

Swage Cable Installation Instructions

NOTE: VISUALLY INSPECT ALL TOOLS, ACCESSORIES AND FITTINGS PRIOR TO BEGINNING THE INSTALLATION PROCEDURE. INSPECT CONDUCTOR ACCESSORIES AND ENSURE THE BORE OF EACH FITTING IS LINED WITH AFL FILLER COMPOUND (AFC). ENSURE YOU HAVE THE CORRECT TOOLS; SEE TABLE 1.

Table 1

AFL NO.	FITTING O.D. (INCHES)	DIE SIZE	HEAD	FILLER DIE	DIE END PLATE	PRESS
SWGGC16	1	45TD16	45THA20	—	D10987-1, D10985-1	45TPU
SWGGC20	1.25	45TD20	45THA20	—	D10987-1, D10985-1	45TPU
SWGGC24	1.5	45TD24	45THA36	B11336-15	D11340-2	45TPU
SWGGC28	1.75	45TD28	45THA36	B11336-15	D11340-2	45TPU
SWGGC30	1.875	45TD30	45THA36	B11336-15	D11340-2	45TPU
SWGGC32	2	45TD32	45THA36	—	D11340-1	45TPU
SWGGC36	2.25	45TD36	45THA36	—	D11340-1	45TPU
SWGGC44	2.75	65TD44	65THA200	L11988-1-S7	B12082-1	65TPU

1. Clean and prepare the cable end.

Cut the cable strands at the end to ensure all strands are even with each other. Clean at least 4 inches of the cable end using ConductaClean® (Fig. 1a) or a wire brush (Fig. 1b). Remove any oil, oxidation or burrs on exterior.



Fig. 1a



Fig. 1b

2. Assembly of the cable connector fitting with the cable

Insert the cable into the cable connector fitting until the end of the cable is visible through the inspection hole. See Fig. 2.

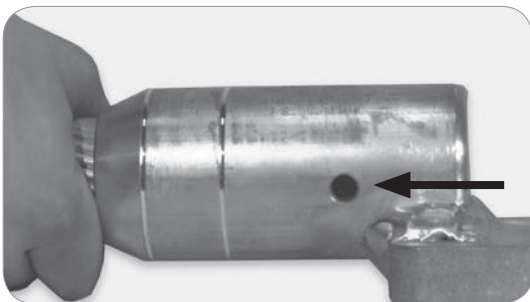


Fig. 2

continued

Swage Cable Installation Instructions (cont.)

3. Assembly of the Hydraulic Pump to the Power Swage Press

Connect the 45 Ton Power Unit or 65 Ton Power Unit to the hydraulic pump using the quick-disconnect hose. See Fig. 3.

NOTE: Use 45TPU for die sizes: 16-36 and use 65TPU for die size: 44.

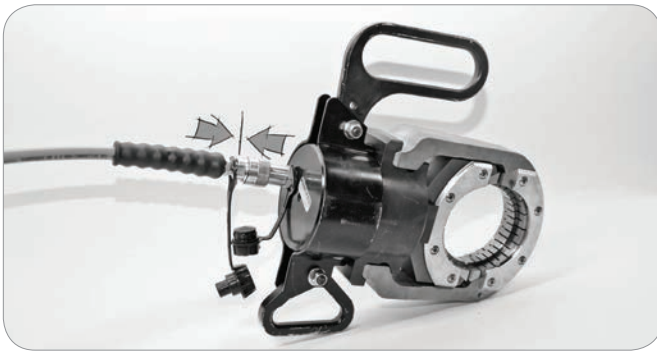


Fig. 3

4. Swaging the Cable Connector Fittings

Using the correct 45TD or 65TD die set, assemble the power unit with the press head. Position the press perpendicular on the accessory as shown below in Fig. 4. Ensure the die teeth are in-line with the Swage lines on both sides. Compress the cable connector to 10,000 psi.



Fig. 4a—**NOTE:** Complete die closure is required on all compressions.

