



Compression Dead-End and Jumper Assembly for ACFR conductor

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

Supplied parts in Kit

- A. Aluminum outer tube with terminal pad
- B. Steel Eye
- C. Aluminum inner sleeve
- D. Washer
- E. 150 ml Grease (not shown)

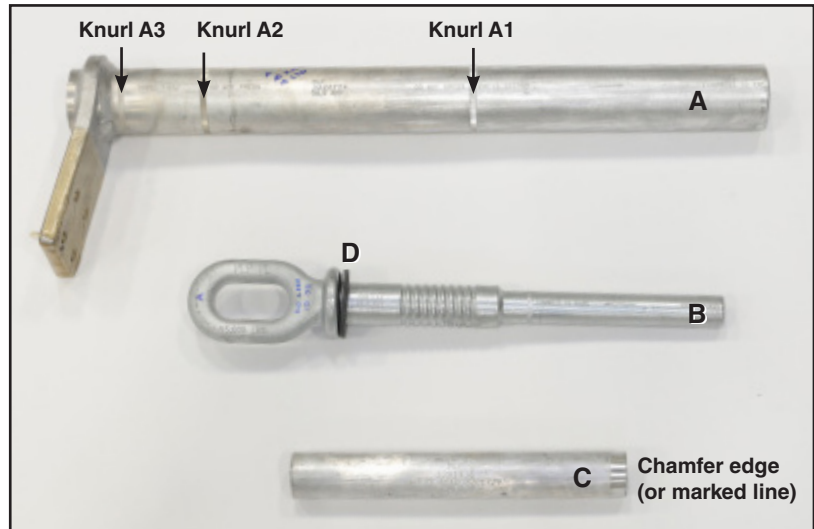


Chart A - Compression Die Information

Conductor	Compression Die for Aluminum Components	Compression Die for Steel Components
ACFR 182/28-FA-TT	43.0 A/F	24.5 A/F
ACFR 237/37-FA-TT		25.4 A/F
ACFR 245/37-FA-RR		24.6 A/F
ACFR 267/37-FA-TT		25.4 A/F
ACFR 281/37-FA-TT		
ACFR 302/37-FA-RR		
ACFR 312/37-FA-TT		
ACFR 325/37-FA-TT		56.5 A/F
ACFR 470/56-FA-TT		
ACFR 492/56-FA-TT		
ACFR 540/56-FA-TTT		
ACFR 679/56-FA-TTT		
ACFR 665/71-FA-TTT		

Step #1

Measure and mark 203 mm (8") from the end of the conductor. Apply tape just past the mark to secure outer strands during the cutting procedure in Step 2.



Step #2

Using a conductor cutting tool, remove the outer strands of aluminum up to the 203 mm (8") mark. The innermost layer of aluminum strands should not be removed, but it is acceptable if these are scored by the cutting tool.



Step #3 Measure and mark 178 mm (7") from the end of the conductor, and from the end of the steel eye.



Step #4 With the aluminum inner sleeve held 9.5 mm (3/8") from the end of the outer aluminum strands, mark the length to the end on the conductor.



Step #5 Using a wire brush, clean the conductor up to the mark made in the previous step. Apply the supplied grease evenly to this entire area.



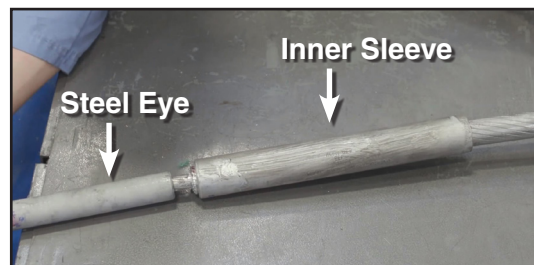
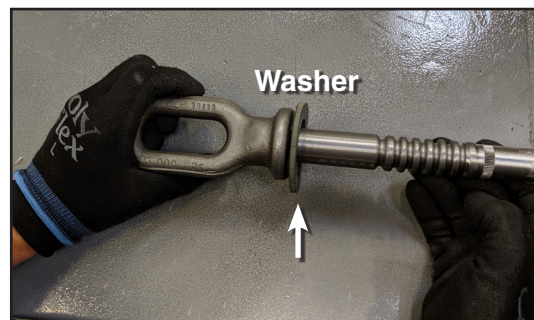
Step #6 Slide the aluminum outer tube onto the conductor, past the mark made in Step 4. The terminal pad should be oriented towards the end of the conductor.



Step #7 With the tapered end facing the conductor, slide the inner sleeve up to the mark made in Step 4. Then clean the sleeve and apply grease evenly to the outer surface.



