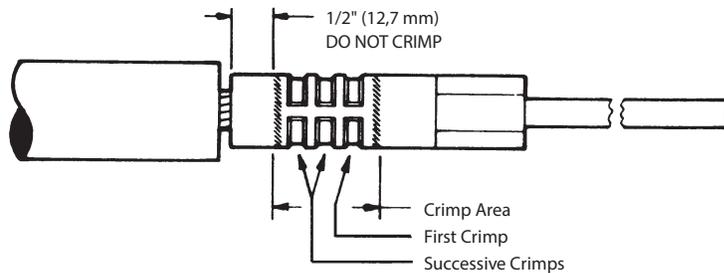


3M™ Stem Connectors Installation Instructions

A. Remove cable insulation from conductor end for a distance Dimension B.

Conductor Size - AWG & kcmil			Connector Code	Dimension B
Stranded/Compressed	Compact	Solid	Stem Connector	
4 2 1 1/0	2 1 1/0 2/0	2 1 1/0 2/0	SC0002 SC0001 SC0001 SC0010	2" (50,8 mm)
2/0 3/0 4/0	3/0 4/0 250	3/0 4/0 --	SC0020 SC0030 SC0040	

B. For Aluminum Conductors - Thoroughly wire brush conductor strands to remove aluminum oxide layer. Immediately insert conductor into stem connector barrel as far as it will go.



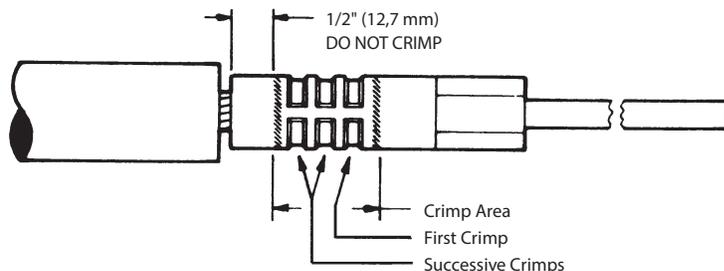
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B. For Aluminum Conductors - Thoroughly wire brush conductor strands to remove aluminum oxide layer. Immediately insert conductor into stem connector barrel as far as it will go.



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C. Crimp 3M™ Stem Connector per Crimping Table.

Crimping Table for 3M™ Stem Connectors								
Conductor Size	3M Connector No.	Manufacturer	Recommended Crimping Tools					
			Mech. Tool	Die Size	Indents Per End	Hyd. Tool	Die Size	Indents Per End
#4 Stranded; #2 Solid	SC0002	Burndy	MD6	BG W241	4	Y35, Y39, Y45*, Y46*	U25ART U243	2
			0-51 0-52	5/8-1	3			2
#2, #1 Stranded; #1, 1/0 Solid	SC0001	Kearny	0-51 0-52	5/8-1	4	WH-1 WH-2	5/8-1	4
			T&B	Tan Olive; Tan	2			TBM15
1/0 Stranded 2/0 Solid	SC0010	Anderson			TBM5 TBM8	--	--	
			--	--	--	--	2	
2/0 Stranded; 3/0 Solid	SC0020	Burndy	MD6	W249	3	Y35, Y39, Y45*, Y46*	U28ART	2
			0-51 0-52	840	5			WH-1 WH-2
3/0 Stranded; 4/0 Solid	SC0030	Kearny	0-51 0-52	840	5	TBM15	71H	
			T&B	Red	4			TBM15
4/0 Stranded	SC0040	Anderson			--	--	--	
			--	--	--	--	2	

*Y45 accepts all Y35 dies ("U" series). For Y45 use PT6515 adapter. ** Anderson VC6 is dieless and does not require a die set.

D. Remove excess oxide inhibitor and sharp crimp flashing following crimping.

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C. Crimp 3M™ Stem Connector per Crimping Table.

Crimping Table for 3M™ Stem Connectors								
Conductor Size	3M Connector No.	Manufacturer	Recommended Crimping Tools					
			Mech. Tool	Die Size	Indents Per End	Hyd. Tool	Die Size	Indents Per End
#4 Stranded; #2 Solid	SC0002	Burndy	MD6	BG W241	4	Y35, Y39, Y45*, Y46*	U25ART U243	2
			0-51 0-52	5/8-1	3			2
#2, #1 Stranded; #1, 1/0 Solid	SC0001	Kearny	0-51 0-52	5/8-1	4	WH-1 WH-2	5/8-1	4
			T&B	Tan Olive; Tan	2			TBM15
1/0 Stranded 2/0 Solid	SC0010	Anderson			TBM5 TBM8	--	--	
			--	--	--	--	2	
2/0 Stranded; 3/0 Solid	SC0020	Burndy	MD6	W249	3	Y35, Y39, Y45*, Y46*	U28ART	2
			0-51 0-52	840	5			WH-1 WH-2
3/0 Stranded; 4/0 Solid	SC0030	Kearny	0-51 0-52	840	5	TBM15	71H	
			T&B	Red	4			TBM15
4/0 Stranded	SC0040	Anderson			--	--	--	
			--	--	--	--	2	

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D. Remove excess oxide inhibitor and sharp crimp flashing following crimping.

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