Installation Instructions

Standard Compression Dead End for ACSR and ACSS Conductor

CAUTION: ACSR Dead Ends Cannot Be Used on ACSS HT Conductor

1. Mark the conductor a distance of 3/4 the length of the aluminum body (***Figure 1***).
2. Prior to making connection, the outer strands of the conductor must be cleaned with a wire brush or abrasive cloth (***Figure 2***).
3. Prior to any strand cutting, tape the end of the conductor to help maintain the round contour.
4. Slide the aluminum dead end body over conductor until sufficient working length protrudes from tongue end. (***Figure 3***).
5. Cut back aluminum strands equal to the depth of the steel forging barrel plus 1 inch (25.4 mm). Do not nick the steel strands. File burrs, if present. (***Figure 4***). Use of a cable trimming tool is recommended. (***Figure 4a, 4b***).
6. Insert steel core into steel barrel to full length of bore. (***Figure 5***).
7. Using the proper SH die set, compress steel barrel full length making initial compression adjacent to rib closest to barrel. Overlap each successive compression by at least ¼ inch (6.4 mm). Complete die closure is required on all compressions. (***Figure 5a, 5b***).
8. Slide the aluminum body over the steel forging until the tongue end butts solidly against felt washer and shoulder of steel eye. Align eye with tongue to desired orientation for attachment to insulator string. (***Figure 6***).

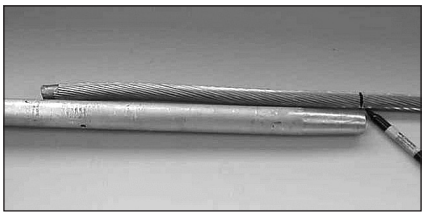

FIGURE 1: Mark the conductor and clean 3/4 the length of the aluminum body.

FIGURE 2: Clean a distance of at least ¾ the distance of the aluminum dead end body.

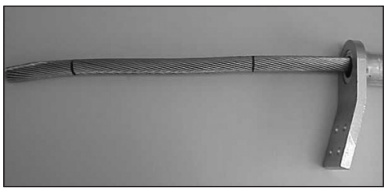

FIGURE 3: Slide aluminum dead end body over conductor.

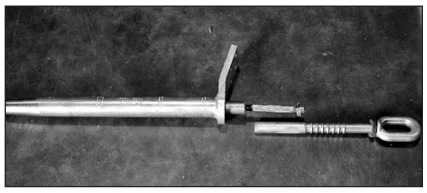

FIGURE 4:

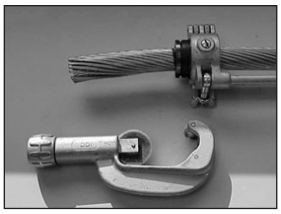

FIGURE 4a:

FIGURE 4b:

FIGURE 5:

FIGURE 5a:

FIGURE 5b:

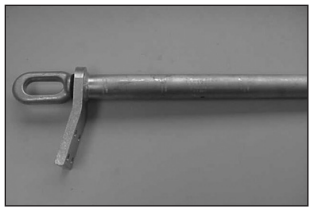

FIGURE 6:

Installation Instructions (cont.)

Standard Compression Dead End for ACSR and ACSS Conductor

9. Inject filler compound (AFC or AFCHT for HiTemp®) into filler hole until compound emerges at felt washer and tapered end of aluminum body. (***Figure 6a***).

10. Insert and drive filler plug (cavity up) into hole and peen edge of hole over top surface of plug. (***Figure 7***). Leaving the filler plug in the small plastic bag makes it easier to insert when working with gloves. (***Figure 7a***).

11. Using the proper AH die set, make the initial compression on the aluminum body beginning at the "start" mark nearest the tongue. Overlap each successive compression by at least ¼ inch (6.4 mm). Press only to the "stop" mark. Complete die closure is required for each compression. (***Figure 8***).

    Note: A light oil coating on the die grooves and aluminum sleeve is recommended.

12. To press the dead end body over the conductor, use the same die used in step 11. Begin compressing at the "start" mark about centrally located. Overlap each successive compression by at least ¼ inch (6.4 mm). Press to the end of the body, including the tapered portion. Complete die closure is required on each compression. (***Figure 9***).

    During this compression sequence, the plastic bag in which the dead end assembly was received can be used as a medium between the aluminum body and dies (instead of oil as mentioned in step 11).

13. Compressed portion of dead end body should have a smooth uniform appearance. (***Figure 10***). If die flash is present, remove with a file or emery cloth.

14. Remove any excess filler compound which may have been forced out the end of the dead end body.

FIGURE 6a:

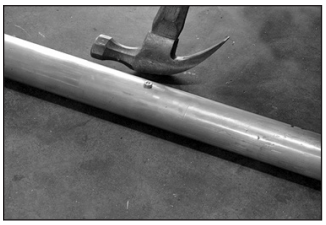

FIGURE 7:

FIGURE 7a:

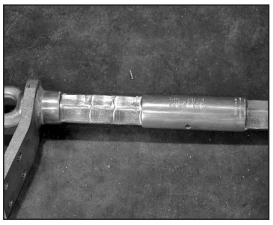

FIGURE 8:

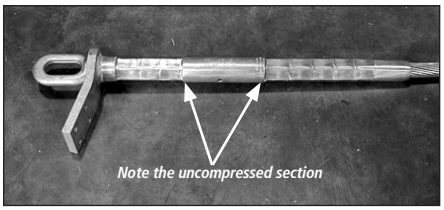

FIGURE 9:

FIGURE 10: