



M. C. Miller Co., Inc.

MAN380

11640 U.S. Highway 1, Sebastian, Florida, U.S. A.

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“AccuRef / IonX 40 Splice-able Permanent Electrode” Instruction Manual

Item # 14631: AccuRef20 (Copper/Copper Sulfate) Splice-able Electrode

Item # 14628: AccuRef30 (Copper/Copper Sulfate) Splice-able Electrode

Item # 14625: AccuRef20 (Silver/Silver Chloride) Splice-able Electrode

Item # 14605: AccuRef60 (Silver/Silver Chloride) Splice-able Electrode

Item # 14350: IonX 40 Splice-able Permanent Reference Electrode

Basic Components:



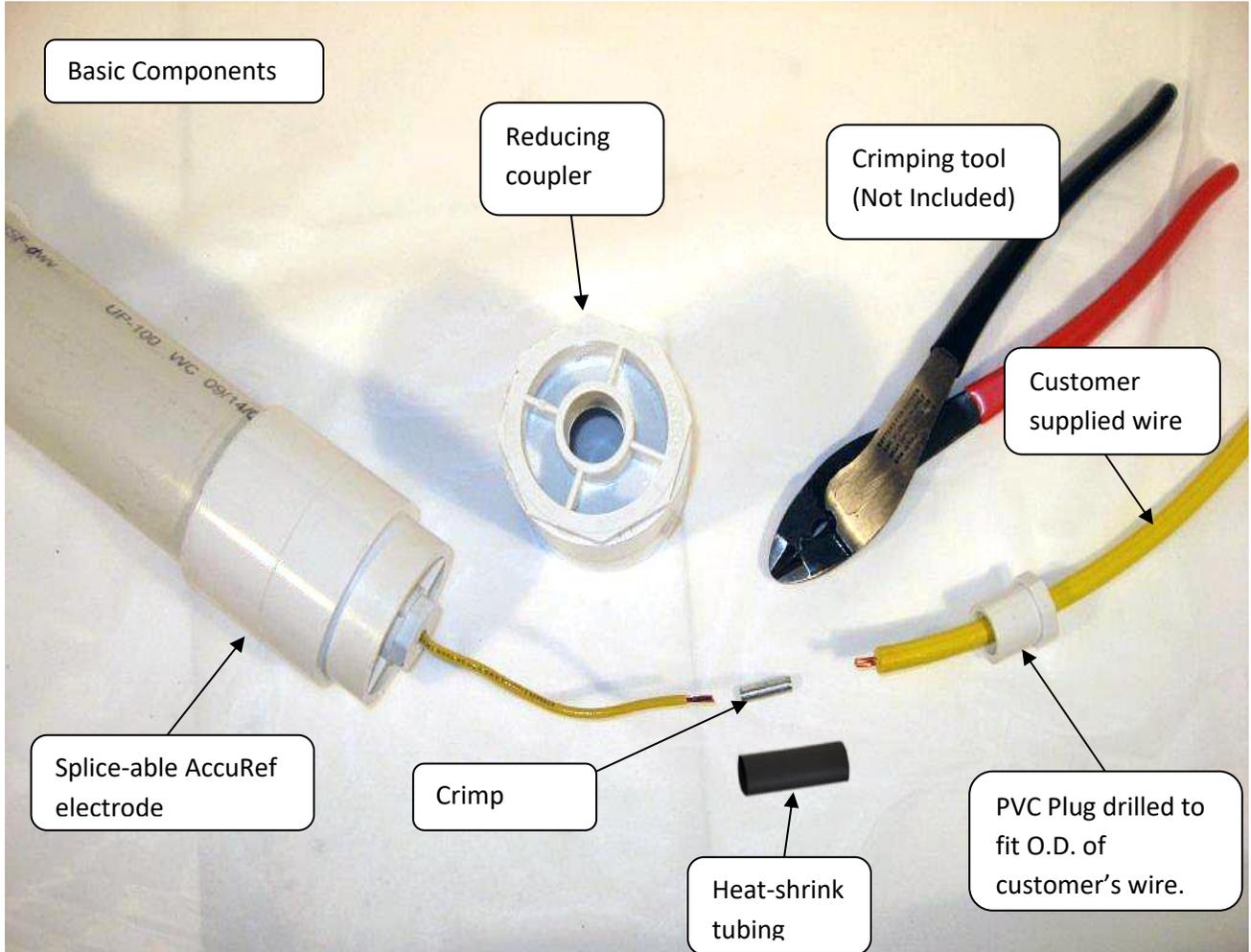
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Step 1: Wire Preparation.

