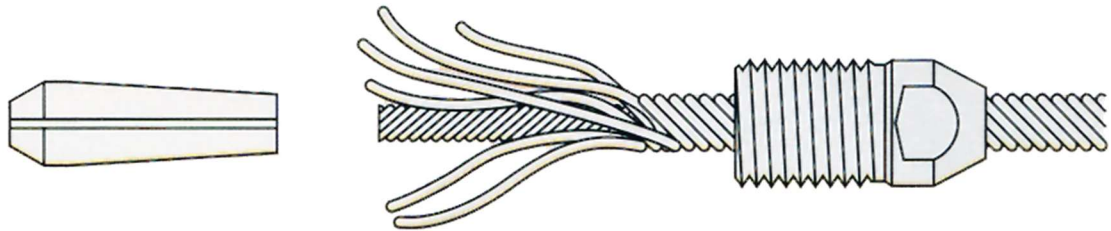


Sta-Lok Assembly Instructions

1. Unravel the Wire



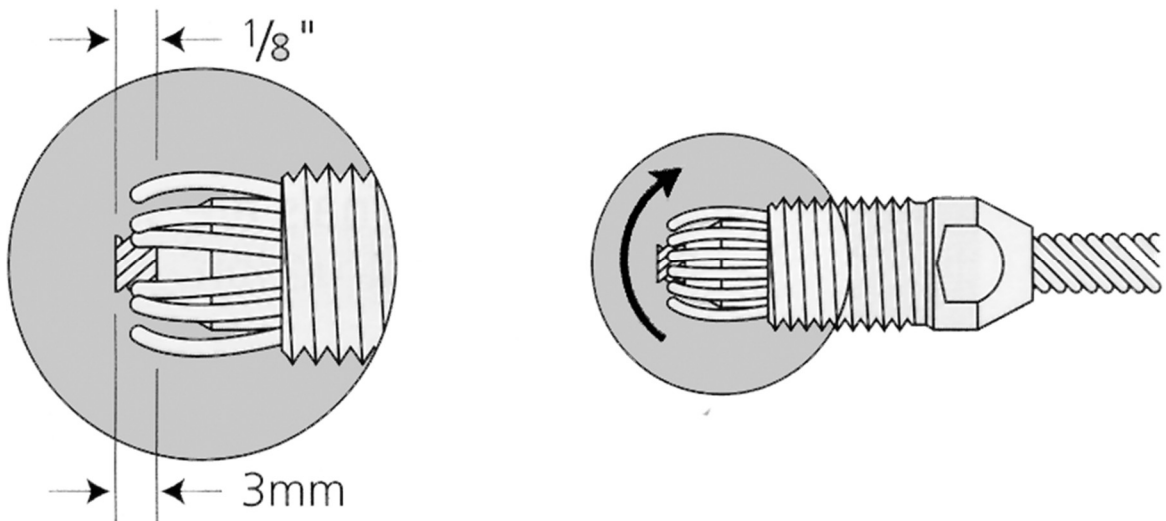
Slide the socket end over the wire and unravel the outer strands (one strand at a time) 2-3 inches exposing the center core. Slide the wedge over the central core, as shown.

Tip: Use a screw-driver to pry strands loose one at a time.

2. Reposition the Outer Strands

Twist the wire so that it reforms around the wedge. Insure that the strands protrude 1/8" (2-3mm) from the eye of the wedge.

3. Push the Socket Over the Wedge

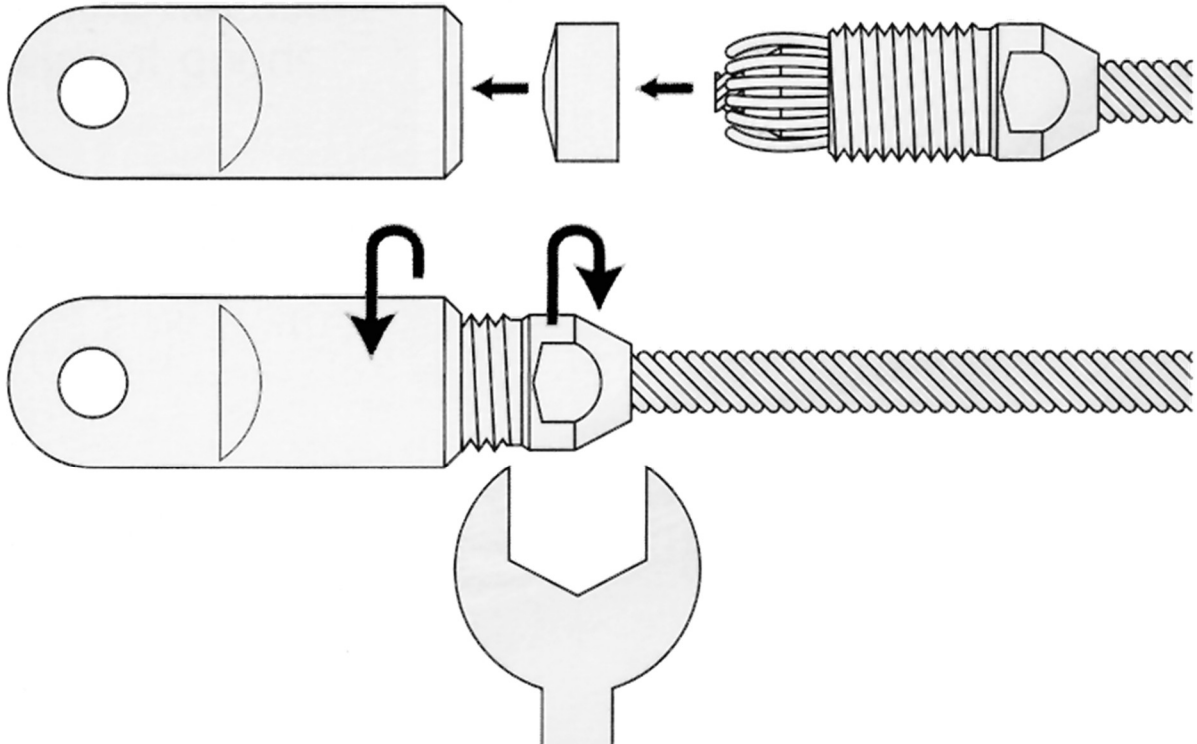


Individual strands should not overlap! Make sure the strands are evenly spaced around the wedge. Do not let a strand slip into the slot in the wedge.

Tip: Push the socket towards the end of the wire while repositioning strands.

Important: Put a couple of drops of Loctite on the starting threads when first assembling the terminal. The Loctite will act as a lubricant and ensure that the threads will not gall. Loctite will also ensure that the terminal will not loosen after the final assembly.

4. Initial forming Process



The initial forming process begins when you start screwing the terminal and socket together. Do not overtighten! When you bottom out - **Stop!**

Unscrew the fitting to ensure that the strands are evenly formed around the wedge. There should be no overlapping strands and the slot in the wedge should not have any trapped wire. **The wedge must compress! The slot must be clear for tightening!**

5. Final Assembly

Fill the cavity of the terminal's body about 1/2 full of Life Caulk and place a few drops of Locktite on the threads. Reassemble the fitting and tighten to the point of bottoming out.

Do not overtighten! Overtightening will damage the threads and wire, and may render the terminal impossible to reuse at a later date.