



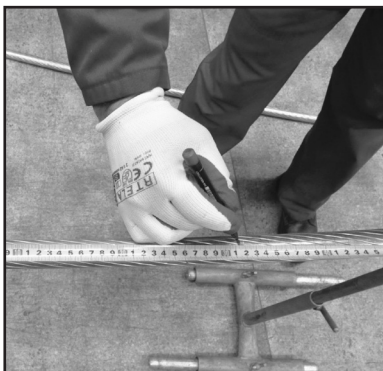
PLP Compression Dead-end and Jumper Terminal for ACCC® Conductors

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



USA ACCC Code Name	kcmil	International ACCC Code Name	mm ²	Outside Dia. Inches (mm)	Exposed core length Inches (mm)	Approx Eye Distance Inches (mm)
--	--	Skadar	79.3	0.523 (13.2842)	9.05 (230)	1.97 (50)
--	--	Rijeka	112.4	0.535 (13.589)	9.05 (230)	1.97 (50)
--	--	Silvassa	122.7	0.565 (14.351)	9.05 (230)	1.97 (50)
Pasadena	--	Helsinki	150.6	0.616 (15.6464)	9.05 (230)	1.97 (50)
--	--	Jaipur	155.7	0.65 (16.51)	9.05 (230)	1.97 (50)
--	--	Zadar	177.4	0.673 (17.0942)	9.05 (230)	1.97 (50)
--	--	Rovinj	187.8	0.673 (17.0942)	9.05 (230)	1.97 (50)
Ocenside	383.2	--	--	0.68 (17.272)	9.05 (230)	1.97 (50)
Linnet	430.5	Copenhagen	219.9	0.72 (18.288)	9.05 (230)	1.97 (50)
Oriole	438.6	Reykjavik	223.1	0.741 (18.8214)	9.05 (230)	1.97 (50)
--	--	Gdansk	248.8	0.756 (19.2024)	9.05 (230)	1.97 (50)
Waco	454.0	Glasgow	236.7	0.77 (19.558)	9.05 (230)	1.97 (50)
Laredo	529.8	Casablanca	273.6	0.807 (20.4978)	9.05 (230)	1.97 (50)
Hawk	611.3	Lisbon	315.5	0.858 (21.7932)	9.05 (230)	1.97 (50)
Dove	713.5	Amsterdam	367.4	0.927 (23.5458)	9.05 (230)	1.97 (50)
--	--	Cordoba	399.4	0.961 (24.4094)	9.05 (230)	1.97 (50)
Amarillo	784.7	Lieipzig	406.4	0.99 (25.146)	9.05 (230)	1.97 (50)
Grosbeak	821.4	Brussels	421.4	0.99 (25.146)	9.05 (230)	1.97 (50)
--	--	Monte Carlo	228.5	1.04 (26.416)	12.40 (315)	1.57 (40)
Irving	609.5	Oslo	313.8	1.04 (26.416)	12.40 (315)	1.57 (40)
Lubbock	903.9	Stockholm	453.7/ 463.3	1.04 (26.416)	12.40 (315)	1.57 (40)
Galveston	1011.3	Warsaw	507.5	1.09 (27.686)	12.40 (315)	1.57 (40)
Drake	1025.6	Dublin	524.5	1.108 (28.1432)	12.40 (315)	1.57 (40)
--	--	Kolkata	543.5	1.127 (28.6258)	12.40 (315)	1.57 (40)
Curlew	1033.0	Mahakam	544.9	1.14 (28.956)	12.40 (315)	1.57 (40)
Plano	1059.5	Hamburg	546.5	1.127 (28.6258)	12.40 (315)	1.57 (40)
Corpus Christi	1103.0	Milan	567.7	1.146 (29.1084)	12.40 (315)	1.57 (40)
Arlington	1151.1	Rome	592.5	1.177 (29.8958)	12.40 (315)	1.57 (40)
Cardinal	1221.8	Vienna	629.2	1.198 (30.4292)	12.40 (315)	1.57 (40)
Forth Worth	1300.4	Budapest	668.3	1.24 (31.496)	12.40 (315)	1.57 (40)
--	--	Mumbia	685.4	1.251 (31.7754)	12.40 (315)	1.57 (40)
El Paso	1349.9	Prague	690.7	1.251 (31.7754)	12.40 (315)	1.57 (40)
Beaumont	1427.6	Dhaka	723.9	1.294 (32.8676)	12.40 (315)	1.57 (40)
--	--	Munich	733.2	1.293 (32.8422)	12.40 (315)	1.57 (40)
--	--	Warwick	749.5	1.315 (33.401)	12.40 (315)	1.57 (40)
San Antonio	1474.9	London	759.0	1.315 (33.401)	12.40 (315)	1.57 (40)
Bittern	1581.6	Paris	813.7	1.345 (34.163)	12.40 (315)	1.57 (40)
--	--	Bordeaux	880.9	1.408 (35.7632)	12.40 (315)	1.57 (40)
Dallas	1794.9	Antwerp	944.9	1.452 (36.8808)	12.40 (315)	1.57 (40)
Houston	1927.4	Berlin	1006.6	1.504 (38.2016)	12.40 (315)	1.57 (40)
Lapwing	1948.9	Madrid	1013.1	1.506 (38.2524)	12.40 (315)	1.57 (40)
Falcon	2045.1	--	--	1.545 (39.243)	12.40 (315)	1.57 (40)
Chuckar	2241.5	--	--	1.604 (40.7416)	12.40 (315)	1.57 (40)
Bluebird	2740.6	Athens	1409.8	1.762 (44.7548)	12.40 (315)	1.57 (40)

