

Installation Procedure for AFL

IMPACCT®

Implosive Accessory Compression Technology

Compression Dead End (ACSR)

(Assembly Reference B9631)

NOTE:

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Preparation

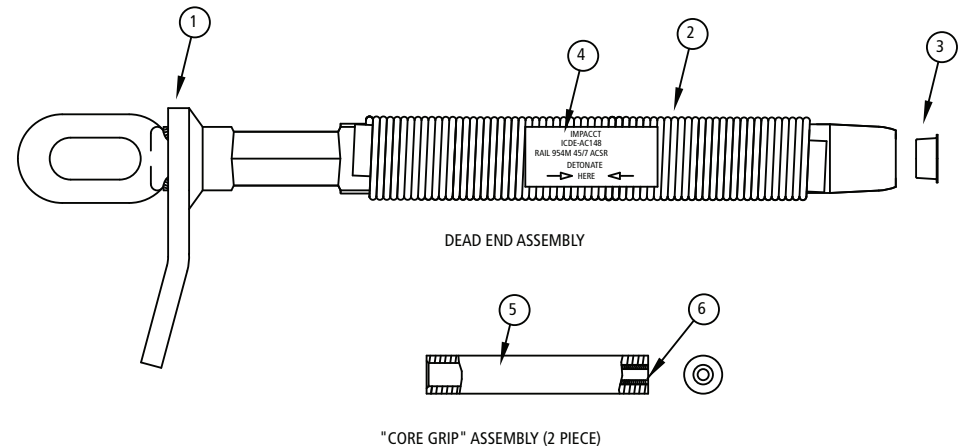
Prior to making connections, conductor and accessory "bore" must be clean. Regardless of conductor condition, the strands need to be cleaned with a wire brush or abrasive cloth. Check accessory "bore" for foreign particles, removing if present.

Straighten out several feet of conductor removing set caused by reel. Ensure conductor end is in good condition for use. If conductor is to be cut, use tape or tie wire to temporarily retain the conductor's strands in a tight configuration, remove when appropriate from assembly.

Bill of Materials

IMPACCT® Implosive Dead End (ACSR) Assemblies consist of the following Parts List:

ITEM	DESCRIPTION	MATERIAL	QTY
IMPACCT IMPLOSIVE DEAD END ASSEMBLY			
1	IMPACCT Implosive Dead End	Aluminum Body & Steel Eye	1
2	Implosive Charge - Wrap	Detonation Cord	—
3	End Cap	Plastic	1
4	Protective Wrap with Identification	Plastic	—
"CORE GRIP" ASSEMBLY			
5	Sleeve - Outer	Aluminum	1
6	Sleeve - Inner - Half Sleeve	Aluminum	1



Installation

General Information

Do not remove plastic wrap from outside of Accessory. The wrap maintains the Detonation Cord in a tight configuration and provides location for the Detonator.

1. Remove "End Cap." Mark the conductor from label location to end of barrel. See Fig. 1.

NOTE: It is important while performing the following steps, to ensure the Dead End remains clean and free from damage.

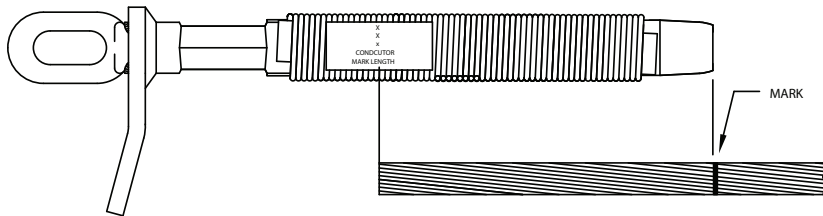


Fig. 1

2. Cut back the aluminum strands on end of conductor a distance equal to the length of the "Inner - Half Sleeve," less 0.12 inches. Use a cable trimming tool. Use tape or tie wire to temporarily retain the conductor's strands in a tight configuration during strand removal. See Fig. 2.

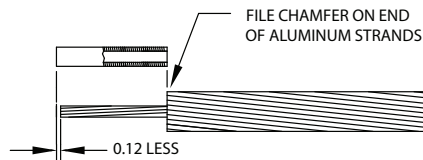


Fig. 2

3. **IMPORTANT:** File burrs from end of steel strands. Slide conductor's steel core into end of "Inner - Half Sleeve" (Center Piece of "Core Grip"). Rotate the Sleeve in a "back-and-forth" motion to ease insertion of the steel core. Ensure "Inner - Half Sleeve" is tight against the aluminum strands as shown in Fig. 3.

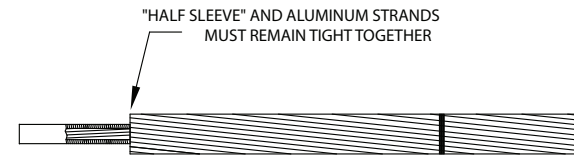


Fig. 3

4. Slide the "Half Sleeve" into the "Core Grip." Note identification on "Core Grip" for proper end to insert "Half Sleeve." Ensure "Core Grip" is tight against the aluminum strands as shown in Fig. 4.

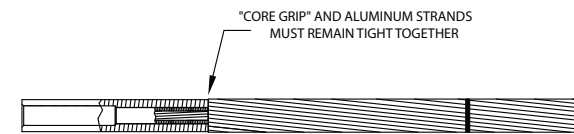


Fig. 4

5. Slide the conductor/core grip into the barrel of the Dead End until it bottoms against the steel forging. The "mark" should now be at the end of the barrel. See illustration shown in Fig. 5. The end of the "Core Grip" will now be over the "smaller" corrugations of the Steel Eye. See illustration shown in Fig. 5. Add "Mark" 4 inches from end of Barrel. (To verify no "pull out," see Step 6.)

