



ASSEMBLY INSTRUCTIONS

8-2 Gauge Connector Series

with Color Coded Contacts

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

Accepts wire with “K” stranding in four gauges:

- 8 GA - Color Code Blue
- 6 GA - Color Code Blue
- 4 GA - Color Code Grey
- 2 GA - Color Code Brown

8 – 2 Gauge Connector Series PART NUMBERS for cap / receptacle connectors with socket contacts:

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

24C8CA30L	24C6CA30L	24C4CA30L	24C2CA30L
24C8CA45L	24C6CA45L	24C4CA45L	24C2CA45L
24C8CA65L	24C6CA65L	24C4CA65L	24C2CA65L
48C8CA30L	48C6CA30L	48C4CA30L	48C2CA30L
48C8CA45L	48C6CA45L	48C4CA45L	48C2CA45L
48C8CA65L	48C6CA65L	48C4CA65L	48C2CA65L

Tools Required For Assembly

- 1) Choose one of the following:
 - * Burndy BCT500 Battery Crimp Tool with crimp dies #W5CVT
 - * Burndy MD7-34R Full Cycle Ratchet Hand Tool with crimp dies #W5CVT
 - * T&B TBM6S Full Cycle Ratchet Tool with crimp dies:
 - a. for (8ga + 6ga) #13475 upper & #13477 lower – **color code blue**
 - b. for (4ga) #13472 upper & #13476 lower – **color code grey**
 - c. for (2ga) #13477 upper & #13474 lower – **color code brown**

8 – 2 Gauge Connector Series PART NUMBERS for plug connectors with pin contacts:

24C8PL30L	24C6PL30L	24C4PL30L	24C2PL30L
24C8PL45L	24C6PL45L	24C4PL45L	24C2PL45L
24C8PL65L	24C6PL65L	24C4PL65L	24C2PL65L
48C8PL30L	48C6PL30L	48C4PL30L	48C2PL30L
48C8PL45L	48C6PL45L	48C4PL45L	48C2PL45L
48C8PL65L	48C6PL65L	48C4PL65L	48C2PL65L

- 2) Wire Stripper – Outer Jacket
- 3) Wire Stripper – Inner Conductors
- 4) Ruler or Caliper
- 5) #2 Phillips Screwdriver

Assembly of Cap / Receptacle and Plug Connectos

- 1) Strip length for the outer jacket is 1”.
- 2) Strip lengths for inner conductors as follows: 2 GA is 5/8”, 4 GA, 6 GA and 8 GA is 1/2”.
- 3) Use the tool manufacturer’s instructions for set-up procedure and quantity of crimps per terminal.
- 4) For socket contacts, position the crimp barrel of the color coded socket contact onto the conductor so that the four slots in the socket contact are aligned with the major axis of the tray cable. See Figure 1. For pin contacts, position the crimp barrel of the color coded pin contact onto the conductor.



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Assembly of Cap / Receptacle and Plug Connectors - Continued from previous page.

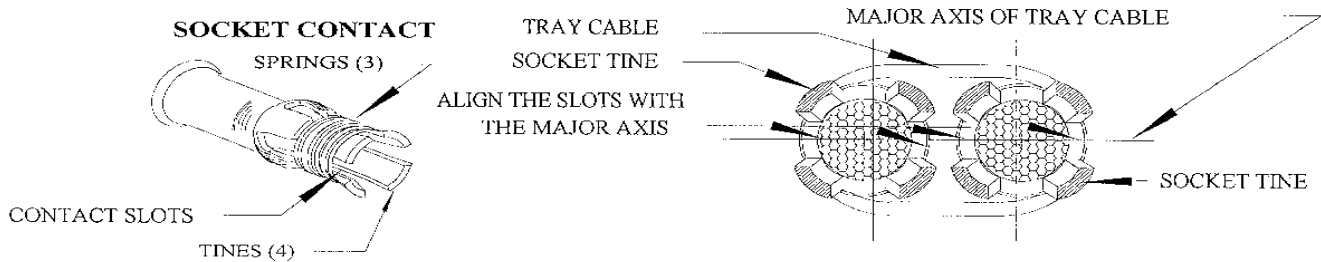


Figure 1 – Alignment of Contact Slots with the Major Axis of Tray Cable

- 5) For crimping, position the contact in the crimp die so that the crimp indentations will be contained within the “color coded” area.
- 6) Crimp both contacts, then proceed to assemble the terminals into the cable connectors.
- 7) Observe polarity, then position each contact into the bottom half of the connector housing. The socket contacts must align with the spring retaining bosses of the cable connector housing.

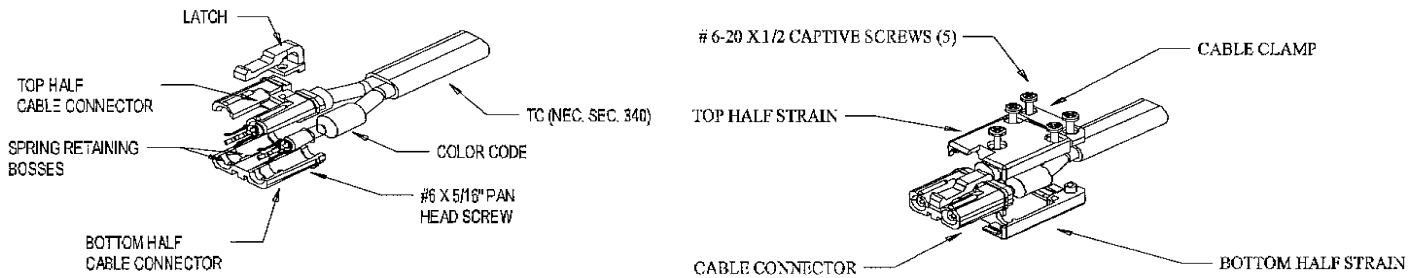


Figure 2

- 8) Place the top of the cable connector onto the bottom half.
- 9) **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 it into position. Secure the connector halves using the pan head screw (#6 x 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 9)A.
- 10) Place the bottom of the assembled cable connector into the alignment grooves of the bottom half strain.
- 11) Attach the top half of the 8 – 2GA Series strain relief housing with the captive screws (#6 x 1/2”) provided.
- 12) Tighten the cable clamp onto the tray cable jacket to provide a strain relief, use the remaining #6 x 1/2” captive screws.
- 13) Utilize the socket Contact Leg Adjustment Tool (Cat. No. WTS6810) and Contact Tip Adjustment Tool (Cat. No. WTS6811) to reset the tines inside the cap/receptacle housing. Not applicable to plug housings with pin contacts.
- 14) Verify wire polarity.