

Swage Grounding Installation Instructions

NOTE: VISUALLY INSPECT ALL TOOLS, ACCESSORIES AND FITTINGS PRIOR TO BEGINNING THE INSTALLATION PROCEDURE. INSPECT CONDUCTOR ACCESSORIES AND ENSURE THAT THE FITTING IS NOT OBSTRUCTED. ENSURE YOU HAVE THE CORRECT TOOLS; SEE TABLE 1.

Table 1

FITTING OD (INCHES)	DIE SIZE	HEAD	FILLER DIE	PRESS
1.00	45TD16	45THA20	—	45TPU
1.25	45TD20	45THA20	—	45TPU
1.50	45TD24	45THA36	B11336-15	45TPU
1.75	45TD28	45THA36	B11336-15	45TPU
1.88	45TD30	45THA36	B11336-15	45TPU
2.00	45TD32	45THA36	—	45TPU
2.25	45TD36	45THA36	—	45TPU
2.75	65TD44L	65THA200L	—	65TPU-L

1. Clean and prepare the cable end.

Using a brass or stainless steel wire brush, brush and thoroughly clean the conductor to be used with the Swage grounding connector.



2. Assemble the cable connector fitting with the cable.

Insert the cleaned end of the conductor into the barrel of the grounding fitting to be used. Using the sight/weep hole, ensure that the conductor is at the bottom of the cavity and mark the insertion depth on the conductor with a permanent ink marker.

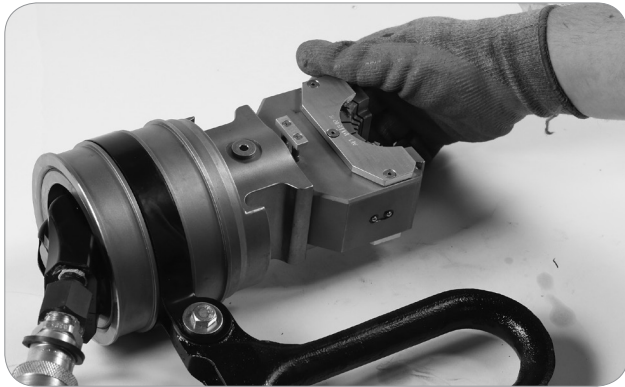


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Swage Grounding Installation Instructions (cont.)

3. Make the Swage compression.

With the tooling assembled, insert the grounding connector in the tool. Align the raised Swage mark (line) on the connector with the raised portion of the teeth of the dies (contact surface) and the end of the connector. Insert the cable in to the grounding connector to the ink mark on the conductor and compress to 10,000 PSI.



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Swage Grounding Installation Instructions (cont.)

4. Make the proper Swage connection.

Use appropriate go/no-go gauge and measure the crimped area for fit. If the gauge fits compressed area, compression is complete. If the gauge does not fit the compressed area, check hydraulic pump for correct pressure and fluid level. Re-squeeze to ensure full compression and re-check.



5. Properly inspect the Swage compression.

Verify complete compression was achieved by using the "Swage Gauge." See Fig. 5a. Place the –GO/NO-GO– gauge over Swage compression area to ensure the gauge fits over the full compression area. Confirm that the accessory touches the deepest point of gauge. See Fig. 5b and 5c. If the "Swage Gauge" does not slide over compressed area, then re-swage the fitting and re-inspect using the –GO/NO-GO– gauge ensuring they touch the compression mark.



Fig. 5a

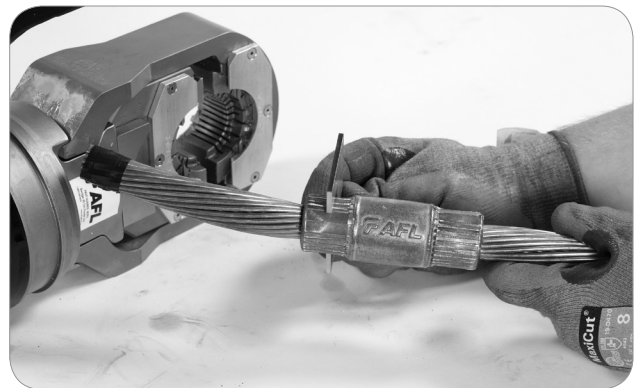


Fig. 5b

Repeat steps 1-5 for each Grounding Fitting.