Strip an appropriate length (about 3/8" or 9.5mm) of your wire to be attached to the Permanent Electrode as shown below.



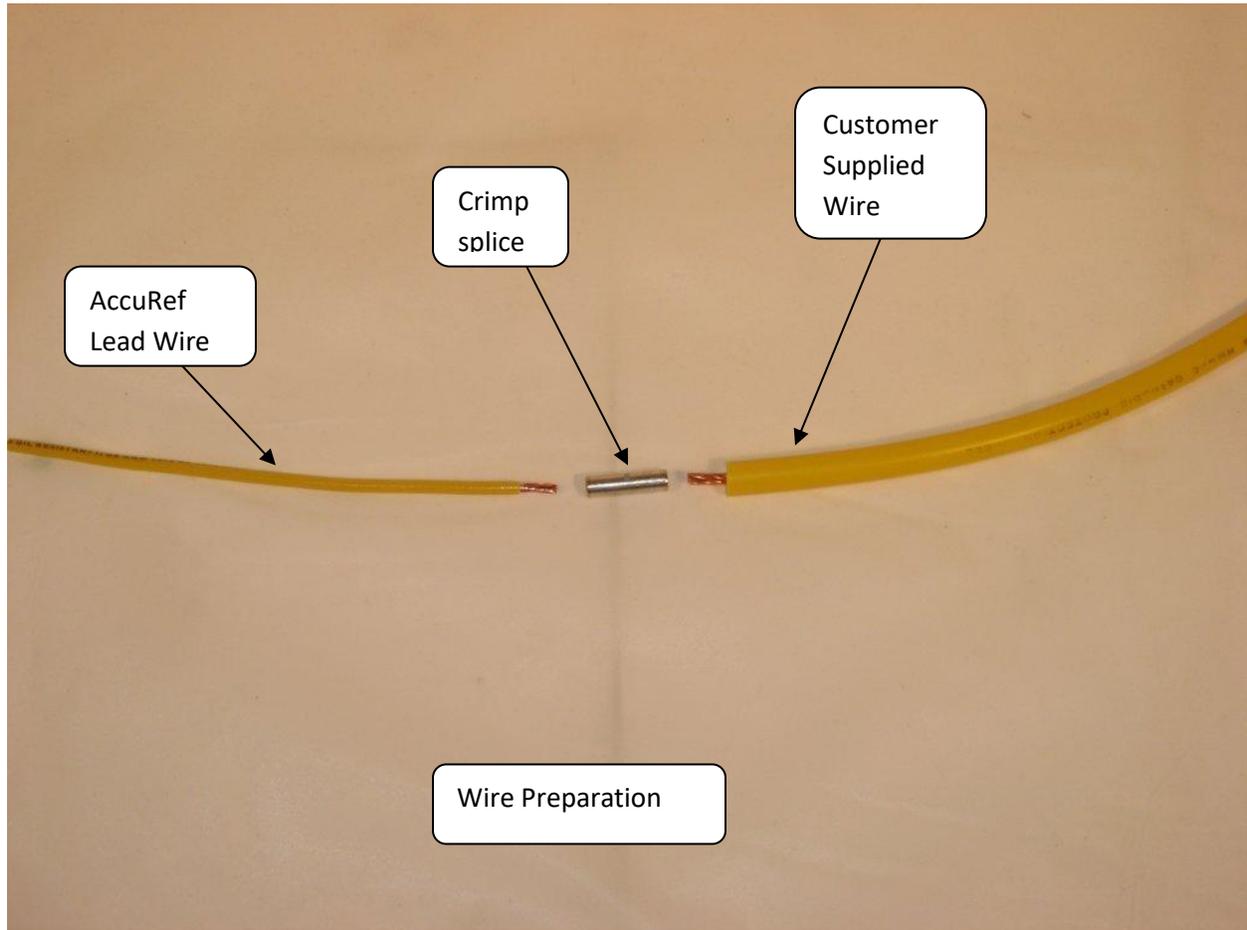
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Step 2: Plug Preparation.

Drill out the PVC plug to provide a tight fit over your wire.

Step 3: Sealing the Plug.



