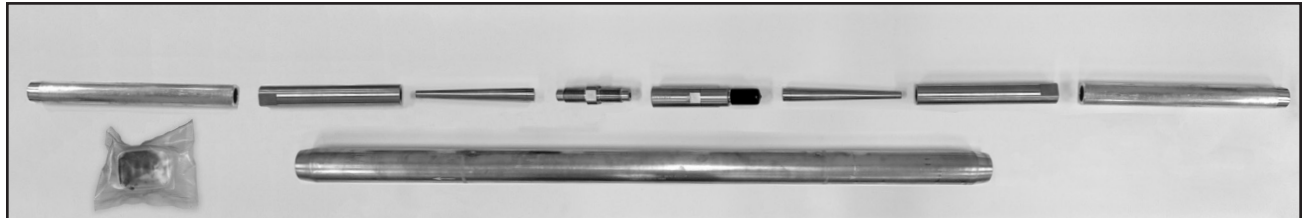




## PLP Compression Splice for ACCC® Conductors

Be sure to read and completely understand this procedure before applying product.  
Be sure to select the proper size PREFORMED™ product before application.



### Step #1

Measure and mark both conductors' core length from the end of the conductor, according to the "Exposed Core Length" column in the provided table.



**Side A** is denoted as the conductor closest to the structure.

**Side B** is denoted as the conductor that is furthest from the structure.

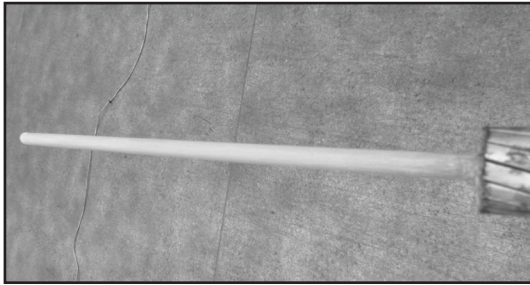
USA ACCC Code Name	International ACCC Code Name	mm <sup>2</sup>	Outside Dia. Inches (mm)	Side A Exposed core length Inches (mm)	Side B Exposed core length Inches (mm)
--	Silvassa	150.7	0.565 (14.35)	8.3 (212)	7.0 (177)
Pasadena	Helsinki	153.5	0.616 (15.65)	8.3 (212)	7.0 (177)
--	Jaipur	156.7	0.65 (16.50)	8.3 (212)	7.0 (177)
Linnet	Copenhagen	223.0	0.72 (18.29)	8.3 (212)	7.0 (177)
Oriole	Reykjavik	226.3	0.741 (18.82)	8.3 (212)	7.0 (177)
Waco	Glasgow	239.8	0.769 (19.53)	8.3 (212)	7.0 (177)
Laredo	Casablanca	276.8	0.807 (20.50)	8.3 (212)	7.0 (177)
Hawk	Lisbon	318.7	0.857 (21.78)	8.3 (212)	7.0 (177)
Dove	Amsterdam	371.4	0.927 (23.55)	8.3 (212)	7.0 (177)
Grosbeak	Brussels	425.3	0.990 (25.14)	8.3 (212)	7.0 (177)
Irving	Oslo	317.7	0.882 (22.40)	11.2 (285)	10.2 (260)
Lubbock	Stockholm	467.2	1.039 (26.40)	11.2 (285)	10.2 (260)
Galveston	Warsaw	514.8	1.091 (27.72)	11.2 (285)	10.2 (260)
Drake	Dublin	528.5	1.108 (28.15)	11.2 (285)	10.2 (260)
Plano	Hamburg	553.3	1.127 (28.62)	11.2 (285)	10.2 (260)
Corpus Christi	Milan	574.6	1.146 (29.10)	11.2 (285)	10.2 (260)
Arlington	Rome	599.4	1.177 (29.89)	11.2 (285)	10.2 (260)
Cardinal	Vienna	635.9	1.198 (30.42)	11.2 (285)	10.2 (260)
Forth Worth	Budapest	674.9	1.240 (31.50)	11.2 (285)	10.2 (260)
El Paso	Prague	697.7	1.251 (31.77)	11.2 (285)	10.2 (260)
Beaumont	Munich	740.3	1.293 (32.85)	11.2 (285)	10.2 (260)
--	Mumbai	756.7	1.251 (31.77)	11.2 (285)	10.2 (260)
San Antonio	London	766.0	1.315 (33.40)	11.2 (285)	10.2 (260)
Bittern	Paris	820.9	1.345 (34.17)	11.2 (285)	10.2 (260)
Dallas	Antwerp	952.1	1.451 (36.85)	11.2 (285)	10.2 (260)
--	Madrid	1023.5	1.504 (38.20)	11.2 (285)	10.2 (260)

\*ACCC® is a registered trademark of CTC Global, Inc.

**Step #2** Apply tape approximately 1" (25.4 mm) back from each mark to secure the aluminum strands and maintain the conductor diameter after the cut is made.

**Step #3** Cut the outer strands at each mark to expose the composite core.

**NOTE:** Take care not to cut or damage the core. Ensure that the core end is uncrushed. Failure to follow these instructions could result in a poor connection.

