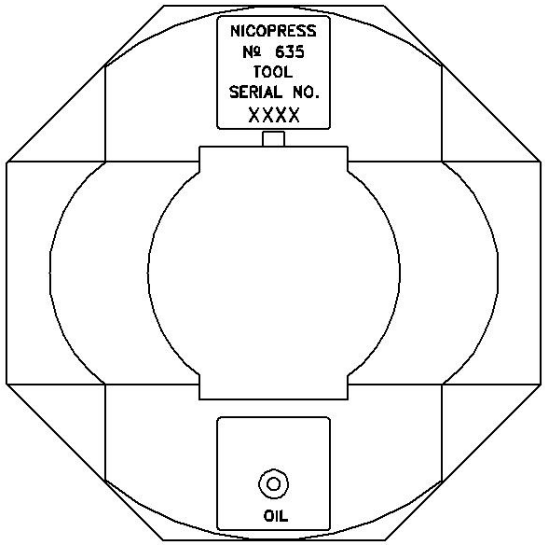
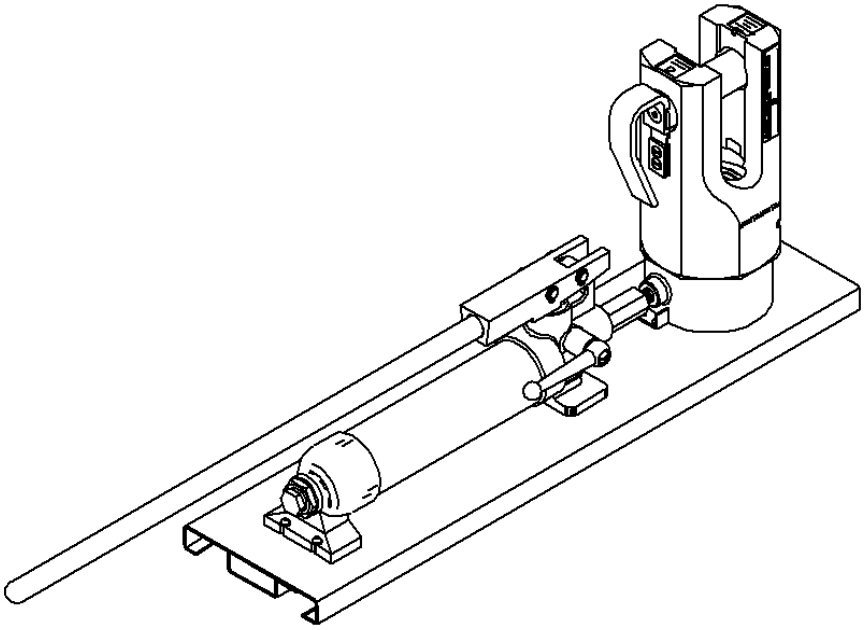
NICOPRESS®

No. 635 Hydraulic Tool



NOTE: Please be sure to make note of the Serial Number, which is stamped on the top of the HEAD. When writing to us, be sure to mention this number.



