



ASSEMBLY INSTRUCTIONS

10 – 6 Gauge Connector Series with Straight Strain Relief Housings

W.T. Storey Inc.
866-355-0100
www.wtstorey.com

10 – 6 GA Connector Series PART NUMBERS for cap / receptacle connectors with socket contacts:

**Accepts wire from size
10 GA “C” or “K”
stranding to
6 GA “C” or “K”
stranding**

24CA30L	48CA30L	24SC30L	48SC30L
24CA30OSL	48CA30OSL	24SC30OSL	48SC30OSL
24CA30OOSL	48CA30OOSL	24SC30OOSL	48SC30OOSL
24CA45L	48CA45L	24SC45L	48SC45L
24CA45OSL	48CA45OSL	24SC45OSL	48SC45OSL
24CA65L	48CA65L	24SC65L	48SC65L

10 – 6 GA Connector Series PART NUMBERS for plug connectors with pin contacts:

***To minimize problems during
the assembly,
and for ease of alignment,
the following procedures
should be followed exactly.***

24PL30L	48PL30L	24SP30L	48SP30L
24PL30OSL	48PL30OSL	24SP30OSL	48SP30OSL
24PL30OOSL	48PL30OOSL	24SP30OOSL	48SP30OOSL
24PL45L	48PL45L	24SP45L	48SP45L
24PL45OSL	48PL45OSL	24SP45OSL	48SP45OSL
24PL65L	48PL65L	24SP65L	48SP65L

Tools Required For Assembly

- 1) Thomas & Betts crimp tool Cat. No. TBM6S or TBM6
- 2) Special Die by W.T. STOREY INC.
 - For (10ga) order Cat. No. D1030
 - For (8ga) order Cat. No. D845
 - For (6ga) order Cat. No. D645
- 3) 3/8” Wrench (for adjusting T&B Crimp Tool)
- 4) Tape Measure
- 5) Wire Stripper – Outer Jacket
- 6) Wire Stripper – Inner Conductors
- 7) Slotted Screwdriver (1/4” tip)
- 8) Phillips Head Screwdriver (#2)
- 9) Ruler or Caliper
- 10) For socket contacts: Polarity/Adjustment Tool (Cat. No. WTS6810) or a WTS pin contact.

Assembly of Cap/Receptacle and Plug Connectors with Straight Strain Relief

- 1.) To insert dies into Thomas & Betts Crimping Tool:
 - a.) Open handles until fully extended with retaining spring facing you. Insert the top die (see above for correct WTS die) under the retaining spring in the tool head (see Figure 1).



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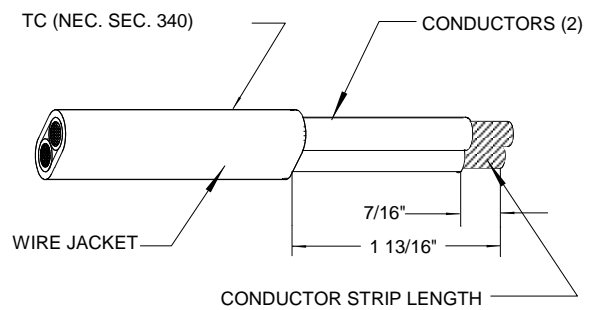
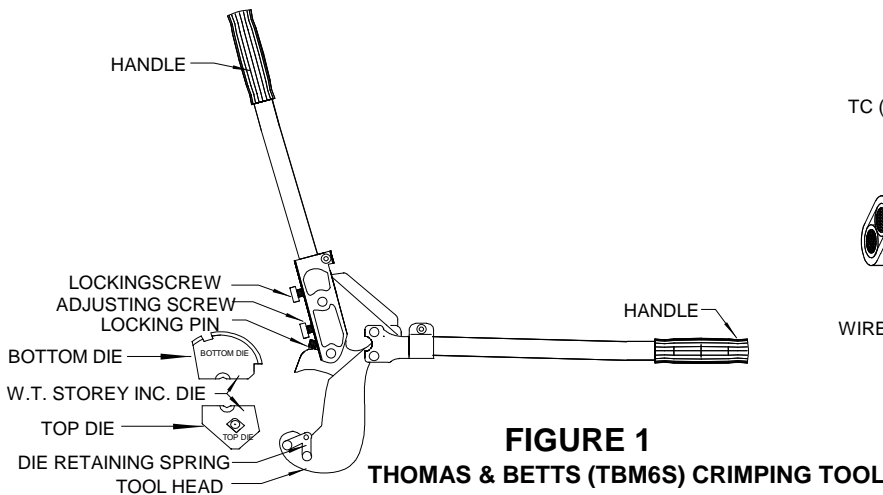
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Assembly of Cap/Receptacle and Plug Connectors with Straight Strain Relief

Continued

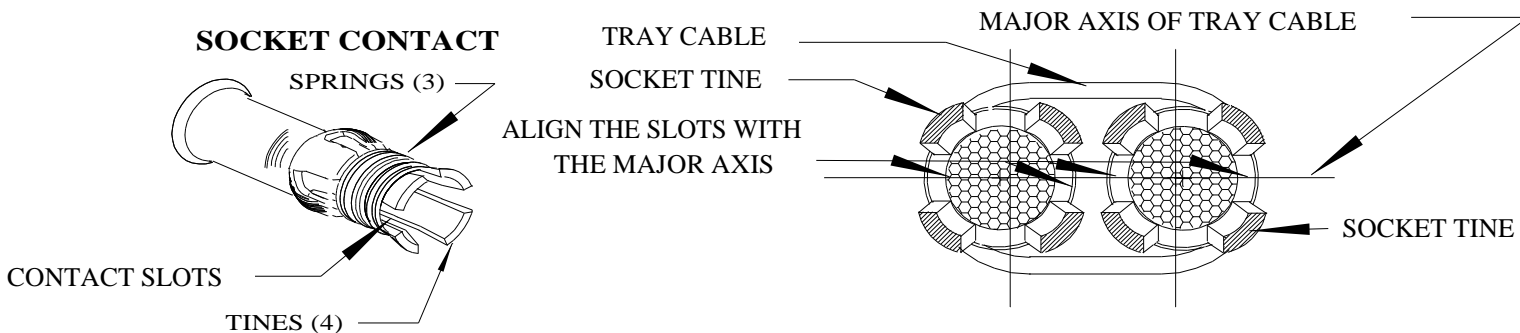
- b.) Place the rib of the bottom die (see above for correct WTS die) into groove in moveable jaw until the die is properly seated and the locking pin snaps into notch. (See Thomas & Betts instructions for more details).
- c.) After dies are inserted, see Thomas & Betts instructions located on tool for handle spread adjustment.



