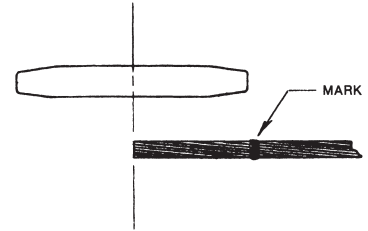


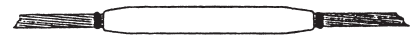
## Installation Instructions

### HiTemp Jumper Connectors for ACSS and ACSS/TW Conductors

1. Measure back from each conductor end and mark at a distance equal to 1/2 the length of the aluminum jumper connector.
2. File burrs or sharp edges off the aluminum strands as necessary for ease of insertion.
3. Prior to making connections, the conductor and accessory bores must be clean. If the conductor is weathered or blackened, carefully unlay aluminum strands for a distance equal to or greater than 1/2 the length of the aluminum jumper connector and clean strands thoroughly with wire brush or abrasive cloth. The outer layer of new conductor should be wire brushed 1/2 the length of the jumper. Check accessory bore for foreign particles, removing if present.



4. Inject HiTemp AFL Filler Compound (AFCHT) into each end of jumper connector and on the conductor to insure that excess compound will be forced from the jumper connector when compressions are completed. Insert the conductor ends into the jumper connector. If the mark on the conductor is not at the end of the jumper connector, and there is resistance to further entry, twist the jumper connector on the conductor. This will work the compound between conductor strands and bleed air from the jumper connector.
5. Select die size for compressing jumper connector. The die size on die and die size marked on aluminum jumper connector must be the same.
6. The jumper connector must be supported a minimum of 15 feet on each side to prevent bowing during compression.



7. Compress jumper connector full length making initial compression over center stop. Overlap each successive compression by approximately 1/4 die bite. Complete die closure is required for each compression.
8. Compressed jumper connector should have a smooth uniform appearance. Remove flash, if present, with file or emery cloth.