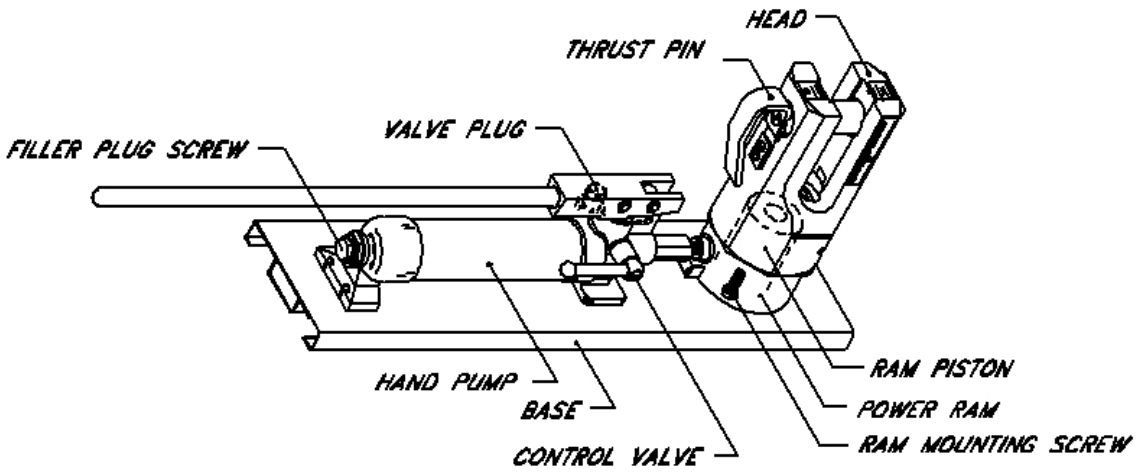
I. CARE AND USE OF THE EQUIPMENT

CAUTION – SAFETY FIRST

High pressure hydraulic equipment can be dangerous if not properly used. It is important that **ONLY** persons fully familiar with the proper use and care of the No. 635 TOOL and the No. 635A Compressor should operate them.

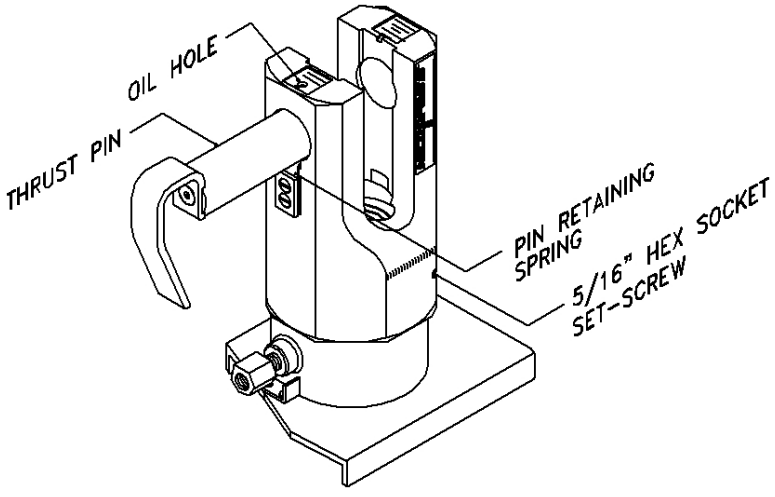
NEVER OPERATE the Tool without the **THRUST PIN ALL THE WAY In and A SET OF DIES INSTALLED IN THE TOOL**. (Note: The Thrust Pin Handle is designed to prevent operation of the No. 635 Tool pump except when the thrust pin is all the way in.)

DO NOT OPERATE EITHER TOOL OR COMPRESSOR WITHOUT DIES IN PLACE



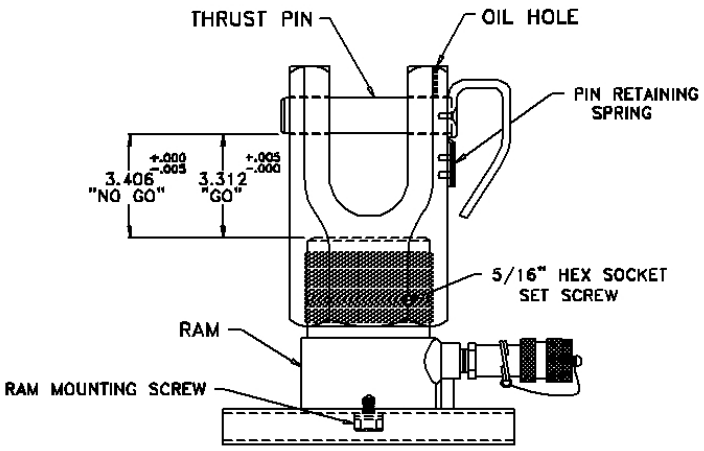
The No. 635 Tool is shown in the illustration above. The No. 635A Compressor has the same power ram and head and uses the same dies as the No. 635 but must be connected to a separate power or hand operated pump of proper capacity using the non-metallic hose and quick disconnects furnished. Any pump used with the No. 635A should have its cutoff valve set at 9,200 psi to provide safely for the 35 ton capacity of the tool.

- **NOTE**:Whenever the hand pump supplied with the No. 635 Tool or the separate hydraulic pump used with the No. 635A compressor are torn down for maintenance, the output pressure must be checked and reset as required. A 10,000 p.s.i. hydraulic pressure gauge should be connected to the pump output port. Operate the pump until pressure builds up and the overload valve unloads. Proper setting for the pump is 9,200 p.s.i. Adjust the overload valve as required to reach this setting.



