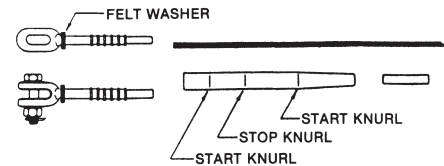


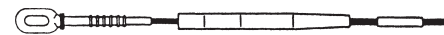
Installation Instructions

Compression Dead Ends on EHS ACSR, Alumoweld® and Steel Ground Wire

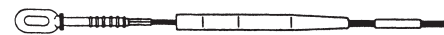
1. Serve the conductor, prior to cutting, to help maintain the round contour. File burrs or shape edges off the conductor as necessary for ease of insertion.
2. Straighten several feet of conductor removing set caused by reel.



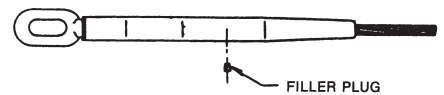
3. Slide the aluminum filler sleeve over conductor.
4. Slide the aluminum dead end body over conductor; tapered end first.
5. Select the die size for compressing the steel barrel. The die size marked on the die and the die size marked on the steel dead end must be the same.
6. Insert the conductor into the bore of the steel dead end.



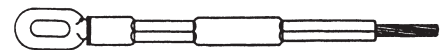
7. Compress the steel barrel full length making initial compression adjacent to the corrugations. Overlap each successive compression by approximately 1/4 die bite. Complete die closure is required for proper compression.



8. Slide the aluminum dead end body over steel forging until the end butts solidly against the felt washer.
9. Slide the aluminum filler sleeve into the aluminum dead end body until the ends of the filler sleeve and the aluminum dead end body are flush.
10. Inject AFL Filler Compound (AFC) into filler hole until compound emerges at the felt washer. Insert and drive filler plug into hole and peen edge of hole over top surface of plug.
11. Select the die size to compress the aluminum dead end body. The die size for the aluminum dead end body and the size marked on the die must be the same.



12. It is recommended that die grooves be well lubricated with a light weight oil. Oil coating should be maintained during entire compression operation.
13. Make the initial compression on the dead end body over the steel shank beginning at the "start knurl" nearest the eye or clevis. Continue making compressions to the "stop knurl" overlapping the previous compression by 1/4 die bite. Complete die closure is required for each compression.
13. To press the dead end body and filler sleeve over the conductor, use the same die used in step 13. Make the initial compression at the "start knurl" nearest the end of the dead end body. Complete die closure is required for each compression.
14. The 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.