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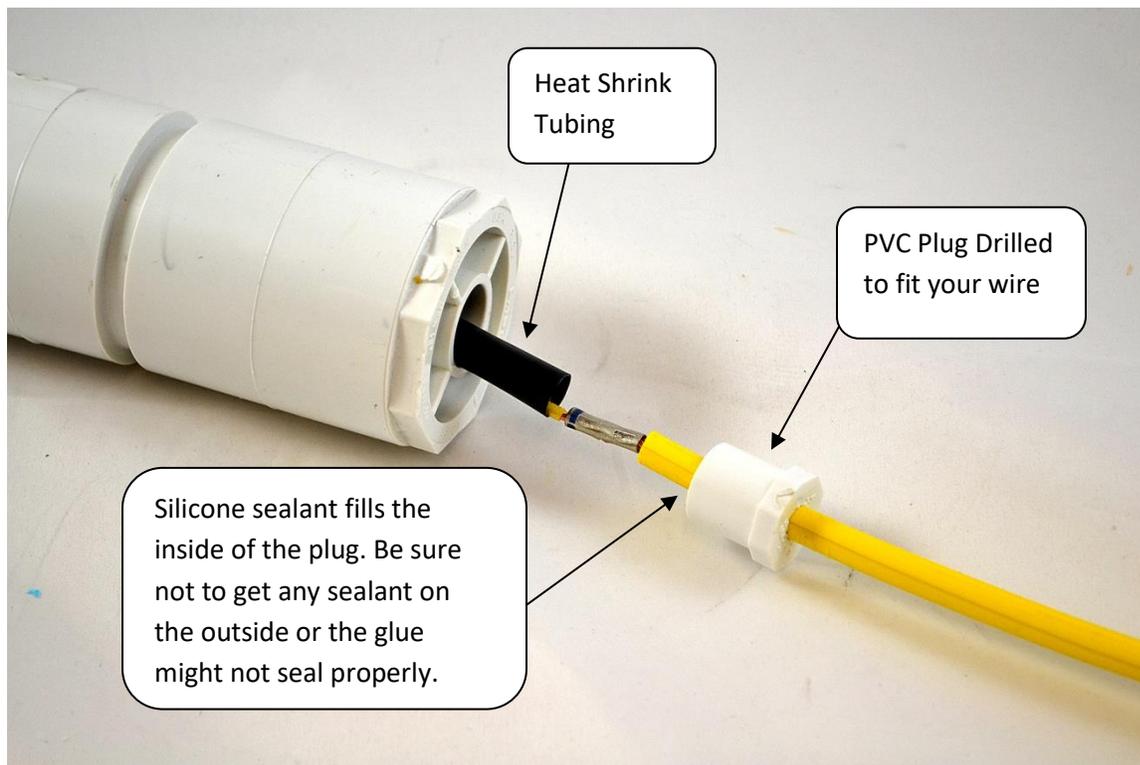
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Slide the plug over your wire so that approximately one inch (25mm) of the wire extends past the end of the plug. Next, fill the inside of the plug with silicone sealant and set it aside for the sealant to fully cure. **Be careful** not to get silicone on the outside bonding surface of the plug or on the exposed wire.

Step 4: The Splice - Part 1.

After the silicone sealant has cured, temporarily install (without any glue) the reducer coupling onto the Permanent Electrode with the yellow #12 AWG wire and heat-shrink tubing extending through the hole as shown below.