To clean the top of the ram piston, remove the Compressor head by loosening the 5/16" set screw in the side of the head and unscrewing the head from the power ram section. The threads on the head and ram should be cleaned while the Compressor head is removed. Be careful not to lose the soft copper shoe which is beneath the socket set screw. To reassemble, screw the head back onto the power ram. Position the ram so that the distance between the bottom of the Thrust Pin and the top of the fully retracted ram matches the distance shown on the sketch. If this distance is not set correctly, the ram piston could rise too high and bear against the cylinder head causing internal damage. If working with the No. 635 tool, position the Thrust Pin handle so that it is directly over the pump handle. If working with the No. 635A tool, position the handle in any convenient position. **BE SURE TO TIGHTEN THE HEX SOCKET SET SCREW** to lock the head in position.

GAUGING LIMITS BETWEEN RAM AND THRUST PIN.
WITH HEAD PROPERLY INSTALLED ON RAM.



VERTICAL DISTANCE FROM TOP OF FULLY RETRACTED RAM
TO BOTTOM FLAT OF FULLY INSERTED THRUST PIN.

ADDING FLUID

To add fluid to the No. 635 tool, open the release valve, allowing the ram to retract all the way down. If necessary, force the ram down.

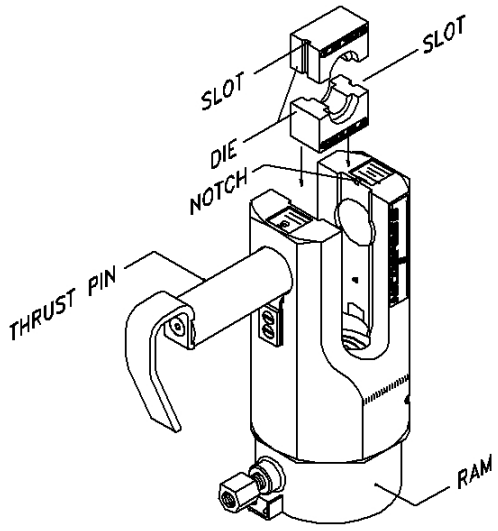
Upend the tool as shown in the sketch. Remove the filler plug screw. The oil reservoir is full when the fluid level falls between the indicated marks.

If necessary, add fluid, being careful to prevent dirt from getting into the pump. Use only Enerpac HF-101 hydraulic oil or equivalent. Replace the filler plug screw and tighten it securely.

With a No. 635A tool equipped with a power pump, add fluid as needed directly to the pump reservoir.

If the ram piston does not fully retract when the valve is open, the pump may be air bound. To correct this, install a set of dies in the tool. Close the control valve and operate the pump until the die set is closed. Upend the tool as shown in the sketch (pg. 3) and open the control valve to allow the ram to retract. If necessary, force the ram to fully retract. If necessary, repeat the above procedure.

Never hammer against the Tool head. The Thrust Pin should move back and forth easily. If is does not, it should be removed to clean and oil it. To remove this pin, it is necessary to rotate it to one side about a half turn before it can be pulled out freely



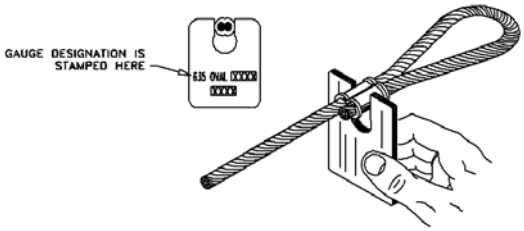
DIES

Each half of the sleeve pressing die has a slot in one end. In the case of the bottom half, the slot should line up with the notch in the Tool head as shown in the picture. This will allow the die to fall all the way down and rest against the top of the ram piston. Have the slot in the top half lined up opposite the slot in the bottom die half. This will allow the small pin in the die-guiding groove of the Tool head to support the upper die half and prevent it from contacting the lower die half when the ram is retracted. Separating the die halves in this manner facilitates the sleeve pressing operation.

SLEEVE PRESSING GAUGE

The dies involved in splicing flexible steel cables and wire ropes are all designated "OVAL" dies, and each die is supplied with a sleeve-pressing gauge. Some of the dies for compressing aluminum oval sleeves onto fiber ropes do not have such gauges (see Page 9). In general, the dies involved in splicing and dead-ending electric cables and non-flexible strands do not have sleeve-pressing gauges.

