
2. Desolder all receptacle leads from control board.
3. Cut both green leads at transformer frame connection.\*  
Cut green lead at control board and discard (early production units of EC1000/2000 only).
4. Remove transformer hold down screw and discard screw \* terminal.
5. Remove and discard receptacle.
6. Insert color coded leads in receptacle (refer to illustration for proper color code to pin number correlation).
7. Install new receptacle in upper housing. Make sure receptacle antirotation key is engaged in slot in housing. Bend plastic ears on receptacle upward to hold receptacle.
8. Solder wires to control board; refer to illustration for proper hookup.
9. Crimp or solder green lead from receptacle and green lead from power cord to screw terminal and reinstall it to transformer frame with transformer hold down screw.\*
10. Reinstall bottom cover and replace rubber feet.
11. Turn the power unit on and perform the following voltage and current tests.

WARNING: Momentary contact with receptacle pins other than those indicated may damage the electronic components. Turn unit off when making connections.

EC1002A/2002A

Pin 3 to Pin 4--7.35 volts D.C. +/- .5 volts  
Pin 1 to Pin 2--27 VAC +/- 3 VAC (pins 3 & 4 shorted)  
Pin 5 to other pins--.5 MA AC or D.C. Max.

EC3002A/4002A

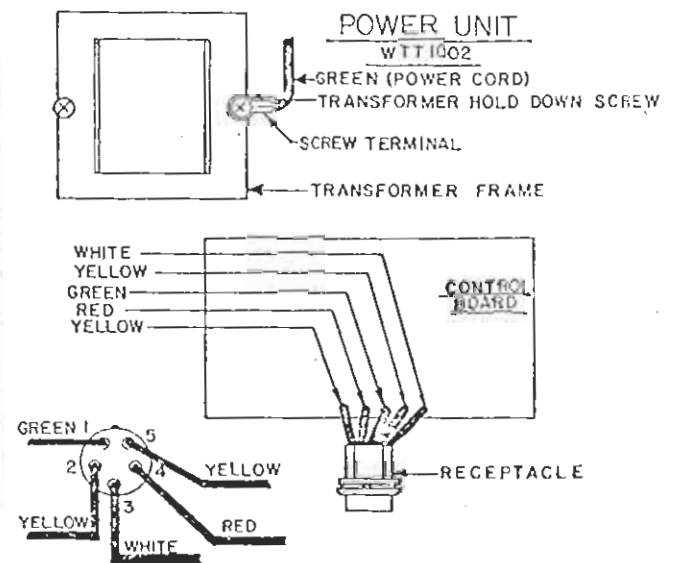
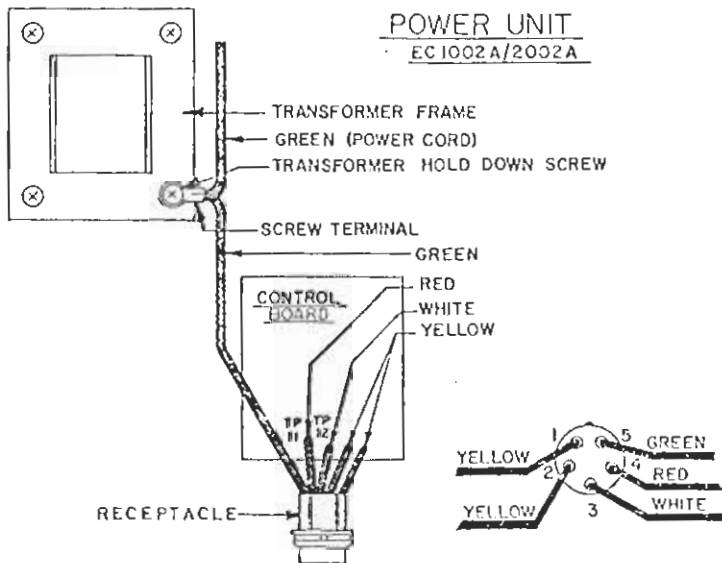
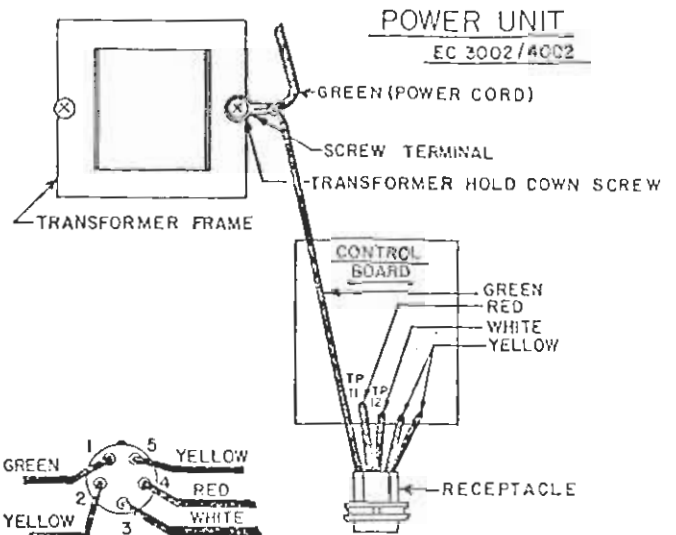
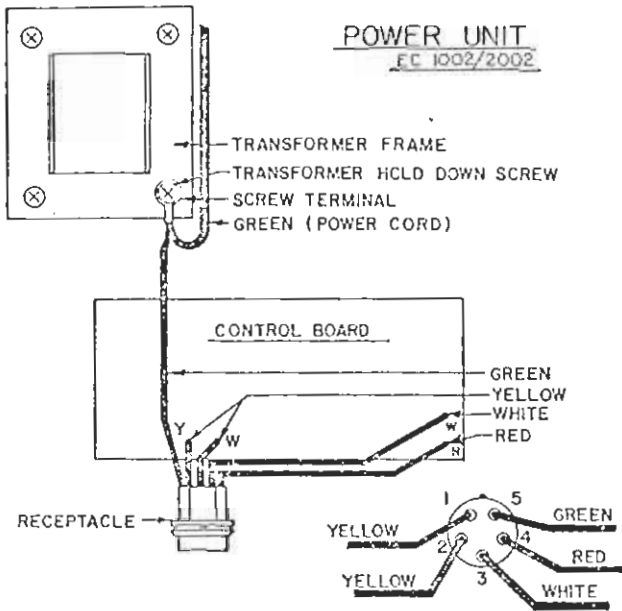
Pin 3 to Pin 4--7.35 volts D.C. +/- .5 volts  
Pin 2 to Pin 5--24 VAC +/- 3 VAC (pins 3 & 4 shorted)  
Pin 1 to other pins--.5 MA AC or D.C. Max.