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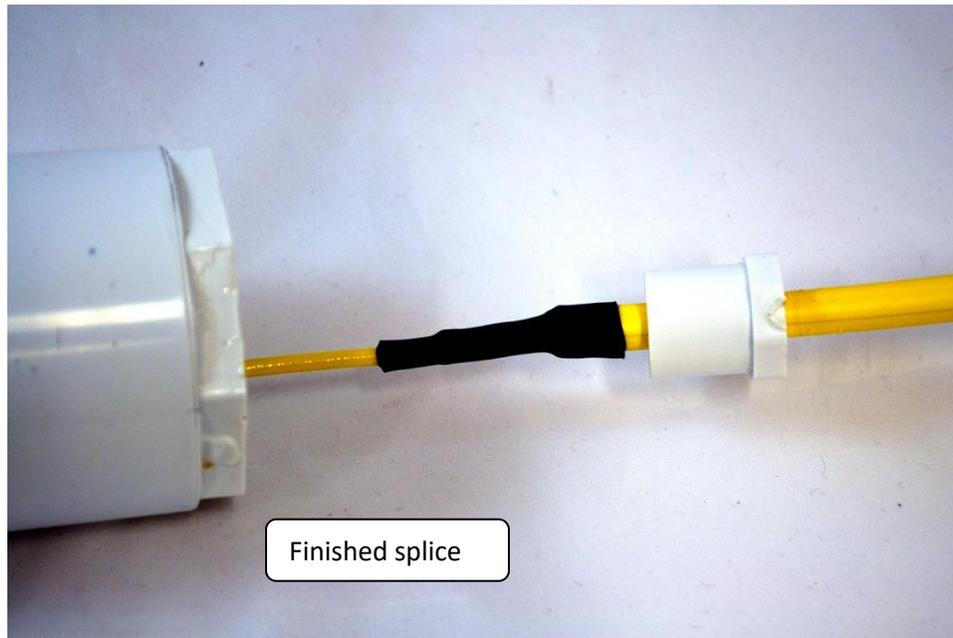
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Step 5: The Splice - Part 2.

Splice the two wires together using the supplied crimp splice and place the heat-shrink tubing over the crimp splice

Next, shrink the heat-shrink tubing, using a heat gun, to seal the connection.



Step 6: Final assembly.

Glue the plug into the reducer coupling using PVC Cement and then glue the coupler to the Permanent Electrode.

Before the two parts mate, rotate the Permanent Electrode to coil the wire inside the adapter making this process easier.

The final configuration should be as shown below.



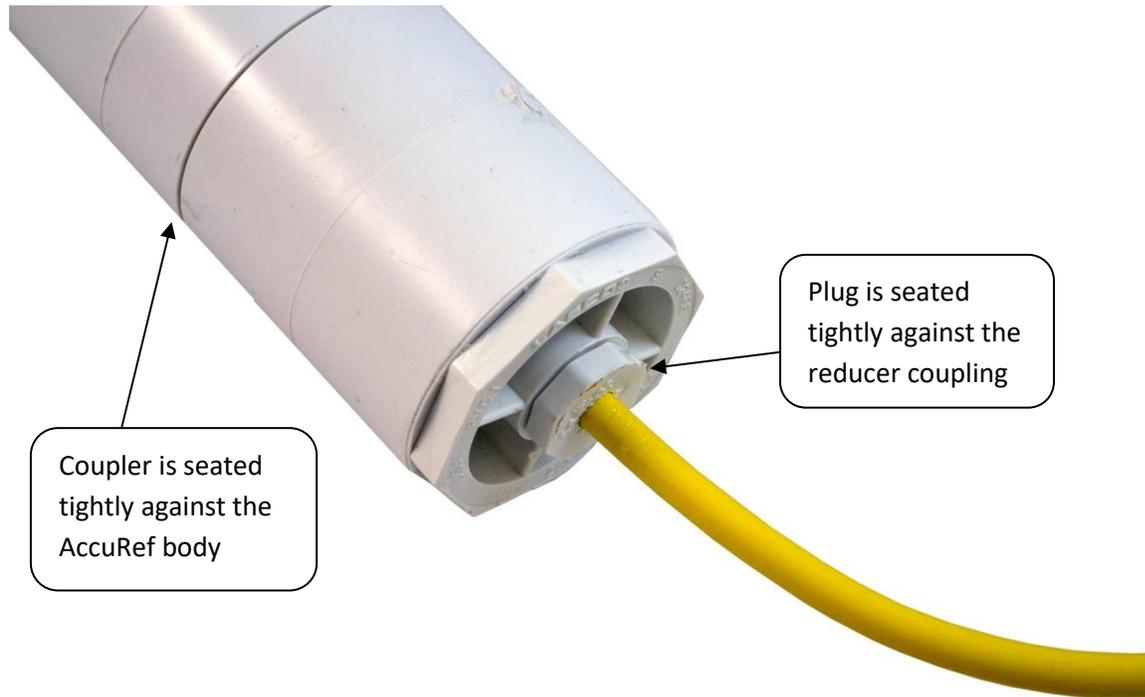
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After the glue cures, the Permanent Electrode with spliced wire is ready for installation.

Please see the "AccuRef/IonX 40 Electrode Installation Instructions" manual (MAN320) for installation instructions.