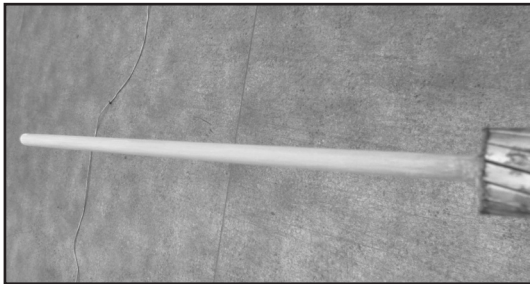
Step #1 Starting from the end, measure and mark the conductor according to the "Exposed Core Length" column in the provided table.



Step #2 Apply tape approximately 1" (25 mm) back from the mark to secure the aluminum strands and maintain the conductor diameter after the cut is made.

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

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

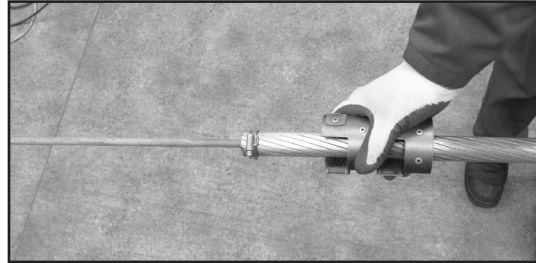


PLP TIP: To ensure no damage to the composite core and rapid installation, PLP recommends the use of a conductor trimming tool.

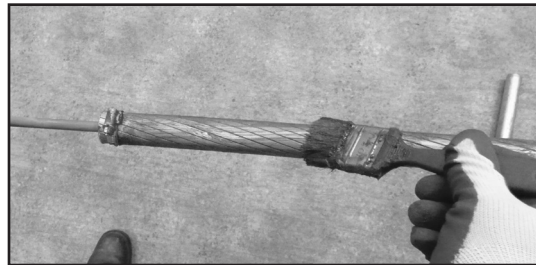
Step #4 Wipe the outer surface of the core clean and free of oil with a clean cloth. Use the provided 220 mesh sanding paper to rub the core lightly until it becomes white. Rewipe the core with a clean cloth.



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



Step #6 Apply the supplied oxide inhibitor along the length of the wire brushed aluminum strands.