In any sleeve compression, operate the pump until the dies meet. Then pump a little more to make sure that the dies are completely closed. An automatic pressure-relief valve within the pump will prevent over-compressing. Where a sleeve-pressing gauge is provided, use it periodically to check the size of the compressions. The compressed portion of the sleeve should enter the gauge easily as shown.



After a splicing job has been completed, open the control valve and allow the ram plunger to retract all of the way down. This will prevent the tool from becoming air-bound.

When the tool is placed in storage, see that the ram-plunger is fully retracted to prevent the tool from becoming air-bound. Then stand it on end to keep the ram packing from drying out. If, at any time, the hydraulic tool does not operate satisfactorily, **RETURN IT TO US** for repairs or adjustments. We have the special tools, spare parts and know-how to do the job speedily and at minimum cost.

If you have facilities and the qualified personnel available to do your own repairs, we can furnish any parts needed. A replacement parts list is available upon request.

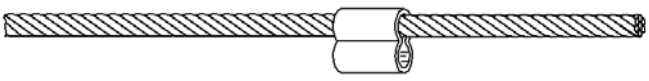
II. INSTRUCTIONS FOR SPLICING FLEXIBLE STEEL CABLE, WIRE ROPE & FIBER ROPE

These instructions cover the use of ***NICOPRESS***® Oval Sleeves with cable made to military specifications MIL-W-83420 .

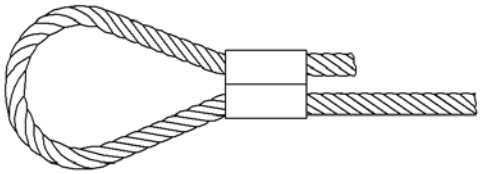
NICOPRESS® Oval Sleeves may also be used on wire ropes or cable of other constructions. Because of the variations in strength, grades, construction and actual diameters, splices should be proof tested initially on the specific cable being used. This is to insure the proper selection of materials, the correct pressing procedure, and the assurance of an adequate margin of safety for the intended use.

Before making a splice, be sure you have the correct dies for the particular size of sleeve to be pressed.

When making an eye or loop splice, first insert the cable into the sleeve:



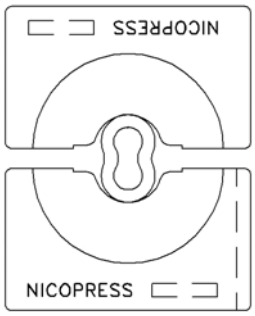
Bend the cable back on itself, making a large loop, and push the cable end back into the sleeve:



NICOPRESS® No. 2498 Cable Cutter Die is recommended for use in the No. 635 Tool and the No. 635A Compressor for clean, fast cutting.

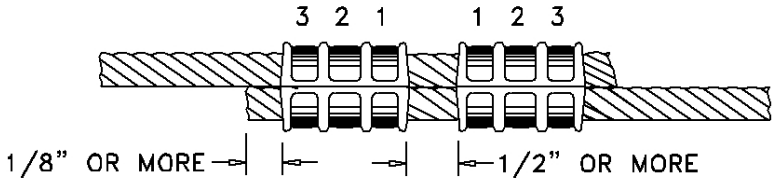
Always have cable-end project beyond the sleeve to insure that the cable in the sleeve is round and undistorted and also to care for the elongation of the sleeve which occurs when pressing it. Where permissible, have the cable project beyond the sleeve after is is compressed.

1.Place the sleeve in the groove of the bottom die.
2.Insert the top die.
3.Center the sleeve in the die grooves, as shown:



Next, push the thrust-pin **ALL THE WAY IN**. If it does not go in all the way, then open the control valve and allow the ram-plunger to retract sufficiently so that the thrust-pin will go **ALL THE WAY IN**. Close the control valve tightly, but do not hammer it shut. Operate the pump to close the dies and make the compression. Make the number of compressions that are called for in the tables that follow.

LAP or **RUNNING** splices can also be made with ***NICOPRESS***® Oval Sleeves when lengthening a cable or in making grommet slings. The same sleeves and dies are used, and the same number of presses are required, as in making an eye-splice. However, it is necessary to use **TWO (2)** sleeves per splice to equal the strength of a ONE (1) sleeve eye-splice.



