

# WT2SX SERIES

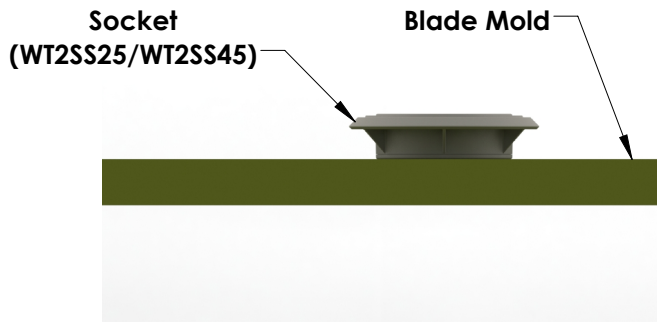
## Wind Turbine Side Receptor Assembly

### List of Suggested Tools/Supplies (Not Included):

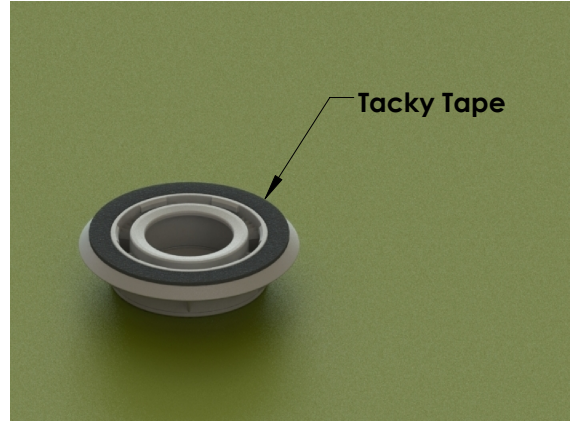
- ERICO part number WTBRFS (Receptor Disk Installation Tool) or face spanner wrench
- Needle nose pliers
- Tacky tape

### Procedure:

1. Place the socket(s) onto the blade mold (Figure 1) where the side receptor(s) will be installed. Apply tacky tape to the socket(s) flange (Figure 2). The shoulder on the flange guides installation and constrains the tape.

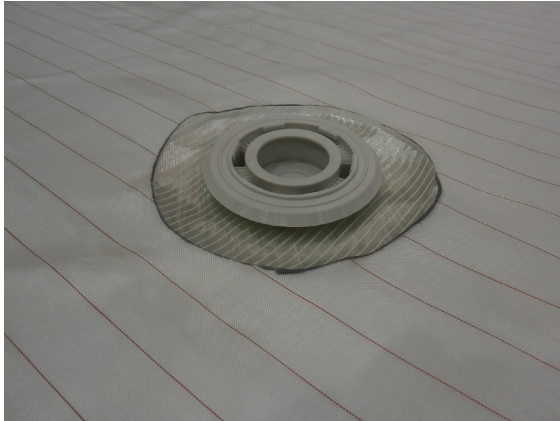


**Figure 1:** Socket on blade mold



**Figure 2:** Tacky tape on socket

2. Layer fiberglass sheets and/or core material around the socket(s) (Figure 3). Apply consumables and vacuum bag over the entire blade. Ensure there is a good seal around the socket(s) opening (Figure 4). Infuse the blade with resin and cure.



**Figure 3:** Fiberglass layered around socket



**Figure 4:** Socket sealed under vacuum

#### WARNING:

1. nVent products shall be installed and used only as indicated in nVent product instruction sheets and training materials. Instruction sheets are available at [www.nVent.com](http://www.nVent.com) and from your nVent customer service representative.
2. nVent products must never be used for a purpose other than the purpose for which they were designed or in a manner that exceeds specified load ratings.
3. All instructions must be **completely** followed to ensure proper and safe installation and performance.
4. Improper installation, misuse, misapplication or other failure to completely follow nVent's instructions and warnings may cause product malfunction, property damage, serious bodily injury and/or death, and void your warranty.

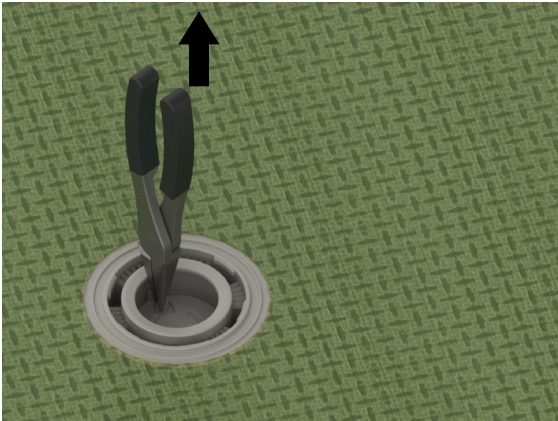
#### SAFETY INSTRUCTIONS:

All governing codes and regulations and those required by the job site must be observed. Always use appropriate safety equipment such as eye protection, hard hat, and gloves as appropriate to the application.

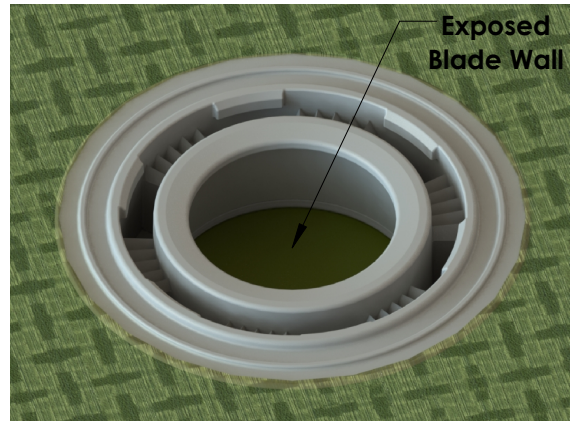
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3. Remove the vacuum bag and consumables from the blade. The center section of the socket can be removed and discarded. To remove the center section, grab onto the tab with needle nose pliers and pull upwards (Figure 5). The center section will tear and break away from the rest of the socket. The blade wall will be exposed through the socket (Figure 6).