Step #7 With the tapered end of the inner aluminum sleeve facing the end of the conductor, slide it approximately 3 ft (1 meter) down the conductor.



Step #8 Apply the oxide inhibitor to the outer surface of the inner aluminum sleeve, excluding the tapered section.



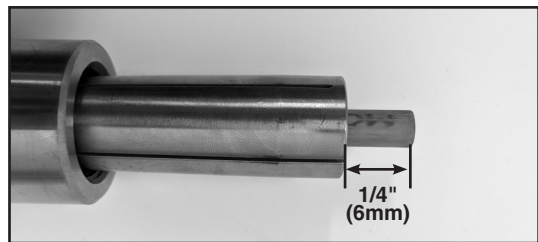
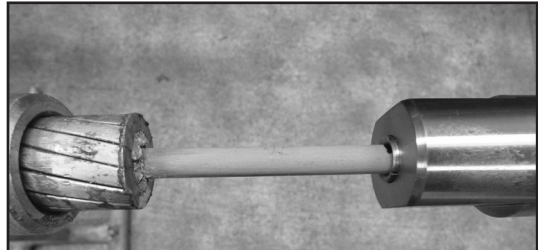
Step #9 Slide the outer aluminum dead-end sleeve over the ACCC conductor toward the inner aluminum sleeve.

NOTE: Do not slide the outer aluminum tube past the inner aluminum sleeve.

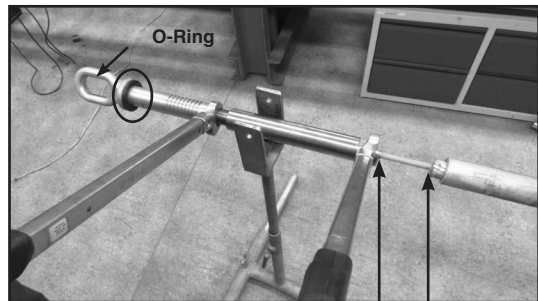
Step #10 Using a felt tip marker, make a mark on the core 3" (76 mm) from the end of the aluminum strands)



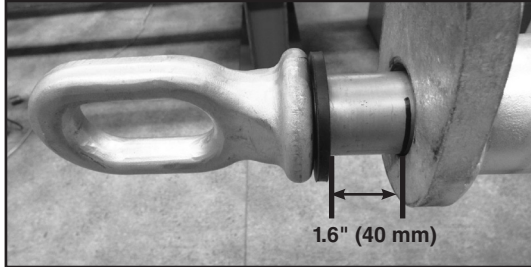
Step #11 Slide the collet housing, with the wrench flats facing the conductor, onto the core. Install the collet, with the narrow end facing the housing, onto the core until the edge reaches the 3" (76 mm) marking. 1/4" (6 mm) of the core must be exposed through the back of the collet.



Step #12 Ensure that the rubber o-ring is installed onto the dead-end eye. Install the dead-end eye hand tight then use a torque wrench to fully tighten to a minimum of 85 ft-lb (115 Nm). Check the location of the collet and ensure that approximately 3" (76 mm) of the core is exposed. Avoid skewing the conductor core to prevent damage.

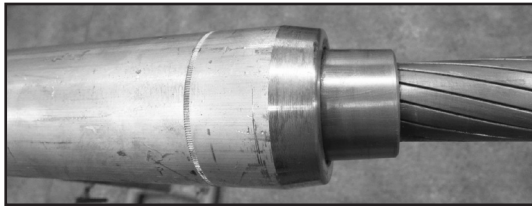


Step #13 Slide the aluminum outer sleeve towards the eye, lining up the edge of the pad with the mark on the steel eye. If no mark is present, offset the dead-end eye to dimension in table in step #1 column Eye Distance.