WTT1002

Pin 1 to Pin 3--7.35 volts D.C. +/- .5 volts  
Pin 1 to Pin 4--7.35 volts D.C. +/- .5 volts  
Pin 2 to Pin 5--24 VAC +/- 3 VAC (pins 1 & 3 shorted)

Recheck wire hookup and/or refer to troubleshooting guide for unit if test is failed.

\* These steps do not apply to the WTT1000.





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SOLDERING TOOL:

1. Cut off existing plug.
2. Trim outer jacket 5/8" and remove filler threads.
3. Strip and tin leads 1/8".
4. Slide cord guard on cord (refer to illustration).
5. Crimp and solder two gold pins and three tin pins to leads (refer to illustration for proper color code hookup). Use minimum solder in crimp area only. (WTT1001 - three gold pins)
6. Insert pins in plug housing (refer to illustration for color code to pin no. correlation).
7. Align cord guard slot with housing key, compress strain relief fingers against cord and insert housing in cord guard. Force cord guard over housing key by placing housing face against a flat surface. Key should snap into slot.
8. Perform the following resistance tests before plugging iron into power unit:

EC1201A or EC1201 (converted to EC1201A)

Pin 3 to Pin 4--21-27 ohms  
Pin 1 to Pin 2--12-14 ohms  
Pin 5 to tip--1 ohm max.  
Pin 5 to all other pins--10 megohms min.  
Pin 1 to Pin 3--10 megohms min.

EC1301

Pin 3 to Pin 4--21-27 ohms  
Pin 2 to Pin 5--25-30 ohms  
Pin 1 to Tip--1 ohm max.  
Pin 1 to all other pins--10 megohms min.  
Pin 2 to Pin 3--10 megohms min.

WTT1001

Pin 3 to Pin 4--4 ohms max.  
Pin 3 to Pin 1--6-8 ohms  
Pin 4 to Pin 1--6-8 ohms  
Pin 2 to Pin 5--45-52 ohms  
Pin 1 to Tip--10 ohm max.  
Pin 2 to Pin 1--10 megohms

Recheck wire hookup and/or refer to troubleshooting guide for unit if the test is failed.