NICOPRESS® *Copper, Aluminum & Stainless Steel Oval Sleeves* for Flexible Cable and Wire Rope

NICOPRESS® Copper Oval Sleeves							
NICOPRESS® Oval Sleeves				*NICOPRESS*® #635 Hydraulic Tool Dies			
Cable Size	**Plain Copper Sleeve**	**Zinc Plated Copper Sleeve**	**Tin Plated Copper Sleeve**	**Die Stock No.**	**No. of Presses**	**635 Oval Gauge**	**Groove Designation**
3/64"	18-11-B4	28-11-B4	428-1.5-VB4	OVAL B4 DIE	1	3376	OVAL B4
1/16"	18-1-C	28-1-C	428-2-VC	OVAL C DIE	1	3376	OVAL C
3/32"	18-2-G	28-2-G	428-3-VG	OVAL G DIE	1	3376	OVAL G
1/8"	18-3-M	28-3-M	428-4-VM	OVAL M DIE	1	3376	OVAL M
5/32"	18-4-P	28-4-P	428-5-VP	OVAL P DIE	1	3376	OVAL P
3/16"	18-6-X	28-6-X	428-6-VX	OVAL X DIE	1	3375	OVAL X
7/32"	18-8-F2	28-8-F2	428-7-VF2	OVAL F2 DIE	1	3375	OVAL F2
1/4"	18-10-F6	28-10-F6	428-8-VF6	OVAL F6 DIE	1	3375	OVAL F6
5/16"	18-13-G9	28-13-G9	428-10-VG9	OVAL G9 DIE	1	3375	OVAL G9
3/8"	18-23-H5	28-23-H5	428-12-VH5	OVAL H5 DIE	1	3375	OVAL H5
7/16"	18-24-J8	28-24-J8	428-14-VJ8	OVAL J8 DIE	2	3375	OVAL J8
1/2"	18-25-K8	28-25-K8	428-16-VK8	OVAL K8 DIE	2	3376	OVAL K8
9/16"	18-27-M1	28-27-M1	428-18-VM1	OVAL M1 DIE	3	3376	OVAL M1
5/8"	18-28-N5	28-28-N5	428-20-VN5	OVAL N5 DIE	3	3376	OVAL N5

Nicopress® Aluminum Oval Sleeves					
Cable Size	**Aluminum Oval Sleeve**	*NICOPRESS*® 635 Hydraulic Tool Dies			
		Die Stock No.	**No. of Presses**	**635 Oval Gauge**	**Gauge Designation**
1/16"	188-2-VC	OVAL C DIE	1	3376	OVAL C
3/32"	188-3-VG	188-VG DIE	1	3376	OVAL G
1/8"	188-4-VM	188-VM DIE	1	3376	OVAL M
5/32"	188-5-VP	188-VP DIE	1	3376	OVAL P
3-16"	188-6-VX	188-VX DIE	1	3375	OVAL X
1/4"	188-8-VF6	188-F6 DIE	1	3375	OVAL F6
5/16"	188-10-VG92	VG92 DIE OVAL G9 DIE	2 1	3375	OVAL G9
3/8"	188-12-VH5	OVAL H5 DIE	2	3375	OVAL H5
7/16"	188-14-VK8	OVAL K8 DIE	2	3376	OVAL K8
1/2"	188-16-VM1	188-VM1 DIE OVAL M1 DIE	2 3	3376	OVAL M1

Nicopress® Stainless Steel Oval Sleeves					
Cable Size	Stainless Steel Oval Sleeve	***NICOPRESS*® 635 Hydraulic Tool Dies**			
		Die Stock No.	**No. of Presses**	**635 Oval Gauge**	**Groove Designation**
3/64"	168-1.5-VB4	OVAL B4 DIE	1	3376	OVAL B4
1/16"	168-2-VB4	OVAL B4 DIE	1	3376	OVAL B4
3/32"	168-3-VC	OVAL C DIE	1	3376	OVAL C
1/8"	168-4-VG	OVAL G DIE	1	3376	OVAL G
5/32"	168-5-VM	OVAL M DIE	1	3376	OVAL M
3/16"	168-6-VP	OVAL 168-6-VP DIE	1	3376	OVAL 168-6-VP
7/32"	168-7-VX	OVAL X DIE	1	3375	OVAL X
1/4"	168-8-VF2	OVAL F2 DIE	1	3375	OVAL F2
5/16”	168-10-F6	OVAL F6 DIE	2	3375	OVAL F6

Nicopress® Aluminum Oval Sleeves for Splicing Nylon or Dacron Rope

The sleeves may also be used on fiber ropes of other materials. Because of the variations in strength, grades, construction and actual diameters, splices should be proof tested initially on the specific rope being used. This is to insure the proper selection of materials, the correct pressing procedure and the assurance of an adequate margin of safety for the intended use.