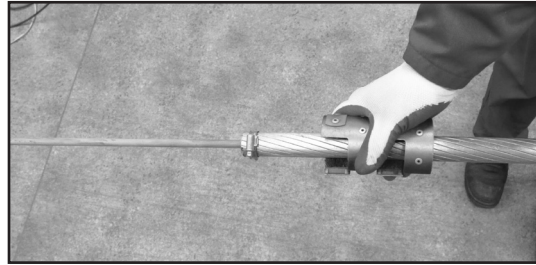


**PLP TIP:** To prevent damage to the composite core and speed installation, PLP recommends using a conductor trimming tool.

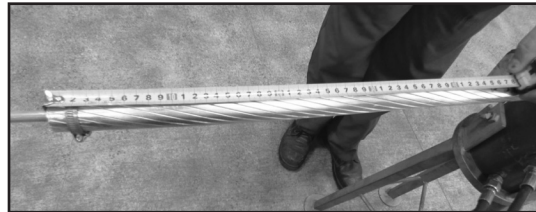
**Step #4** With a clean cloth, wipe the outer surface of the core to remove any oil or residue. Use the provided 220 mesh sanding paper to rub the core lightly until it becomes white. Rewipe the core with a clean cloth.



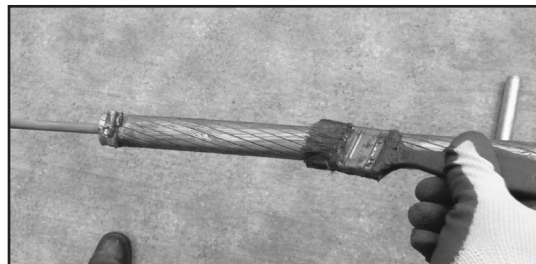
**Step #5** Clean/wire-brush the entire aluminum area to be covered by the compression hardware per your standard company practices. Ensure that no residue or surface particles remain.



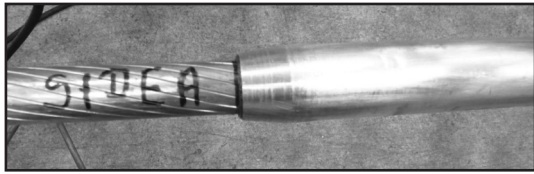
**Step #6** Mark the conductor on Side A with the Filler Tube length plus 3/8" (10 mm) from the end of the aluminum strands.



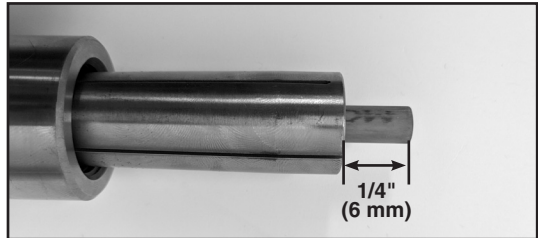
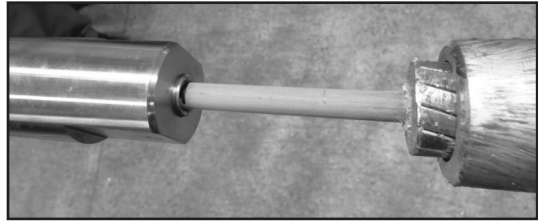
**Step #7** Apply the supplied oxide inhibitor along the length of the wire brushed aluminum strands, up to the mark made in Step #6.



**Step #8** With the tapered end of the inner sleeve facing the end of the conductor, slide each inner sleeve down the conductor. Slide the Side A inner sleeve to the mark made in Step #6.



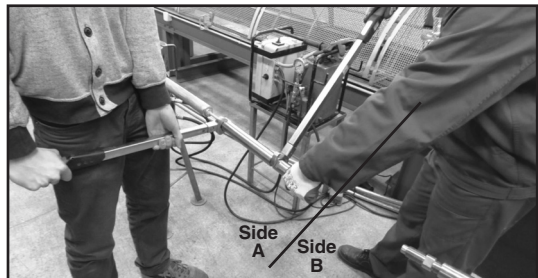
**Step #11** With wrench flats facing the conductor, slide both collet housings onto the core. Install the collets (narrow end toward the housing) onto the core until the edge meets the marks. The core must be exposed 1/4" (6 mm) through the back of the collet.



**Step #9** Apply oxide inhibitor to the outer surface of both inner aluminum sleeves, excluding the tapered sections.



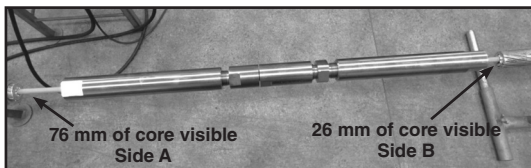
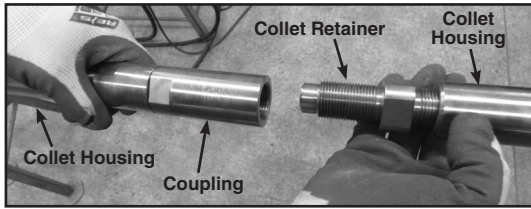
**Step #12** Install the coupling hardware on Side A and the collet retainer on Side B and tighten by hand. Use a torque wrench to fully tighten the coupling hardware and coupling retainer to a minimum of 85 ft-lb (115 Nm).