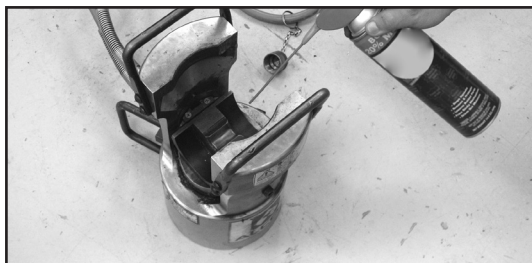


NOTE: This distance can vary ± 0.20 " (5mm), installer may adjust after first compression is complete

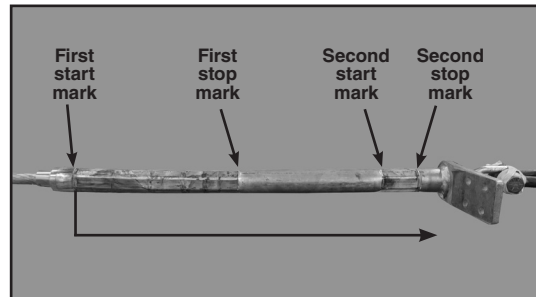
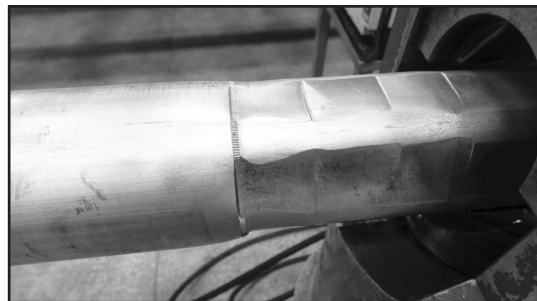
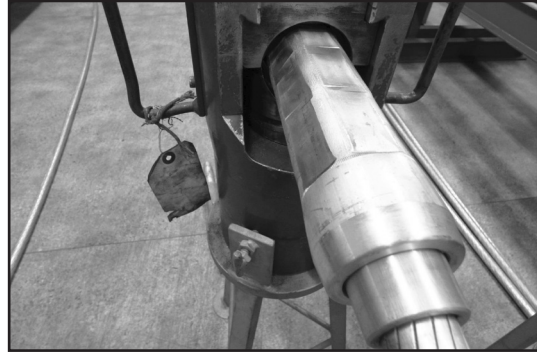
Step #14 Position the inner aluminum sleeve so that 1" (25mm) is stick out or is stopped by the indent in the outer aluminum tube.



Step #15 Ensure that the compression die surfaces are clean and have no burrs. **This is the most critical factor in applying proper compressions.** If it assists the application, lubricate the compression dies with desired lubricant to ensure that the dies slide easily together and that the fitting hardware material slides underneath the dies.



Step #16 Begin compressing on the outer aluminum tube at the opposite end of the eye, making sure that the correct die size is being used. Slightly overlap crimps in the direction of the eye to ensure complete compression. Continue to compress until the compressions meet the stop mark on the outer aluminum tube.



NOTE: If aluminum tube is touching the seal before reaching the First stop mark then stop compression and move to step #17.

Step #17 Start second compression at Second start mark (as shown in Step#16) and compress towards steel eye. Compress until the o-ring is flush with the pad. If the seal is not compressed when you reach the Second stop mark then continue making overlapping compressions until seal is compressed. Do not over compress and damage the o-ring. This should require 1-1/2 to 3 overlapping compressions to fully secure the dead-end.



Compression Dead-end Jumpers for ACCC® Conductors

Step #1 Clean / wire brush the entire aluminum area to be covered by the compression hardware (at least the length of the jumper inner aluminum sleeve) per your standard company practices. Check that no residue or surface particles remain.



Step #2 Apply the supplied oxide inhibitor along the length of the wire brushed aluminum strands.



Step #3 Use the supplied 220 grit sandpaper to lightly sand the outside of the inner aluminum sleeve.