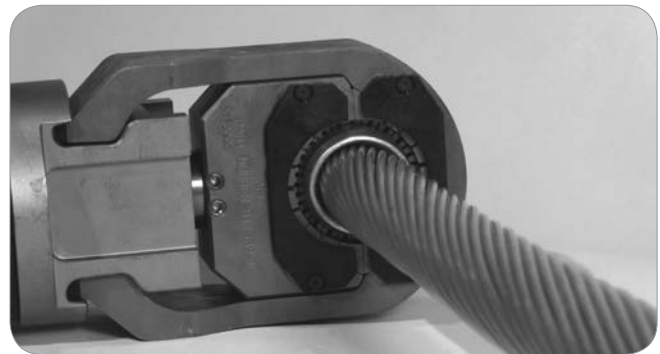


Fig. 4b—**NOTE:** Always properly position yourself to the Swage Press when compression is in progress. Keep clear of the press hose. SEE FIG. 6.

continued

Swage Cable Installation Instructions (cont.)

5. Visually Inspecting the Swage

Verify complete compression was achieved by using the "Swage Gauge." See Fig. 5a. Place –GO– gauge over Swage compression to ensure the gauge fits over the compression mark. Confirm that the accessory touches the deepest point of gauge. See Fig. 5b and 5c. If the "Swage Gauge" does not touch the depth, please re-swage the fitting and re-inspect using the –GO– gauge ensuring they touch the compression mark.

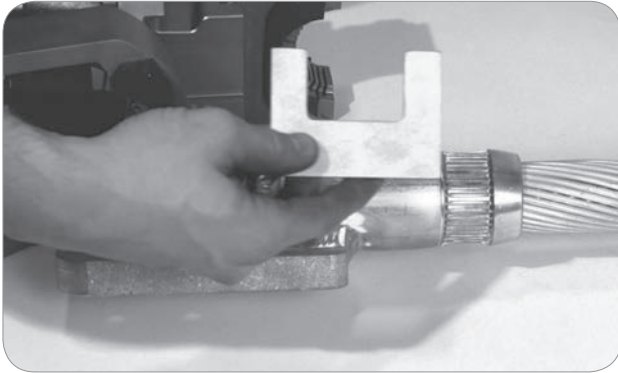


Fig. 5a

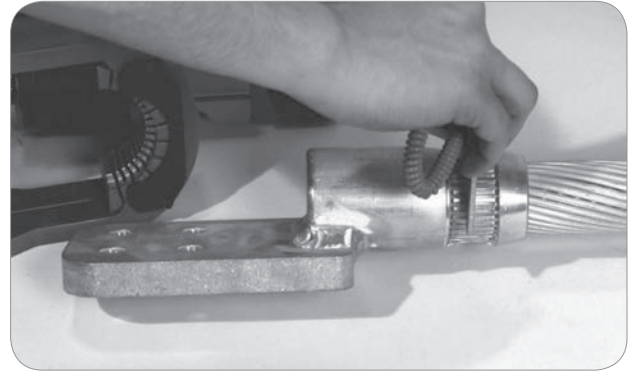


Fig. 5b

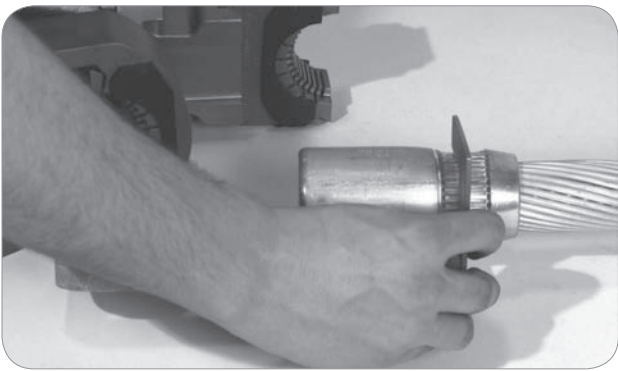


Fig. 5c

Repeat steps 1-5 for each Cable Connector Fitting.