

Installation Procedure for AFL

IMPACCT®

Implosive Accessory Compression Technology

Compression Joint (ACSS)

(Assembly Reference B9932, B11830)

NOTE:

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Preparation

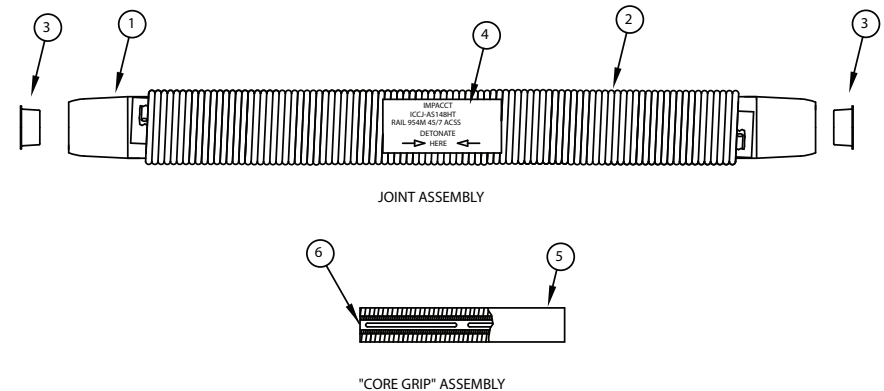
Prior to making connections, conductor and accessory "bore" must be clean. Regardless of conductor condition, the strands need to be cleaned with a wire brush or abrasive cloth. Check accessory "bore" for foreign particles, removing if present.

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 Joint (ACSS) Assemblies consist of the following Parts List:

ITEM	DESCRIPTION	MATERIAL	QTY
IMPACCT IMPLOSIVE JOINT ASSEMBLY			
1	IMPACCT Implosive Joint	Aluminum	1
2	Implosive Charge - Wrap	Detonation Cord	—
3	End Caps	Plastic	2
4	Protective Wrap with Identification	Plastic	—
"CORE GRIP" ASSEMBLY			
5	Sleeve - Outer	Aluminum	1
6	Sleeve - Inner	Steel	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. Mark each conductor from label location (at center of Joint) to end of barrel. See Fig. 1.

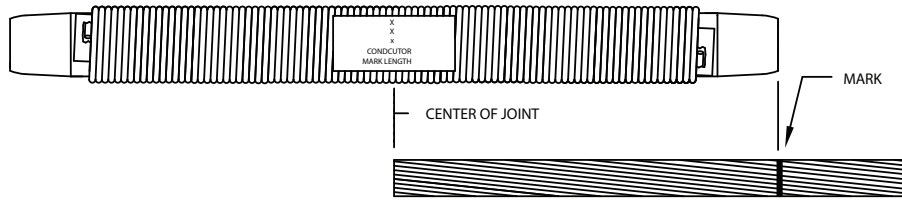


Fig. 1

2. Remove "End Caps," and then slide the Joint over the conductor and beyond mark as shown in Fig. 2.

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



Fig. 2

3. Cut back the aluminum strands on ends of each conductor a distance equal to 1/2 the length of the "Core Grip" Assembly, 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. 3.

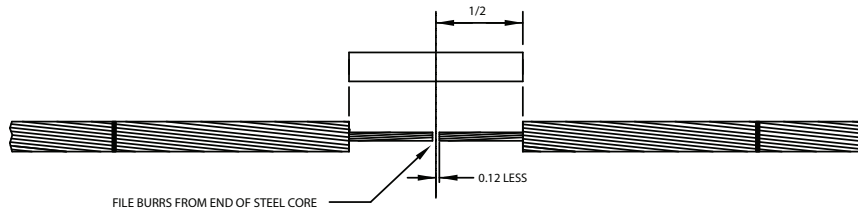


Fig. 3

4. **IMPORTANT:** File burrs from end of steel strands. Slide each conductor's steel core into ends of the "Core Grip" Assembly. Rotate the "Core Grip" Assembly in a "back-and-forth" motion to ease insertion of the steel core. Ensure "Core Grip" Assembly is tight against the aluminum strands as shown in Fig. 4.