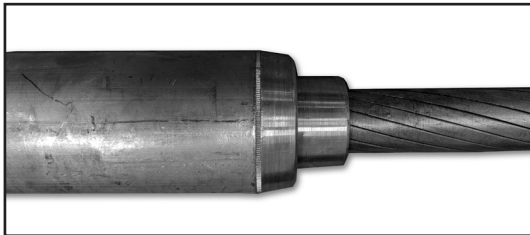
Step #4 With the tapered end of the inner aluminum sleeve facing the end of the conductor, slide it down until the non-tapered end lines up with the end of the conductor.



Step #5 Apply the supplied oxide inhibitor to the non-tapered portion of the aluminum inner sleeve.

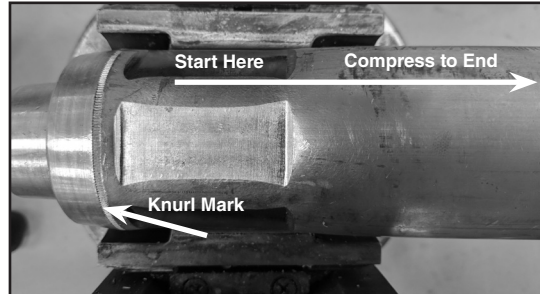


Step #6 Slide the jumper onto the inner aluminum sleeve such that 1" of the inner aluminum sleeve is sticking out.

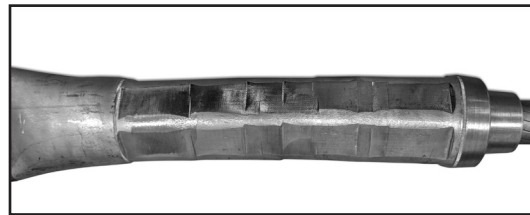


Step #7 Ensure that the compression die surfaces are clean and have no burrs. This is the most critical factor in applying proper compressions. If it assists the application, lubricate the compression dies with desired lubricant to ensure that the dies slide easily together and that the fitting hardware material slides underneath the dies.

Step #8 Begin compression on the outer aluminum tube inside the knurl mark on the opposite end of the jumper pad. Slightly overlap the crimps in the direction of the jumper pad to ensure complete compression.



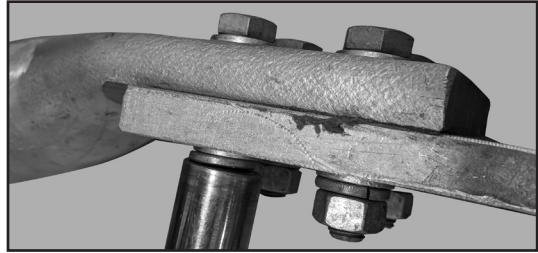
Step #9 Continue to compress until the compressions meet the inside of the knurl mark closest to the jumper pad.



Step #10 Ensure that the pad connections on the jumper and dead-end are free from damage, and that all protective wax and any residue has been removed.



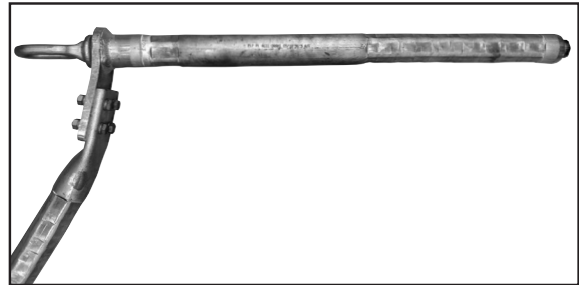
Step #12 To install the jumper terminal pad to the compression dead-end pad and complete the full dead-end assembly, insert a flat washer onto each bolt and thread through the pads. On the opposite end, apply the other flat washer, then lockwasher, then nut, and hand tighten. Once tight, torque bolts to 40 ft-lbs, revisiting each bolt several times to ensure that the pad is fully compressed and that all bolts are tightened to the proper specification.



Step #11 Coat the dead-end terminal pad with conductive electrical joint compound. Spread the compound evenly over the pad, ensuring total coverage.



Completed application.



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.



PREFORMED LINE PRODUCTS

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