

SWAGING USER INSTRUCTIONS

EQUIPMENT

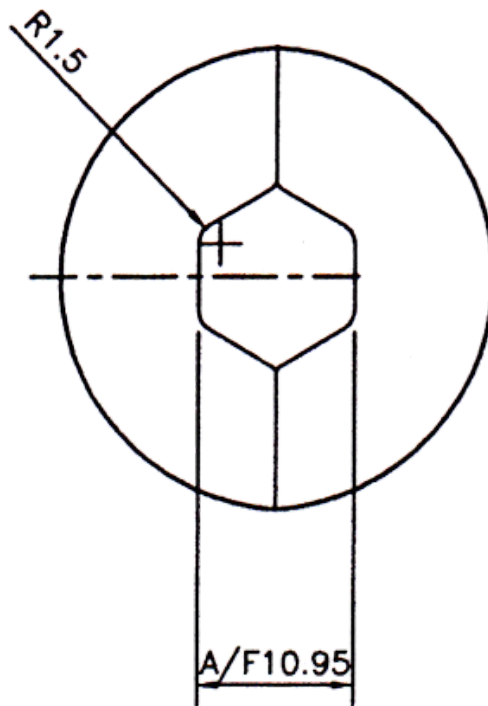
Swaging Tool

- The swaging Tool is the most important equipment to ensure a robust swage. Swaging must be performed by a hydraulic swaging tool capable of providing a force of 120kN.

Note: Please use the right swaging tool.

Hex Loc Die

- Selection of the right size of Hex loc Die is critical. Ensure that the hex loc Die has dimensions as in the Fig. 1



Note 1: The size of the Die available on the market nearest to the recommended size in Fig. 1 is 50mm²

Note 2: Inspect for wear and tear of the dies before each swaging. Replace the dies if the edges are rounded.

Process:

- Insert the cable into the swage tube. Mark the cable by a marker at the edge of the swage tube. Pull the cable out of the swage tube and check if the cable had been inserted fully, by placing the cable over the swage tube.
- Insert the cable in the tube again, until the edge of the swage tube coincides with the marking on the cable. We now know that the cable has been fully inserted in the swage tube.
- The swage tube is marked to identify exact positions of swaging.
- Place the swage tube on the hex loc die of the hydraulic swaging tool. See Fig. 2

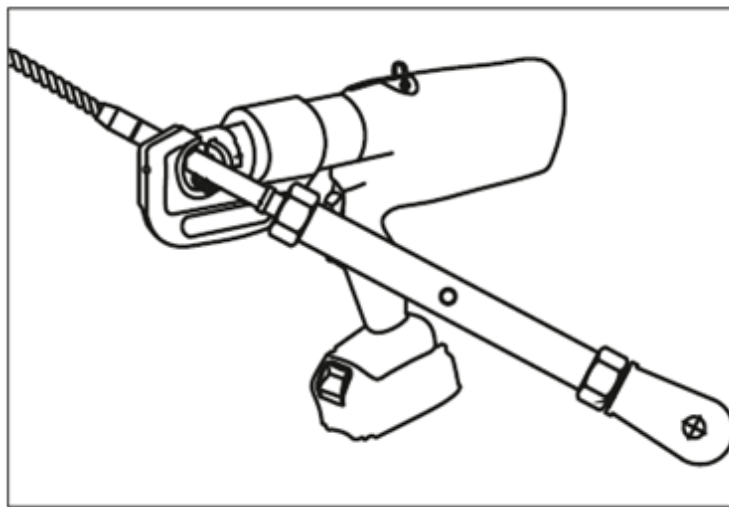


Fig: 1

- While placing the swage tube on the hex loc die, ensure that the mark on the swage tube is in the center of the die.
- Set the hydraulic swaging tool to 120kN force.
- Apply a slight force on the swage by pressing the switch of the swaging tool and releasing it to ensure that the swaging has started and the swage is placed in the right position. Now press the switch again to provide the required 120 kN Pressure. Continue pressing the switch until the green light is on, to indicate that the 120kN force has been achieved.
- Repeat the process for all markings. Rotate the Swage at 90 degrees after each swaging to ensure that the tube does not bend.
- To ensure that the tube does not bend the following sequence of swaging may be followed as good practice.
1st swage: Top
2nd swage: Bottom
3rd & 4th swage: Middle
5th and 6th swage: Remaining swage
- Check the tube after each swaging for any signs of bending. Decrease/increase rotation of the tube if required to offset the bend due to previous swaging.