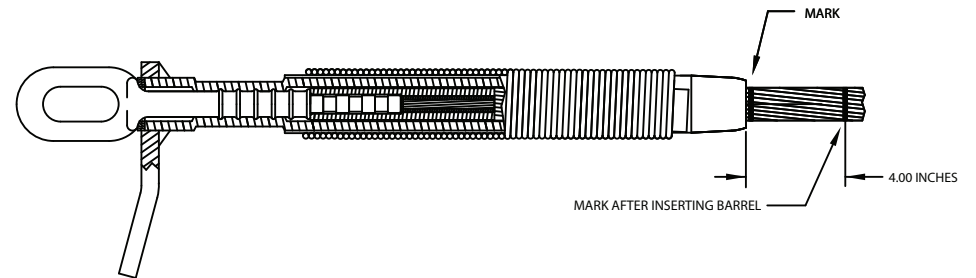


Fig. 5

6. The "Core Grip" assembly must remain tight against the aluminum strands and Steel Eye prior to detonation. (Reference: Steps 3 and 4.) To maintain a tight assembly: use "Duct Tape" to secure. Wrap onto end of barrel, then conductor, to hold conductor tight within assembly. See Fig. 6. Measure from end of the Barrel to 4 inch "Mark" to ensure the conductor has not pulled out.

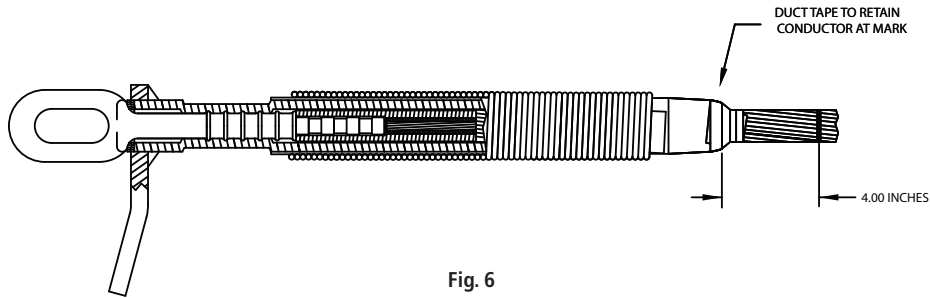


Fig. 6

7. Locate the detonator at location specified on barrel. Tape securely in place. See Fig. 7.

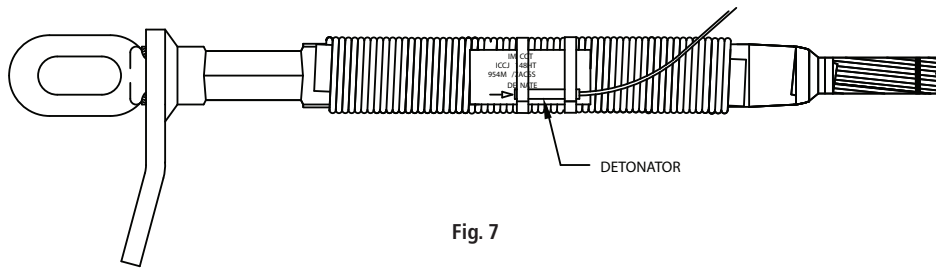
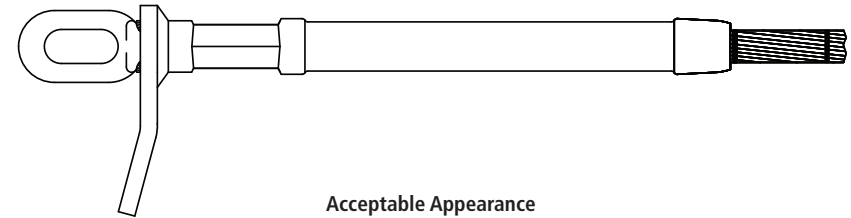


Fig. 7

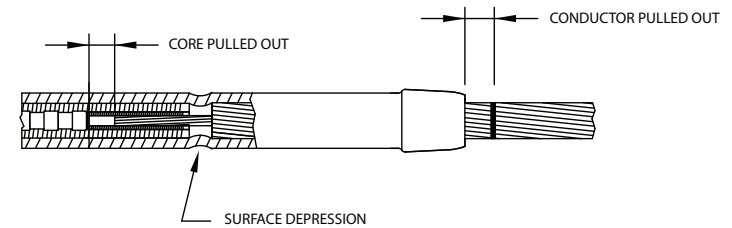
8. Before initiating the implosion, visually inspect Dead End Assembly to ensure the conductor has not pulled out.
9. Follow the procedures given in the Manual for retaining assembly, initiation of Implosives, and Safety.
10. After detonation, remove the debris from accessory and cable. Clean surface of Accessory with cleaner and cloth to remove powder residue.

11. The Dead End should be straight in appearance. Its surface should be smooth and continuous without depressions.



Acceptable Appearance

NOTE: A depressions at location of "Core Grip" and Conductor interface (See Step 3) would indicate the conductor had pulled away form "Core Grip." This condition would lessen the holding strength of the accessory and it should be considered for removal.



Non-acceptable Appearance