

Installation Procedure for AFL

IMPACCT®

Implosive Accessory Compression Technology

Compression Dead End (ACSS)

(Assembly Reference B9930, B11828)

NOTE:

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Preparation

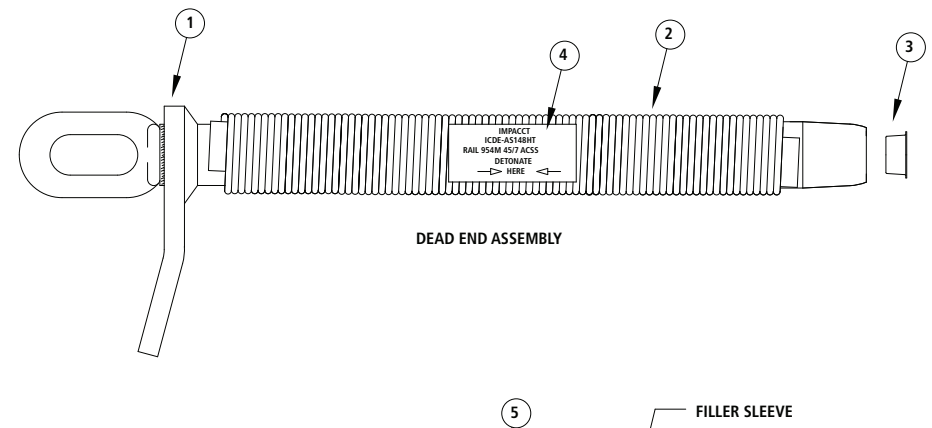
Prior to making connections, conductor and accessory "bore" must be clean. Regardless of conductor condition, the strands need to be cleaned with a wire brush or abrasive cloth. Check accessory "bore" for foreign particles, removing if present.

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 (ACSS) Assemblies consist of the following Parts List:

| ITEM | DESCRIPTION | MATERIAL | QTY |
|--|--------------------------------------|--------------------|-----|
| IMPACCT IMPLOSIVE DEAD END ASSEMBLY | | | |
| 1 | IMPACCT Implosive Dead End | Aluminum Body | 1 |
| 2 | Implosive Charge - Wrap | Detonation Cord | — |
| 3 | End Cap | Plastic | 1 |
| 4 | Protective Wrap with Identification | Plastic | — |
| 5 | Steel Eye and Aluminum Filler Sleeve | Steel and 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.

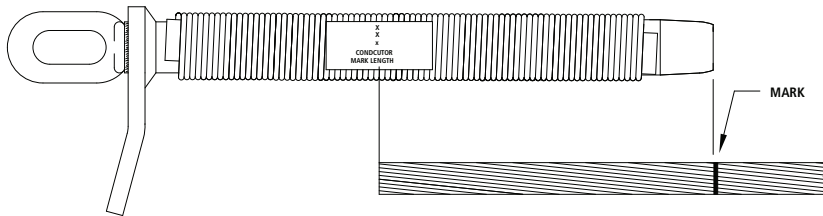


Fig. 1

2. Cut back the aluminum strands on end of conductor, a distance equal to the length of the "Steel Forging" barrel, less 0.12 inches. Use 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.

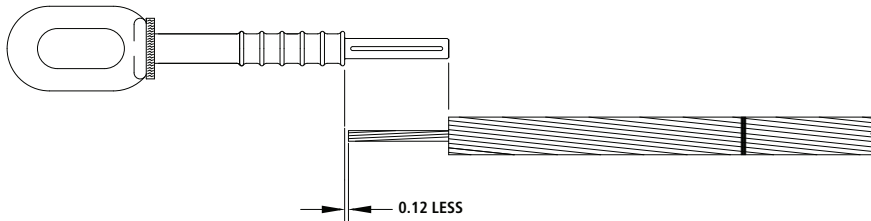


Fig. 2

3. Slide the Dead End over the conductor beyond mark made in Fig. 1. See Fig. 3.

IMPORTANT: File burrs from end of steel strands.

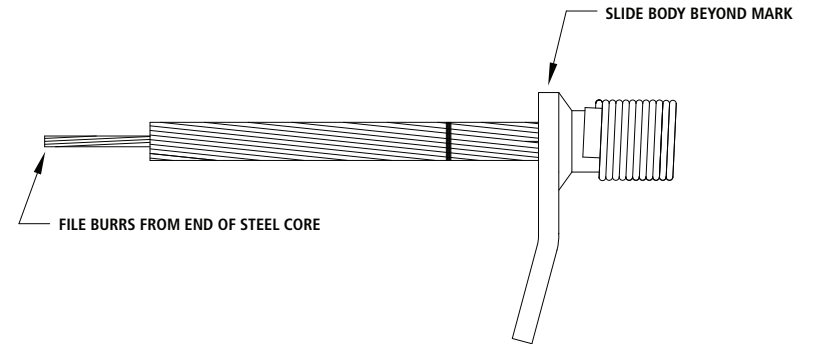


Fig. 3

4. Slide "Filler Sleeve" onto barrel of "Steel Forging." See Fig. 4.

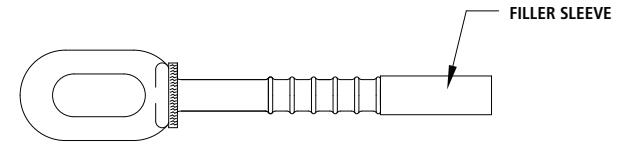


Fig. 4

5. Slide conductor's steel core into ends of the "Steel Forging" barrel. Rotate the "Steel Forging" in a "back-and-forth" motion to ease insertion of the steel core. Ensure "Filler Sleeve" is tight against the aluminum strands as shown in Fig. 5.