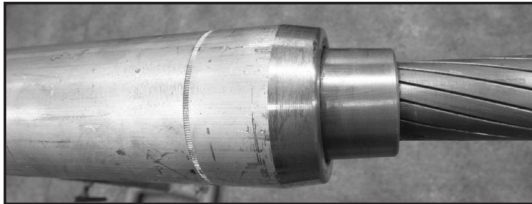
**Step #10** Slide the filler tube on Side B down the conductor so it is able to slide onto the outer tube. Slide the outer tube over the conductor on Side B.

**NOTE:** Do not slide the outer aluminum tube past the filler tube.

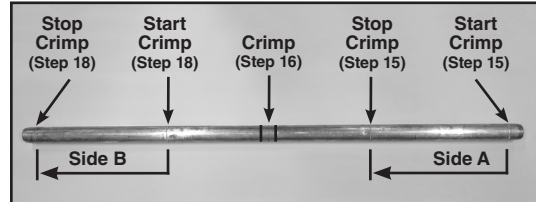
**Step #13** Bring the two sides together and hand-tighten the swivel end of the coupling to the collet retainer. Use a torque wrench to fully tighten to a minimum of 85 ft-lb (115 Nm).



**Step #14** Slide the outer sleeve over the coupling assembly. Position the outer sleeve on the Side A inner sleeve until 1" (25 mm) of filler tube is sticking out or it is stopped by the indent.

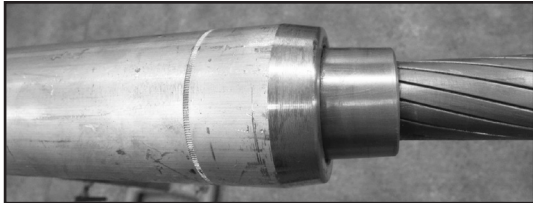


**Step #15** Install the corresponding die into the press. With the outer sleeve in place, compress the outer sleeve beginning at the Side A starting crimp point, moving inwards toward the end of the compression zone on Side A. Slightly overlap the crimps to ensure complete compression.

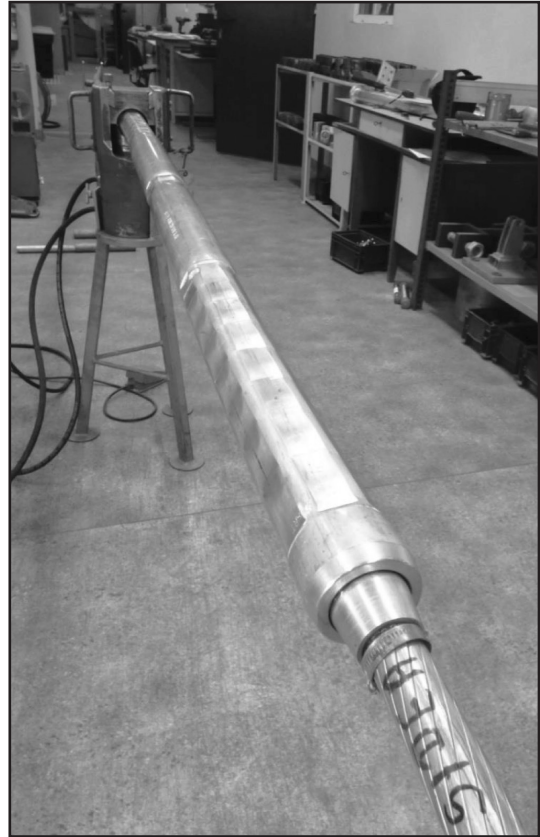


**Step #16** Compress the center of the outer tube to the coupling assembly with one crimp.

**Step #17** Slide the inner tube on Side B into the outer tube until 1" (25 mm) of filler tube is sticking out or until it is stopped by the indent.



**Step #18** Starting at the inside mark and compressing outwards, compress Side B until the end crimp point. Overlap the crimps to ensure complete compression.







## SAFETY CONSIDERATIONS

This application procedure is not intended to supersede any company construction or safety standards. This procedure is offered only to illustrate safe application for the individual. **FAILURE TO FOLLOW THESE PROCEDURES MAY RESULT IN PERSONAL INJURY OR DEATH.**

This product is intended for a single (one time) use and for the specified application.  
**Do not reuse or modify this product under any circumstances.**

This product is intended for use by trained technicians only. **This product should not be used by anyone who is not familiar with, and not trained to use it.**

When working in the area of energized lines, extra care should be taken to prevent accidental electrical contact.

For proper performance and personal safety, be sure to select the proper size PREFORMED product before application.

PREFORMED products are precision devices. To ensure proper performance, they should be stored in cartons under cover and handled carefully.



# PREFORMED LINE PRODUCTS

P.O. Box 91129, Cleveland, Ohio 44101 • 440.461.5200 • [preformed.com](http://preformed.com) • email: [inquiries@preformed.com](mailto:inquiries@preformed.com)

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