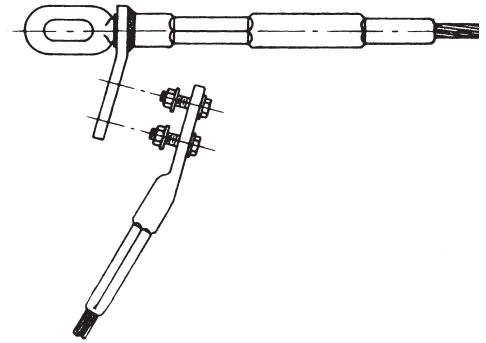


## Installation Instructions

### Terminal Connectors on Alumoweld® and Steel Ground Wire

#### Standard Method

1. Insert conductor full depth into terminal bore and mark conductor at end of barrel. Remove conductor after marking.
2. Inject sufficient AFL Filler Compound (AFC) in the end of the terminal bore and on the conductor to ensure that excess compound will be visible at terminal and when barrel is completely compressed.
3. Insert clean end of the conductor into the terminal barrel to the mark on the conductor.
4. Select die size for compressing aluminum terminal. The die size on die and die size marked on the terminal must be the same.
5. Make initial compression starting at "start knurl". Continue making compressions to the mouth of the terminal overlapping the previous compression by approximately 1/4 die bite. Complete die closure is required for each compression. Compressed portion of the terminal should have a smooth uniform appearance. Remove flash, if present, with file or emery cloth.
6. Clean contact surface of terminal and of dead end pad by wire brushing through No. 2 Electrical Joint Compound (EJC). DO NOT USE AFL FILLER COMPOUND (AFC).
7. Bolt terminal to dead end pad. Partially tighten all bolts and then re-tighten each bolt to recommended torque. 1/2" bolt-25 lbf-ft (34 N.m); 5/8" bolt-40 lbf-ft (54 N.m)



**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.