Before making a splice be sure you have the correct dies for the particular size of sleeve to be pressed.

Nicopress® Aluminum Oval Sleeves					
Cable Size	Aluminum Oval Sleeve	***NICOPRESS*® 635 Hydraulic Tool Dies**			
		Die Stock No.	**No. of Presses**	**635 Oval Gauge**	**Groove Designation**
1/16"	1700-C	OVAL C DIE	1	3376	OVAL C
1/8"	1700-M	1700-M DIE	1	NONE	NONE
3/16"	1582-P	1582-P DIE	1	NONE	NONE
1/4"	1700-X	1700-X DIE	1	NONE	NONE
5/16"	1700-G3	1700-G3 DIE	1	1700-G3 GAUGE	
3/8"	1700-H5	1700-H5 DIE	2	1700-H5 GAUGE	
1/2"	1700-J8	1700-J8 DIE	2	1700-J8 GAUGE	

III. SPLICING AND DEAD-ENDING ELECTRICAL POWER CABLES AND NON-FLEXIBLE STRANDS

1.Select the proper sleeve and die for the particular conductor or strand to be spliced. See the tables for the various conductors on the pages which follow for specific information, including number of presses required.

2.Straighten the ends of the conductor or strand for a foot or more and remove burrs. For cable up to 5/8" diameter, we recommend using the ***Nicopress*®** No. 2498 Cable Cutter die in the No. 635 Tool and No. 635A Tool for clean, fast cutting.

Clean electrical conductors with a wire brush or other abrasive means to assure good conductivity. Some sleeves are prefilled with corrosion inhibiting compound. In the case of splices made with sleeves that do not have compound, it is good practice to coat the cable or strands themselves with such compound before inserting them into the sleeves. Splicing compound is available for this purpose.

Insert the cable or strand into the sleeve and push it until it hits the center stop. A mark or tape wrap made one half of the sleeve length from the conductor, or strands end, provides a positive check on the cable being fully inserted into the sleeve.

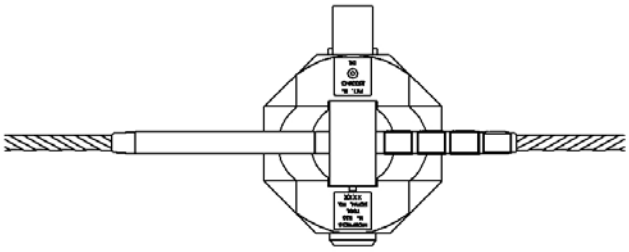
3.Place the bottom die half into the compressor. Have the slot in the end of the die line up with the notch in the tool head so that the die half will fall down all the way to the top of the ram plunger. Lay the sleeve (with the cable ends inserted) into the bottom die with the near edge of the die ¼" from the center mark on the sleeve. Drop the top half of the die over the sleeve. Have the slot in the top half lined up opposite the slot in the bottom die half.

Close the pump control valve and actuate the pump. Be sure to support the sleeve and cable so it is perpendicular to the sides of the die. Misalignment can cause a crooked splice.

Continue pumping until the dies completely close. Then pump a little more. An automatic pressure relief valve in the pump will prevent over-compressing.

4.After the press is completed, open the pump control valve to allow the ram piston to fully retract to the bottom. The sleeve can then be moved into position for the next press. Keep the sleeve aligned in the die each press to avoid a crooked splice. In general, space the presses about 1/8" apart, **progressing from the center to the ends**.

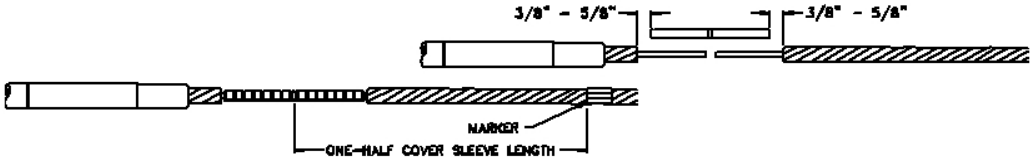
Most sleeves have either tapered or stepped-down diameter ends. Presses must always be made over the entire length of a sleeve, including the tapered or stepped ends (except the mid-section of ACSR Unit cover sleeves).



