

ASSEMBLY INSTRUCTIONS

For Cooper E1015 Series cam connectors

NOTE : Use copper (CU) wire sized #8 to #4 AWG only.

GENERAL

The insulator sleeve has a plastic ring inside of the sleeve to prevent contact pushing back too far to prevent rotation of contact. The ring has a “U” shaped groove in the front edge under the rib on the OD of the sleeve. The contacts have a rivet head which mates with this “U” shaped groove to position the contact.

ASSEMBLY STEPS

1. Cut off cable end of insulator to match cable diameter. The first section fits cable OD of .250 up to .359 diameter. The second section fits cable OD of .375 through .468 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.**
3. Push cable through from rear of sleeve and remove 5/8” length of jacket. Wrap bare conductor with shim stock. See chart for quantity of shim stock. Using the length of bare copper wire included as a strain relief, wrap the wire tightly around the cable jacket 1/4” 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.
4. 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 50-60 in-lbs. of torque. Set screws must be below surface of contact to clear plastic ring inside of sleeve.
5. Place contact against a firm surface and push insulator over contact. Rivet on contact must line up with slot in plastic ring inside of sleeve. Slot is under rib on sleeve. Rotate contact if necessary to align rivet. 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.

SHIM STOCK SELECTION

#8, #6 AWG Cable—2 pcs. 5/8 x 1 1/4”
#4 AWG Cable—1 pc. 5/8 x 1 1/4”

NOTE: Com-a-long assembly tools are available from JCSI if desired. Tool to assemble female cam is part number 15CLF. Tool to assemble female cam is part number 15CLM.

