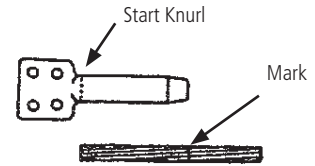


Installation Instructions for HiTemp® Compression Terminals

1. Prior to making any connections, the conductor must be clean. For new conductor, the outside diameter shall be wire brushed to remove the aluminum oxidation. If the conductor is weathered or blackened, only the outside diameter can be wire brushed, due to the dead soft aluminum strands of the ACSS or ACSS/TW. Do not try to unlay the strands to clean the inner layers, as the strands will not lay back to its original form. The ConductaClean® ultrasonic cleaning unit is recommended to be used on new and weathered ACSS and ACSS/TW.
2. Mark the conductor from the end, a distance equal to the compression length of the terminal.



HiTemp Compression

3. Inject sufficient AFL HiTemp Filler Compound (AFCHT) or HiTemp® Universal Compound (HiTUC) in the end of the terminal bore and on the conductor to ensure that excess compound will be visible at terminal end when barrel is completely compressed. See chart below for proper amount of AFCHT or HiTUC required for each terminal size.



AFCHT of HiTUC Filler Compound Required

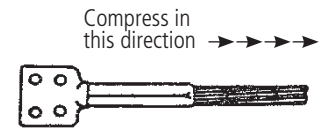
Partial Terminal Catalog Number	lb.	Grams (g)
5175.XXXHT, 5675.XXXHT, 5875.XXXHT	0.1	45
5176.XXXHT, 5676.XXXHT, 5876.XXXHT	0.1	45
5120.XXXHT, 5620.XXXHT, 5820.XXXHT	0.1	45
5124.XXXHT, 5624.XXXHT, 5824.XXXHT	0.2	91
5127.XXXHT, 5627.XXXHT, 5827.XXXHT	0.2	91
5130.XXXHT, 5630.XXXHT, 5830.XXXHT	0.3	136
5134.XXXHT, 5634.XXXHT, 5834.XXXHT	0.3	136
5136.XXXHT, 5636.XXXHT, 5836.XXXHT	0.4	181
5138.XXXHT, 5638.XXXHT, 5838.XXXHT	0.4	181
5140.XXXHT, 5640.XXXHT, 5840.XXXHT	0.4	181
5142.XXXHT, 5642.XXXHT, 5842.XXXHT	0.5	227
5144.XXXHT, 5644.XXXHT, 5844.XXXHT	0.5	227
5148.XXXHT, 5648.XXXHT, 5848.XXXHT	0.6	272

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Continued

CAUTION: Follow installation instructions carefully. Improper installation can result in mechanical failure of the cable system and possible injury to persons handling or in the vicinity of the cable systems.

Installation Instructions for HiTemp® Compression Terminals (cont.)

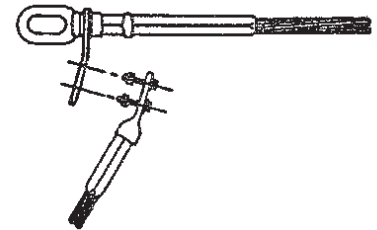
4. To compress, select the proper die size as stamped on the terminal connector.
5. Compress the terminal, beginning at the "start knurl." Continue compressing toward the end of the terminal. Complete die closure is required for each compression. Overlap the previous compression by approximately 1/4 die bite. It is recommended that die grooves be well lubricated with a lightweight oil. Oil coating should be maintained during entire compression operation. (Other acceptable mediums that can be used instead of oil are wax, soap or plastic bag the terminal shipped in.)
6. Remove flash caused by die closure, if any, with a file.



To Attach Terminal Connector to Dead End or Tee Tap

7. Clean contact surface of pads to be connected by wire brushing thoroughly and immediately coating with a thin film of HiTUC or Alnox. **Do not use AFL Filler Compound (AFC).**
8. Bolt terminal to dead end pad. Partially tighten all bolts and then re-tighten each bolt to the recommended torque:

Aluminum 1/2" bolts - 25 lb-ft (34 N.m)
Stainless Steel 1/2" bolts - 40 lb-ft (54 N.m)



CAUTION: Follow installation instructions carefully. Improper installation can result in mechanical failure of the cable system and possible injury to persons handling or in the vicinity of the cable systems.