

ASSEMBLY INSTRUCTIONS

UL Recognized Connector Series

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

**Accepts Wire from size
10 GA “C” or “K” stranding
To 6 GA “C” or “K” stranding**

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

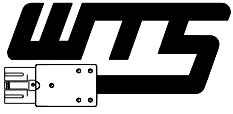
These instructions are specifically for the cable connectors using socket contacts and pin contacts. Please see additional instructions for the additional style housings. Please refer to the Complete List of Part Numbers for UL Recognized Connectors.

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

- 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).
 - 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.



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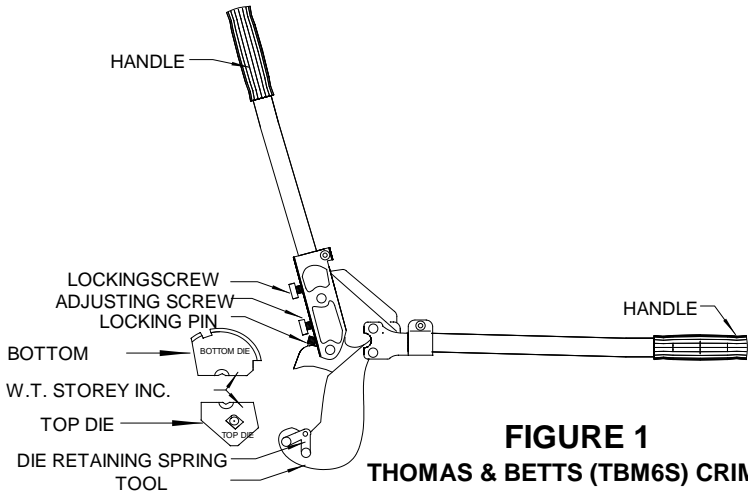


FIGURE 1
THOMAS & BETTS (TBM6S) CRIMPING TOOL

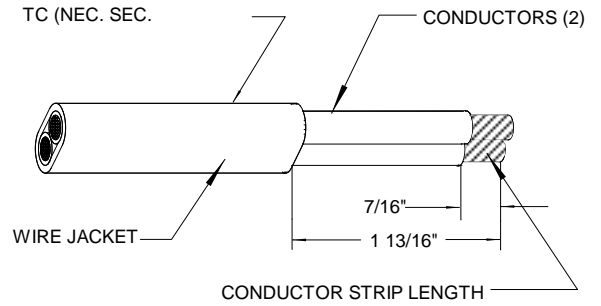


FIGURE 2
CABLE STRIP LENGTH

- 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.

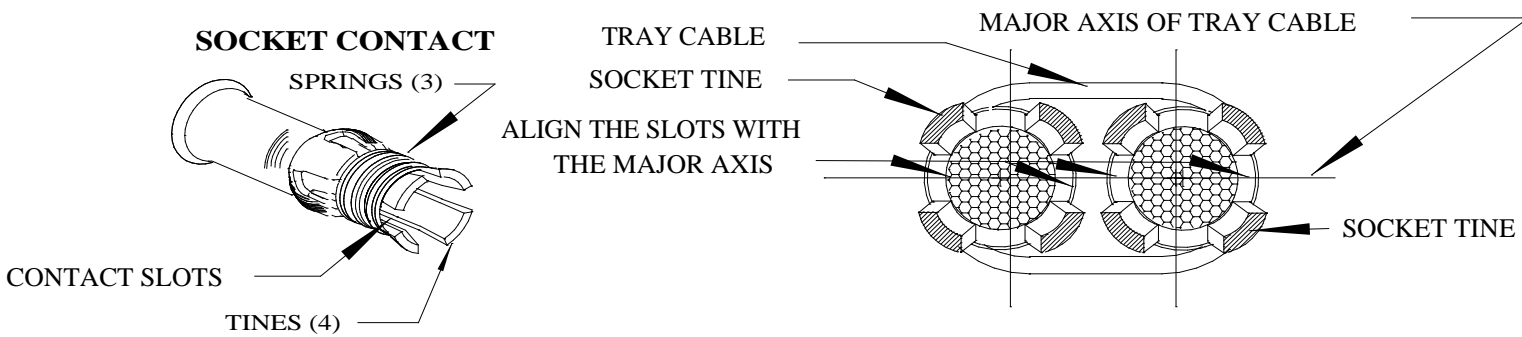
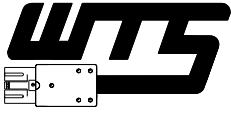


FIGURE 3 - Alignment of Contact Slots with the Major Axis of Tray Cable

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



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Assembly of Cap/Receptacle and Plug Connectors

- continued

- 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 3)
- 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.
- 9.) To remove dies: Open handles until fully extended. Pull locking pin out and disengage bottom first, then top die.