- 2.) Strip length for wire **JACKET** to 1 13/16" in length.
Strip length for both **conductors** is 7/16" in length (see Figure 2).

2A) **For 6GA. wire only** – apply ring washers to each conductor.

- 3.) For socket contacts, position the appropriate gauge socket contact onto the conductor so that 4 opposite slots in the contacts are aligned with the major axis of the tray cable (See Figure 3). For pin contacts, position the pin contact onto the conductor. For socket and pin contacts, the crimp indentation shall be located approximately 1/16" from the back flared portion of the contact.





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Assembly of Cap/Receptacle and Plug Connectors with Straight Strain Relief

- continued

4.) Then Crimp using die cavity as shown in Figure 1. One strike with T & B Tool will make 2 indentations.

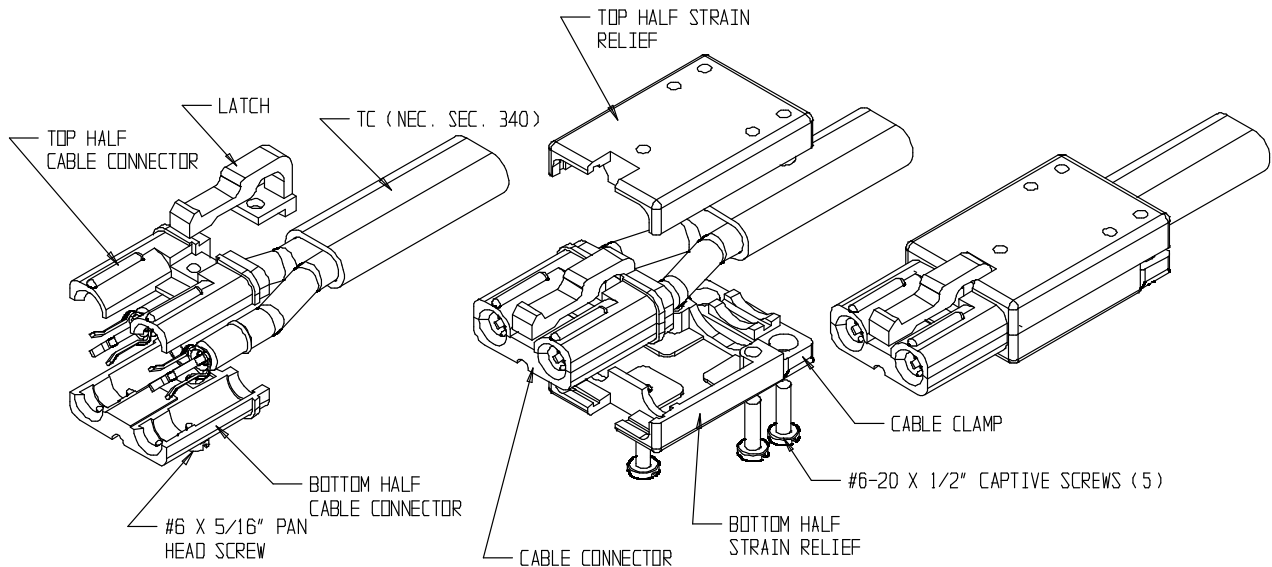


FIGURE 4 – Assembly of Cable Connector **FIGURE 5 – Assembly of Cable Connector Strain Relief**

5.) Crimp both contacts, then position each contact into the bottom half of the connector housing. The slots in socket contacts must align with the spring retaining bosses of the cable connector housing.

(See Figure 6).

6.) Place top half of cable connector housing to bottom half of cable connector housing with socket/pin contacts in place.

7.) **A. Cap/Receptacle Housings:** Slide the long end of the self-release latch up between the contact barrels of the top half of the connector with the short end containing the screw hole fitting into position under the bottom half of the cable connector and snap into position. Secure the connector halves using the pan head screw (#6x 3/8”). **B. Plug Housings:** Slide the long end of the self-release latch over the top of the housing with the short end containing the screw hole fitting into position under the bottom half of the connector as in step 7)A.

8.) Check wire polarity and socket contact leg adjustment, insuring that contact legs are not collapsed from rough assembly. Polarity /Adjustment Tool (Cat. No. WTS6810) or a WTS pin contact can be used to reset contacts if collapsed.



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Assembly of Cap/Receptacle and Plug Connectors with Angled Strain Relief

Continued

- 9.) Place the assembled Cap/Receptacle/Plug Connector in the top half of the connector strain relief housing. Align grooves and cable placement. Place the bottom half of the connector strain relief housing onto the Cap/Receptacle/Plug Connector and attach with the captive screws (#6 x 1/2") provided as shown in Figure 6. Finally, attach the cable clamp to the strain relief housing top half with the captive screws.

- 10.) To remove dies: Open handles until fully extended. Pull locking pin out and disengage bottom first, then top die.