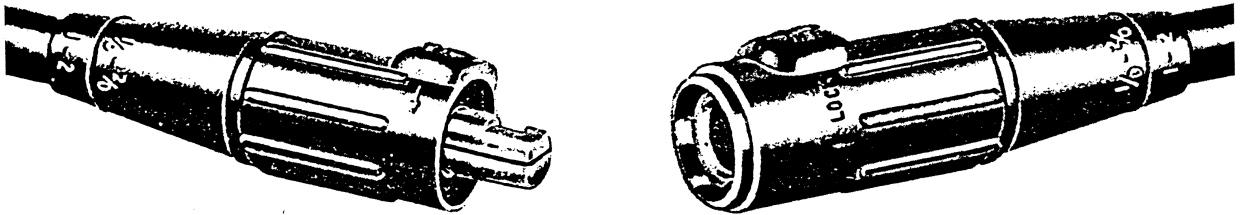


cam-lok[®]

ASSEMBLY INSTRUCTIONS

E1012 ATTACHABLE CONNECTORS

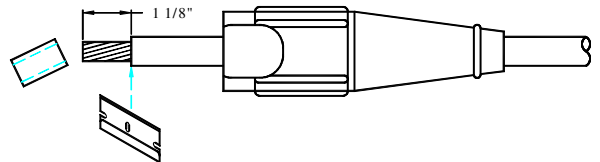


NOTE: Use copper (CU) wire only.

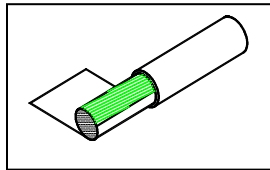
ASSEMBLY PROCEDURE

1. Cut off cable end of insulator to match cable diameter.
2. Coat cable and ID of sleeve at the cable end with a little liquid soap, or cable pulling compound to make assembly easier. **Do not coat contacts or ID of sleeve where contact fits, as this will cause the contact to slip within sleeve.** Push cable through insulator from rear of sleeve

3. Strip cable jacket 1 1/8". Wrap bare conductor with copper shim. See Table 1 for quantity of copper shim.



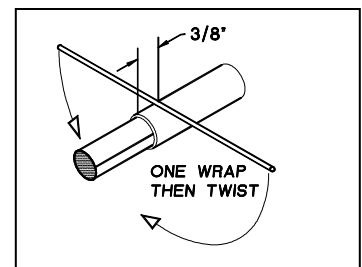
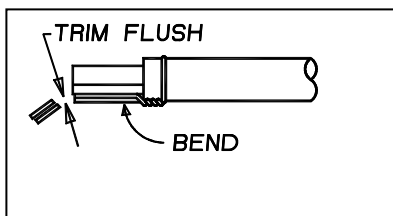
4. The length of bare copper wire is included for cable jacket retention. Wrap the wire tightly around the cable jacket 3/8"-1/2" from the end of the jacket. Bend the ends down against the conductor and squeeze twisted portion tightly against cable jacket so that it will clear inside of insulator during assembly. Cut loose ends of wire off flush with end of conductor.



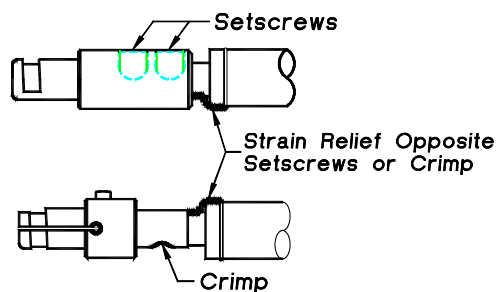
COPPER SHIM SELECTION

Contact Dia	Cable Size AWG	Number of Shims
7/8"	#1, #2	2
7/8"	1/0, 2/0	1
1"	2/0	2
1"	3/0, 4/0	1

Table 1



5. Assemble shim covered conductor and end of strain relief wire into cable hole. Strain relief ends should not be inserted under the set screw of the contact. Tighten set screw to torque shown in Table 2. Set screws must be below surface of contact to clear plastic ring inside of sleeve. If contact is crimp type, crimp should be made opposite retainer wire.



6. Line up external locking pin on contact with arrow marked "MATE" on raised boss on the insulator. Place cam-lok connection end of contact against a firm surface and push insulator over contact until contact locking pin snaps into the internal locking ring molded into the insulator. Male should be inside the insulator approximately 11/32"; female should be inside the insulator about 1/8". Use male contact to assemble female connector. Use female contact to assemble male connector.

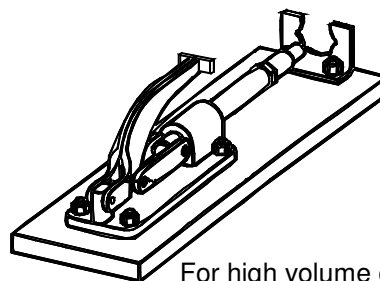
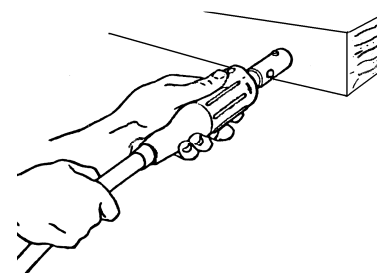
SET SCREW TORQUE

Cable Size AWG	Torque (Lb-In)
#2	100
1/0, 2/0	100-125
3/0, 4/0	175-200

Table 2

CONTACT AND CONDUCTOR SIZE INFORMATION

Contact Style	Cable Size AWG	Continuous Current Rating	Conductor Entrance Diameter	Contact	
				Male	Female
Single Set Screw	#2-2/0	235	.53	A200081-1	A200067-1
Single Set Screw	2/0-4/0	315	.65	A200080-1	A200066-1
Double Set Screw	#2-2/0	235	.57	A200643-1	A200640-1
Double Set Screw	2/0-4/0	315	.65	A200644-1	A200642-1
Crimp/ Solder	#1-#2	170	.40	A200036-30	A200037-35
Crimp/ Solder	1/0-2/0	235	.49	A200036-31	A200037-36
Crimp/ Solder	3/0-4/0	315	.62	A200038-30	A200035-53



For high volume or frequent installation, use the Lektralink assembly tool shown, p/n A400001

A lubricant is available from:
 Chemtrend, Inc.
 1445 West McPherson Park Drive
 Howell, Michigan 48844-0860
 Their part number is CT-39F.



Crouse-Hinds Molded Products

UNITED STATES:
 4758 Washington Street • La Grange, North Carolina 28551
 Phone: (252) 566-3014 • FAX (252) 566-9337 • FSCM 90129

CANADA:
 Crouse-Hinds Canada
 5925 McLaughlin Road • Mississauga, Ontario Canada L5R 1B8
 Phone: (905) 507-4187 • FAX (905) 501-4078