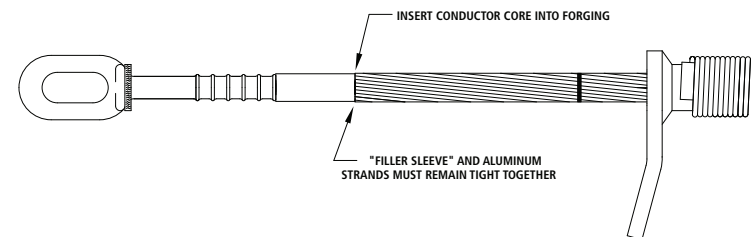


Fig. 5

- Slide the conductor/forging assembly into the barrel of the Dead End, until the felt washer is seated against the end of the barrel. (The felt washer must be tight against end of barrel to form a seal) The "mark" should now be visible at the end of the barrel. **See illustration shown in Fig. 6.** Add "Mark" 4 inches from end of Barrel. (To verify no "pull out," **see Step 7.**)

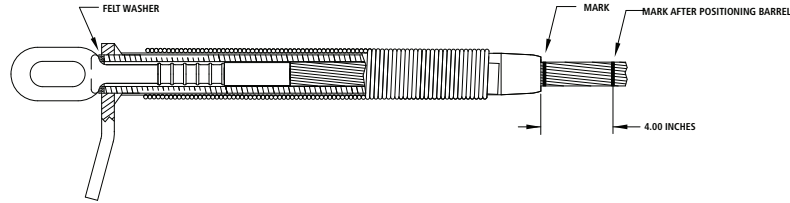


Fig. 6

- The "Steel Forging" assembly must remain tight against the aluminum strands prior to detonation. (**Reference: Steps 5 and 6.**) To maintain a tight assembly: use "Duct Tape" to secure. Wrap onto "Steel Forging" and Dead End Body tongue, to hold forging tight against "Felt Washer" and end of barrel. Then wrap onto end of barrel, then conductor, to hold conductor tight within assembly. **See Fig. 7.** Measure from end of the Barrel to 4 inch "Mark" to ensure the conductor has not pulled out.

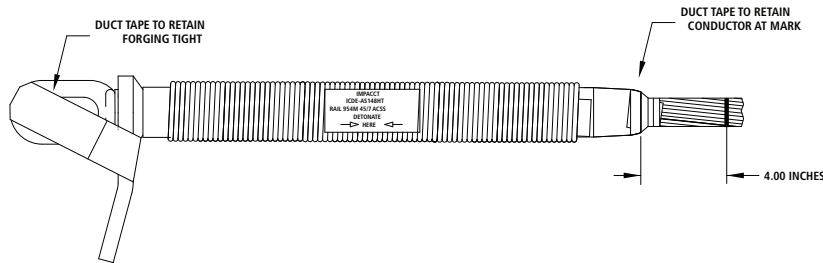


Fig. 7

- Locate the detonator at location specified on barrel. Tape securely in place. **See Fig. 8.**

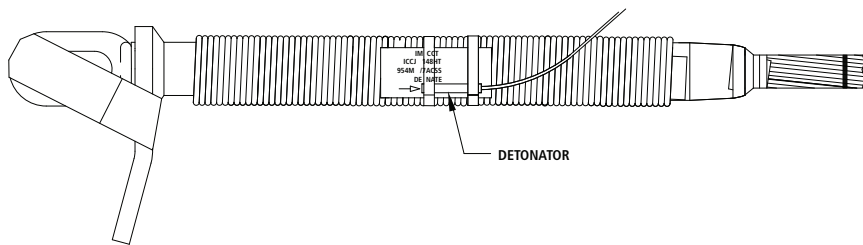


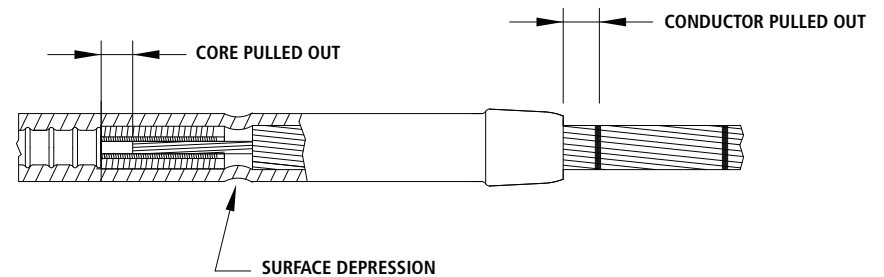
Fig. 8

- Before initiating the implosion, visually inspect Dead End Assembly to ensure the conductor has not pulled out and Forging/Felt Washer is tight against back end of dead end.
- Follow the procedures given in the Manual for retaining assembly, initiation of Implosives and Safety.
- After detonation, remove the debris from accessory and cable. Clean surface of Accessory with cleaner and cloth to remove powder residue.
- The Dead End should be straight in appearance. Its surface should be smooth and continuous without depressions.



Acceptable Appearance

NOTE: A depression at the end of Forging barrel and Conductor interface (**see Step 5**) would indicate the conductor had pulled away from "Forging". This condition would lessen the holding strength of the accessory and it should be considered for removal.



Non-acceptable Appearance