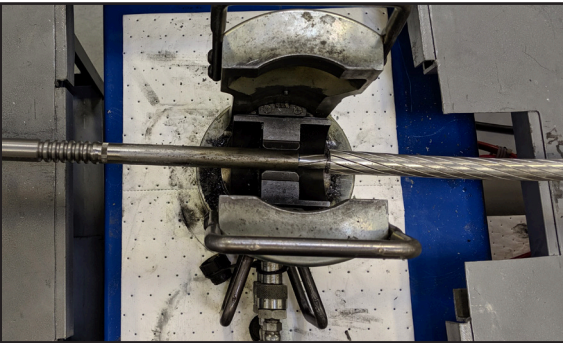
Step #8 Slide the steel eye with the washer onto the conductor up to the 178 mm (7") mark made in Step 3 as shown below.



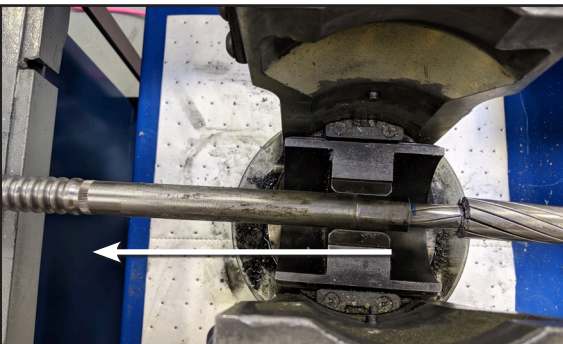
Step #9 Install the appropriate compression die (see Chart A) for the steel eye in a 60-ton or 100-ton press. Lubricate the dies and the area of the steel eye to be compressed.



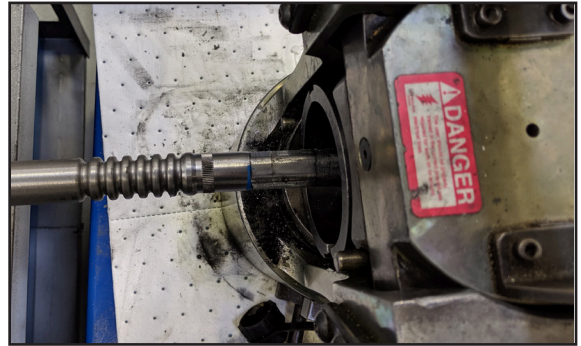
Step #10 Align the end of the steel eye with the chamfer in the compression die and ensure that the eye is straight within the die and level with it. Do not push or pull on the eye while compressing.



Step #11 Begin compressions at the end of the steel eye and continue up to the stop mark made at 178 mm (7"). Recommended overlap between compressions is 50% in order to avoid curvature of the tube.

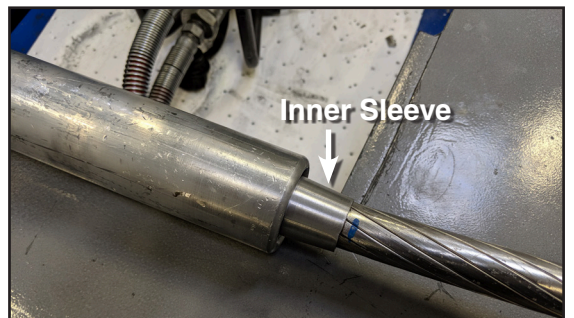
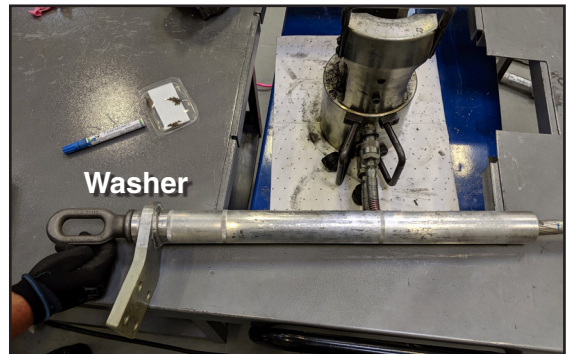


Step #11 (continued)



Step #12 Check the A/F (across the flats) measurement to confirm correct compression (example 260SH100 has an A/F of 26.0 mm).

Step #13 Slide the outer tube towards the end of the conductor until it compresses the washer to the steel eye. Realign the inner sleeve with the mark made on the conductor if necessary.



Step #14 Install the appropriate compression die (see Chart A) for the outer tube in the press. Lubricate the dies and areas of the tube to be compressed.

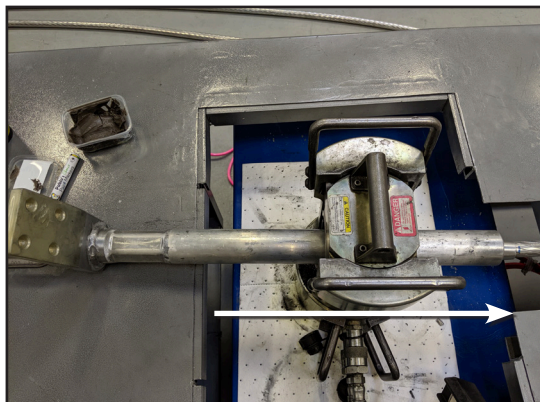
Step #15 Ensuring that the outer tube is straight within the die and level with it, make one compression between knurl marks A2 and A3 near the terminal pad



Step #16 Installation of the dead-end assembly is complete.