SPLICING ACSR WITH *NICOPRESS*® TWO-SLEEVE UNITS

1.Slip the aluminum sleeve over one conductor end, pushing it back enough to be out of the way. If filler sleeves are included, slip one over one cable end ahead of the aluminum cover sleeve and the other over the other conductor end.

2.Cut back all the aluminum strands of each conductor end a distance of 3/8" – 5/8" more than one-half the steel core sleeve length. Remove burrs from the ends of the steel core wires and insert the wires into the galvanized steel sleeve, pushing straight in until they hit the center stop inside the sleeve.



3.Place the proper die (see Table I) in the compressor head and press the sleeve, following the procedure outlined on page 10, **except** make the first press about 1/8" from the center mark. Table I lists the required number of presses.

4.Clean the aluminum strands thoroughly (new or old cable) with a wire brush or other abrasive means to insure good conductivity. Make a mark on one cable a distance of one-half the aluminum sleeve length from the center of the core sleeve with a piece of tape, or other means, to provide a positive guide for centering the aluminum sleeve over the steel core sleeve.

5.Apply a thorough coat of ***Nicopress***® zinc chromate splicing compound, or other approved splicing compound, over the entire length that will be covered by the aluminum cover sleeve. Slide the aluminum cover sleeve over the coated cable and core sleeve, taking care to align it with the mark to center it. If the splice unit includes filler sleeves, slip these inside the cover sleeve with the ends flush with the cover sleeve. Larger size cover sleeves are provided with two (2) holes for injecting inhibitor. After injecting inhibitor, hammer the plugs provided into the holes, peening over the hole edges to secure the plugs.

6.Press the cover sleeve following the general procedures on page 10. The midsection of the cover sleeve, marked by the 2 circumferential markers, bridges over the core sleeve and should not be pressed. Table I lists the proper die to be used and the required number of presses for all ***Nicopress***® ACSR Splice Units

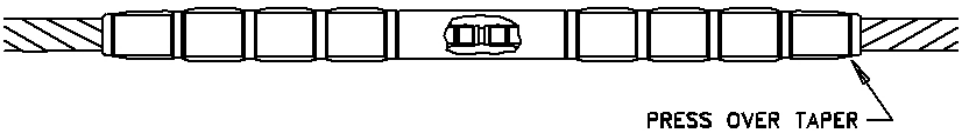
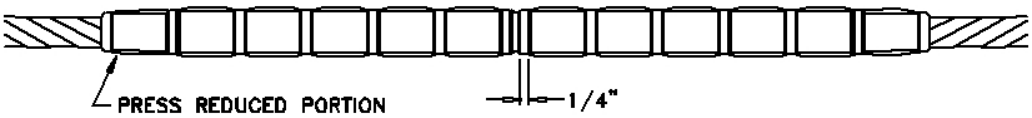


TABLE I
ACSR CONDUCTORS – TWO SLEEVE UNITS

Conductor Size	Splicing Unit Designation	Dies (STL-AL)	Presses Per Half Core	Presses Per Half Cover
4 (6/1)	Orange	Orange	1	3
4 (7/1)	Tangerine	Orange	1	3
3 (6/1)	Grapefruit	Orange	1	3
2 (6/1)	Peach	Peach	1	3
2 (7/1)	Pear	Peach	1	3
1 (6/1)	Quince	Peach	1	4*
1/0 (6/1)	Plum	Plum	1	4
2/0 (6/1)	Ash	74AS	2*	4
3/0 (6/1)	Elm	75AS	2	5
4/0 (6/1)	Maple	75AS	2	5
80 (8/1)	1769-75AS-74AS	75AS-74AS	2	5
101.8 (12/7)	1777-E82-76A	E82-76A	6	7
110.8 (12/7)	1777-E82-76A	E82-76A	6	7
134.6 (12/7)	1778-F92-76A	F92-76A	7	7
266.8 (18/1)	Cedar	74S-76A	2*	6
266.8 (6/7)	Oak	76AS	3	6*
266.8 (26/7)	Pine	76AS	3	6*
336.4 (18/1)	Hickory	74S-76A	2*	6
336.4 (26/7)	1775-E82-77A	E82-77A	6	7
336.4 (30/7)	2430-F62-77A	F62-77A	6	7
477 (24/7; 26/7)	1776-F92-77A	F92-77A	7	8
605 (24/7)	1688-F92-27AH	F92-27AH	7	8
795 (36/1)	2184-74S-28	74S-28	2*	9
795 (26/7)	1689-J82-28	J82-28	8	9
795 (45/7)	2185-E82-28	E82-28	6	9