**Figure 5:** Tab removal



**Figure 6:** Tab removed from socket

4. Lay the LPS on the fixed half of the blade. Snap the plug(s) on the fixed half of the blade into their corresponding socket(s) (Figure 7).



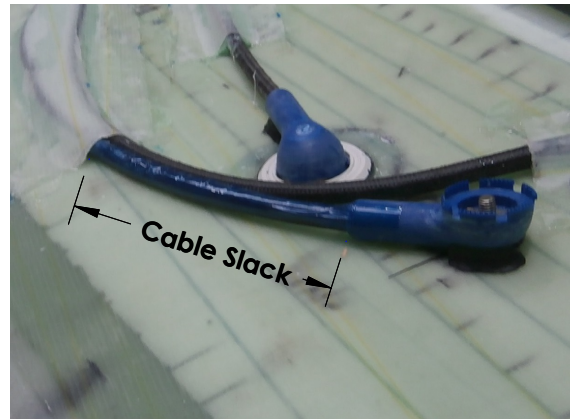
**Side Receptor Plug  
WT2SXXXXXX**

**Figure 7:** Plug in socket

5. Attach the plug(s) for the rotating half to the interior face of the fixed blade wall with temporary adhesive (Figure 8). The bolt in the plug(s) must be facing away from the interior face of the fixed blade half. Bond the LPS in place using bonding paste or hand laid fiberglass sheets. The loose plug(s) must be bonded with enough slack in the cable (Figure 9) to ensure the plug(s) will reach the socket(s) installed on the rotating half of the blade once closed.

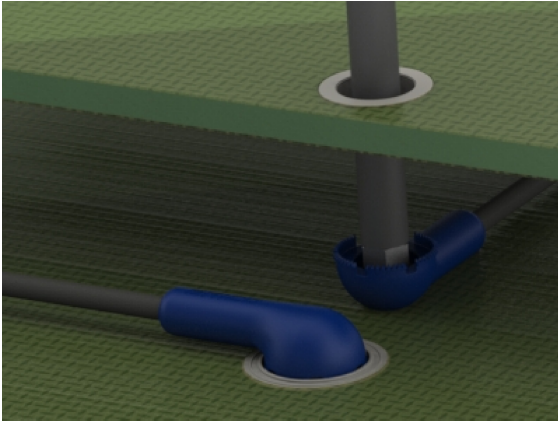


**Figure 8:** Adhesive applied to plug

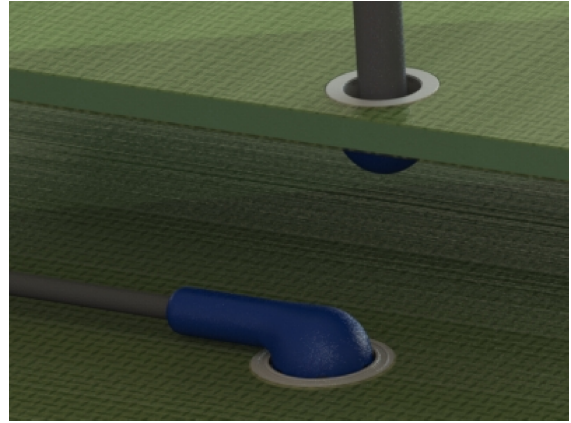


**Figure 9:** Slack in cable

3. Close the blade and remove from the mold. Insert the installation tool to "grab" the stud of the secondary plug(s) (Figure 10) and pull them into the corresponding socket(s) (Figure 11). Unthread the installation tool from the plug.

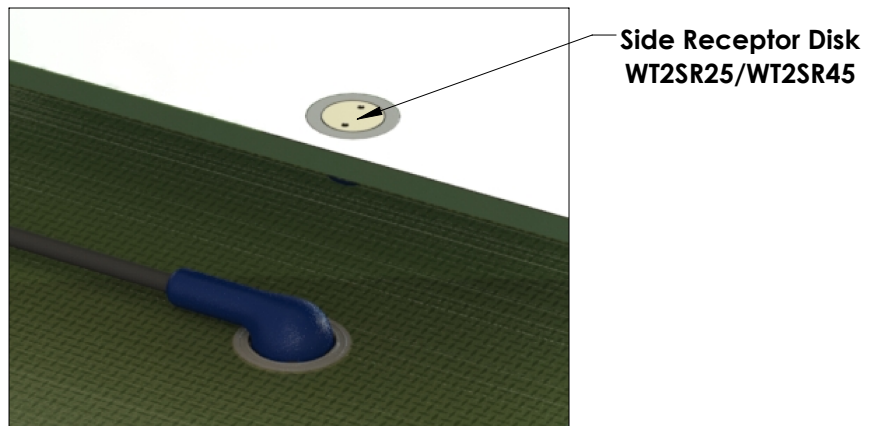


**Figure 10:** Plug engaged



**Figure 11:** Plugs installed

4. Apply Loctite<sup>®</sup> 263 (or equivalent) to the internal threads of the side receptor disk per manufacturer's instructions. Using WTBFRS (Receptor Disk Installation Tool) or a face spanner wrench (7/32" pin diameter, 1-1/4" diameter circle), screw the receptor disk(s) onto the side receptor plug(s) (Figure 12) and torque each receptor disk to 30 N-m (22 ft-lb). Seal around the perimeter of each disk with a silicone sealant.



**Figure 12:** Install receptor disks