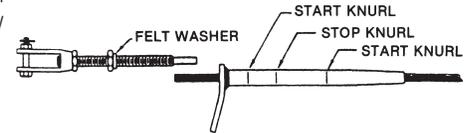


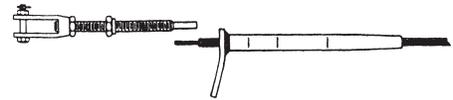
## Installation Instructions

### Adjustable Compression Dead Ends on ACSR Conductors

1. Prior to making connections, the outer strand on all conductors (even new conductors) must be cleaned with a wire brush or abrasive cloth. If the conductor is weathered or blackened, carefully unlay aluminum strands for a distance equal to or greater than 3/4 the length of the aluminum dead end body and clean strands thoroughly with wire brush or abrasive cloth. Check accessory bore for foreign particles, removing if present.
2. Serve the conductor, prior to cutting, with tape to help maintain the round contour making it easier to slide the end through the aluminum dead end.
3. Straighten several feet of conductor removing set caused by reel (if necessary).
4. If a comealong is being used, it should be located at least ten (10) feet from end of conductor.



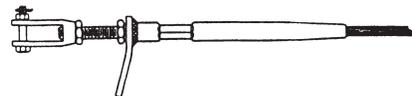
5. Slide dead end body over conductor until sufficient working length protrudes from tongue end.
6. Cut back aluminum strands a distance equal to the depth of the bore of the steel forging barrel plus 1 inch. Do not nick steel strands. File burrs as necessary for ease of insertion.



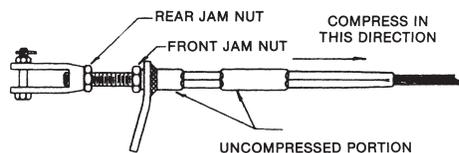
7. Insert steel core into steel barrel to full length of bore.
8. Select die size for compressing steel barrel. The die size on the die and die size marked on steel barrel must be the same.
9. Compress steel barrel full length making initial compression adjacent to corrugations. Overlap each successive compression by approximately 1/4 die bite. Complete die closure is required for each compression.



10. Remove any remaining tape from the aluminum strands and slide aluminum dead end body over steel forging until tongue end butts solidly against felt washer and shoulder of steel dead end. Align clevis or eye with tongue of dead end to ensure proper positioning when dead end is fastened to insulator hardware.
11. Inject AFL Filler Compound (AFC) into filler hole until compound emerges at the felt washer and the tapered end of the body. Insert and drive filler plug into hole andpeen edge of hole over top surface of plug.
12. Select die size to compress aluminum dead end body. Die size for aluminum dead end body and die size marked on die must be the same.
13. It is recommended that die grooves be well lubricated with a light weight oil. Oil coating should be maintained during entire compression operation.
14. Make the initial compression on the dead end body over the steel shank beginning at the "start knurl" nearest the dead end tongue. Continue making compressions to the "stop knurl", overlapping the previous compression by approximately 1/4 die bite. Complete die closure is required for each compression.



15. To press the dead end body over the conductor, use the same die used in step 13. Make the initial compression at the "start knurl" and proceed with compression. Continue making compressions to the end of the dead end body, overlapping the previous compression by approximately 1/4 die bite. Complete die closure is required for each compression.
16. Note there should be an uncompressed area on the dead end body where it covers the compressed barrel of the steel forging (area of the filler plug).
17. Compressed portion of the dead end should have a smooth uniform appearance. Remove flash, if present, with file or emery cloth.



**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.**

**SAFETY: Consult your safety training department to ensure that the installation procedure adopted is in compliance with your company's standard procedure.**

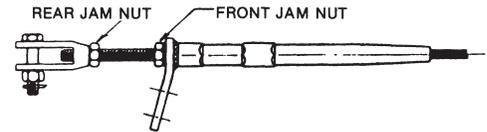
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## Installation Instructions

### Clevis Adjustment of Adjustable Compression Dead Ends on ACSR Conductors

#### Standard Method

1. Loosen rear jam nut.
2. Rotate clevis for proper sag and tension.
3. Tighten rear jam nut.



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**SAFETY:** Consult your safety training department to ensure that the installation procedure adopted is in compliance with your company's standard procedure.