Step #16 Continue compressions, starting at knurl mark A1 and working to the end of the outer tube. Recommended overlap between compressions is 50% in order to avoid curvature of the tube. Do not apply any load on the tube while compressing. Check the across the flats measurement (A/F) to confirm correct compression (example 565AH100 has an A/F of 56.5 mm).

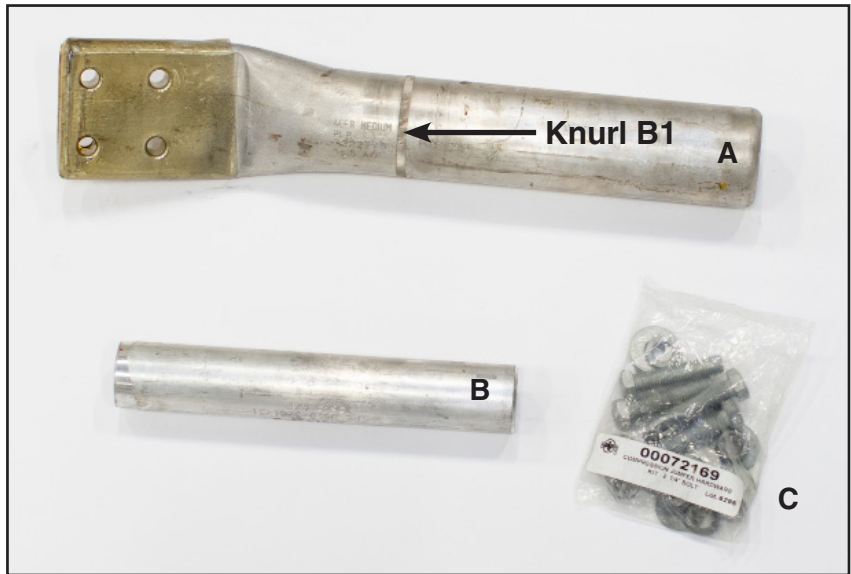


Assembly for ACFR conductor

Be sure to read and completely understand this procedure before applying product.
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Supplied parts in

- A. Outer tube with terminal pad
- B. Aluminum inner sleeve
- C. Fastener Kit
- D. 150 ml Grease (not shown)



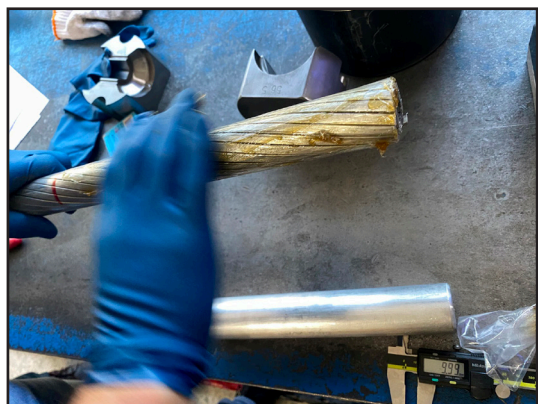
Step #1 Ensure that the Outer jumper tube and inner sleeve are not damaged and have nothing inside them.



Step #3 Apply grease to the area marked for the inner sleeve. Rub grease over the entire area. Using a wire brush, clean the conductor up to the mark.



Step #2 Place the inner sleeve against the conductor and mark filler tube length plus 10 mm.



Step #4 Slide the inner sleeve onto the conductor, chamfered edge first, up to the mark and grease the outside of sleeve.



Step #5 Slide the Outer Jumper body over the inner sleeve up to the chamfer.



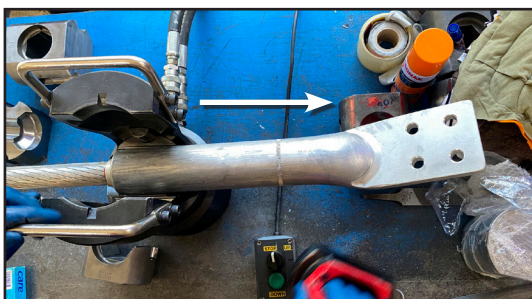
Step #7 Compress up to knurl B1 on the Outer Jumper tube overlapping each compression 50%.



Step #8 Repeat procedure on the other side of the jumper loop.



Step #6 Using the appropriate compression die (see Chart A) begin compression at the opening of the Outer Jumper tube.



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. Be sure to wear proper safety equipment per your company protocol.

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.



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