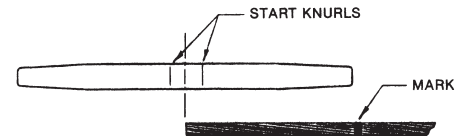


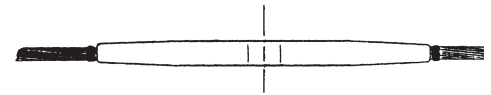
## Installation Instructions

### Compression Joints on AAC, AAAC, ACAR and AWAC Conductors

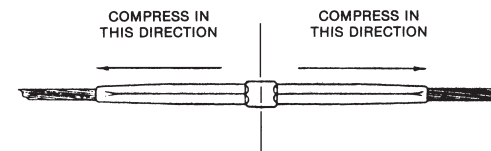
1. Measure back from each conductor end and mark at a distance equal to  $\frac{1}{2}$  the length of the aluminum joint.
2. File burrs or sharp edges off the aluminum strands as necessary for ease of insertion.
3. Prior to making connections, the conductor must be wire brushed and accessory bores must be clean. If the conductor is weathered or blackened, carefully unlay aluminum strands for a distance equal to or greater than  $\frac{1}{2}$  the length of the aluminum joint and clean strands thoroughly with wire brush or abrasive cloth. Check accessory bore for foreign particles, removing if present.
4. Straighten several feet of conductor removing Set caused by reel.



5. Inject AFL Filler Compound (AFC) into each end of joint and on the conductor to ensure that excess compound will be forced from the barrel when compressions are completed. Insert conductor ends into the joint. If the mark on the conductor is not at end of the joint, and there is resistance to further entry, twist the joint on the conductor. This will work the compound between conductor strands and bleed air from the joint.
6. Select die size for compressing joint. The die size on die and die size marked on aluminum joint must be the same.
7. The joint will bow during compression unless reasonable care is taken to have about 15 ft. (4.5 m) of the conductor supported straight out from both ends of the joint such that the weight of the conductor does not hang unsupported from the end of the joint when compressing.



8. Make initial compression on either side of joint starting at the "start knurl". Make the second compression on the opposite end of the joint at the other "start knurl". Continue making compressions to one end of joint overlapping the previous compression by approximately  $\frac{1}{4}$  die bite. Complete die closure is required for each compression. Go back and complete the compressions on the opposite end. The center portion of the joint, approximately one inch, is not compressed. It is recommended that die grooves be well lubricated with a light weight oil. Oil coating should be maintained during entire compression operation.
9. Compressed portion of the joint 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.**