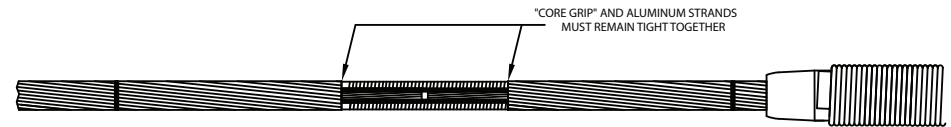


Fig. 4

5. Slide the Joint over the "Core Grip" Assembly and center it within the marks on the conductors as shown in Fig. 5. Add "Mark" 4 inches from each end of Joint. (To verify no "pull out," see Step 6.)

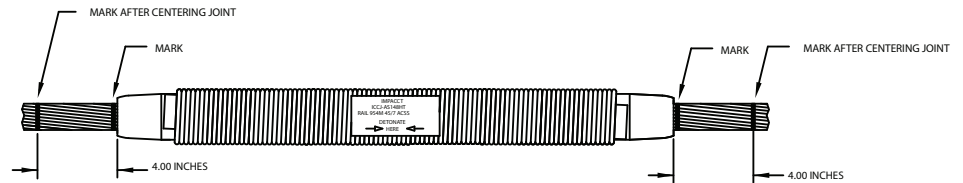


Fig. 5

6. The "Core Grip" Assembly must remain tight against the aluminum strands prior to detonation. (Reference: Step 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 Joint to 4-inch "Mark" to ensure the conductor has not pulled out.

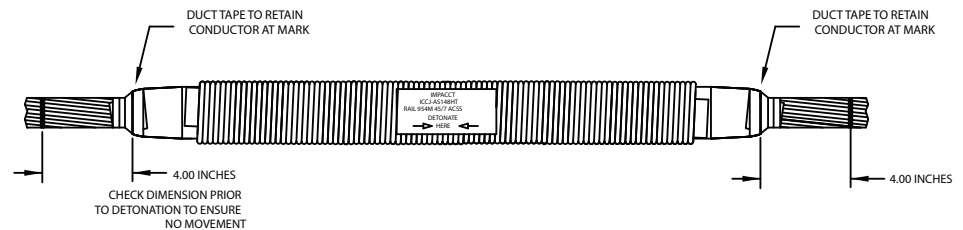


Fig. 6

- Locate the detonator at the center of the Joint. Tape securely in place. See Fig. 7.

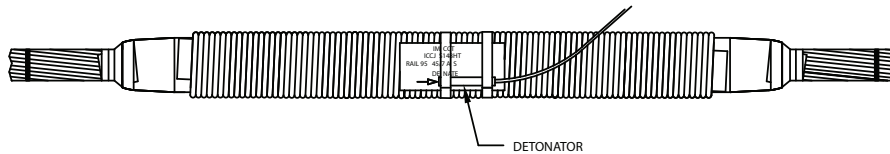
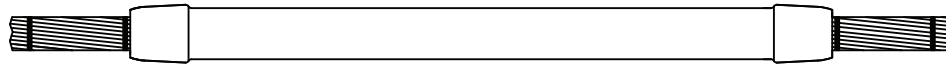


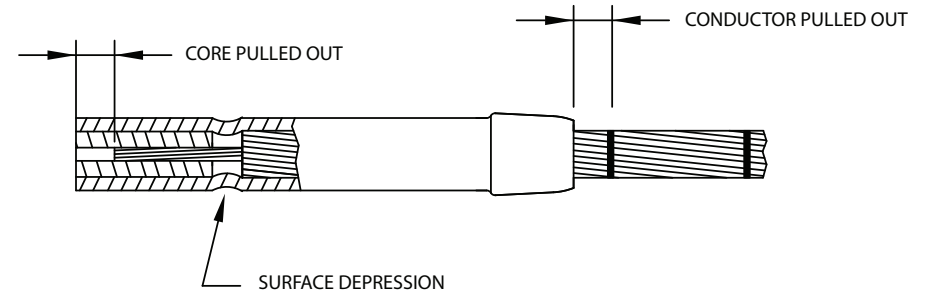
Fig. 7

- Before initiating the implosion, visually inspect Joint Assembly to ensure the conductors have not pulled out.
- 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 Joint should be straight in appearance. Its surface should be smooth and continuous without depressions.



Acceptable Appearance

NOTE: A depression at location of "Core Grip" and Conductor interface (See Step 4) would indicate the conductor had pulled away from "Core Grip." This condition would lessen the holding strength of the accessory and it should be considered for removal.



Non-acceptable Appearance