

SWAGING TOOLS INSTRUCTIONS

****IMPORTANT NOTE****

DO NOT USE FITTINGS PRESSED OR SWAGED OVER ANY PLASTIC JACKETED CABLE



SLEEVES MUST BE SWAGED. USER MUST FOLLOW SWAGING TOOL INSTRUCTIONS FOR PROPER INSTALLATION. FAILURE TO DO SO MAY RESULT IN PERSONAL INJURY, DEATH OR PROPERTY DAMAGE.

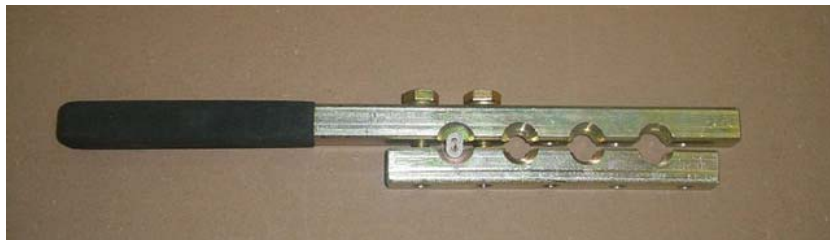
The holding power of sleeves is influenced by the diameter of the wire rope as well as construction. Exact strength tests should always be performed on a sample of the wire rope to be used when exact holding power must be determined. As in all wire rope applications, proper design factor must be employed: design factor is the ratio of strength of assembly to the applied load.

Cable Sleeve Selection Chart		
Aluminum, Copper, Tin Coated Sleeves		
Cable & Sleeve Size	Groove Cavity	Number of Crimps
1/16"	2	1
3/32"	3	3
1/8"	4	3
5/32"	5	3
3/16"	6	4

MAKING A COMPRESSION SLEEVE SPLICE

After determining which nominal diameter wire rope you wish to splice and the type of splice you wish to make, select the Sleeve of the same nominal size. Then, by referring to the Chart note which tool, tool groove/gauge cavity you should use and the number of crimps which should be taken. Proceed as follows:

- Insert sleeve into the appropriately sized cavity of the tool.
- Bolt placement should be aligned with selected size swage.
- Tighten bolts with equal pressure, until swaged properly.



Sleeve placement in hand tool.

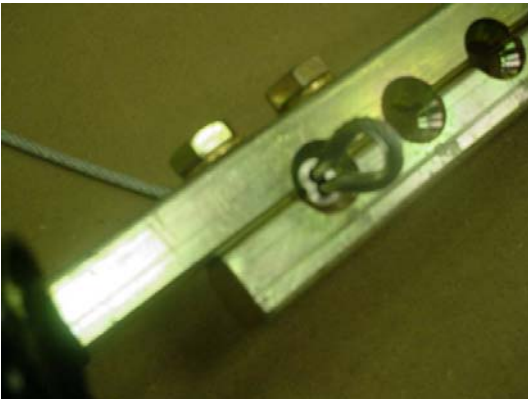
SWAGING TOOLS INSTRUCTIONS

LOOPS:

Insert cable through the sleeve and rethread back to form loop to size desired. It is usually easier to form a larger loop at first and then to pull back on the longer end of the cable until the proper loop size is obtained. Leave cable about the equivalent length of $1\frac{1}{2}$ times the diameter of cable extending outside of the sleeve after threading, and make sure this does not slip back into the sleeve when "pulling up".

Using the correct groove #, take the required number of crimps along the sleeve. Do not start on the very edge of the sleeve. Sleeve ends should project beyond the tool jaws slightly. After each crimp, rotate the sleeve 180° to avoid deforming the shape of the sleeve. Gauge the sleeve after compression. If the gauge does not slip freely onto the crimp portion, the tool should be adjusted.

For manual tools, tighten the bolts alternately and evenly until the two tool halves touch. This is the indication that the crimp is complete.



Completed crimp with hand tool.



Completed crimp with lever tool.

LAP SPLICE:

After threading the two lengths of cable into the Oval Sleeve, crimping instructions are basically the same as loops. Note, a minimum of two sleeves are recommended and proper tests should be made to determine actual strength of the splice. Leave the usual $\frac{1}{8}$ " of cable protruding from the sleeve and allow a space of at least two cable diameters between the sleeves. Gauge as usual.