***Overlap Compressions As Necessary**



Single Sleeves

Single sleeves for All-Aluminum, ACSR, and AAAC conductors are prefilled with gritted corrosion inhibitor. **No further application in necessary**. Make the first press **at least** ¼" from the center mark. Make the last press(es) at each end over the reduced diameter portion (All-Aluminum) or tapered portion (ACSR and AAAC) of the sleeve.

TABLE II — ACSR and AAAC – SINGLE SLEEVES

Conductor Size - ASCR	Conductor Size - AAAC	Sleeve Number	Die	Presses Per Half
4 (6/1; 7/1)	4 (7)	467-Orange	Orange	5
2 (6/1)	2 (7)	261-Peach	Peach	4
2 (6/1; 7/1)	2 (7)	267-Plum	Plum	6
1 (6/1)	---	2281-Plum	Plum	6
1/0 (6/1)	1/0 (7)	1061-Plum	Plum	6
2/0 (6/1)	2/0 (7)	2061-74A	74A	8
3/0 (6/1)	3/0 (7)	3061-75A	75A	7
4/0 (6/1)	4/0 (7)	4061-76A	76A	9

TABLE III — ALL – ALUMINUM CONDUCTORS

Conductor Size AWG - MCM	Sleeve Number	Die	Presses Per Half
1 (7, 19)	AL-1-STR-G33	G3	3*
1/0 (7, 19)	AL-1/0-STR-G33	G3	3
1/0 (7, 19)	AL-1/0-STR-PEACH	PEACH	3*
2/0 (7, 19)	AL-2/0-STR-G33	G3	4
3/0 (7, 19)	AL-3/0-STR-H54	H5	5*
4/0 (7, 19)	AL-4/0-STR-H54	H5	5
250 (7, 19, 37, 61)	AL-250-75A	75A	5*
266.8 (7, 19)	AL-266.8-75A	75A	5
300 (7, 19, 37, 61)	AL-300-76A	76A	5
336.4 (19)	AL-336.4-76A	76A	6*
350 (7, 19, 37, 61)	AL-350-76A	76A	6*
397.5 (19)	AL-397.5-77A	77A	6*
477 (19, 37)	AL-477-77A	77A	6
600 (37, 61, 91)	AL-600-27AH	27AH	7
795 (37, 61)	AL-759-28	28	7

***Overlap Compressions As Necessary**

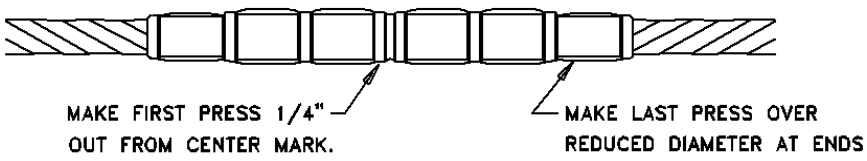


TABLE IV — COPPER CONDUCTORS

Conductor Size	Sleeve Number	Die	Presses Per Half
3 # 6	1-3/162-E8	E8	2
1 (3)	1-289/3-E8	E8	2
1 (7, 19); 1/0 SOL	1-289/7-E8	E8	2
1/0 (7, 19); 2/0 SOL	1-325/7-F6	F6	3
2/0 (7, 19); 3/0 SOL	1-365/7-G3	G3	3
3/0 (7, 19); 4/0 SOL	1-410/7-G9	G9 G92	3 6
4/0 (7, 19)	1-460/7-H5	H5 H52	3 6
250MCM (19, 37)	1-250,000-J2	J2 J22	3 6
300MCM (19, 37)	1-300,000-J8	J8 J82	3 6
350MCM (19, 37)	1-350,000-L12	L12	6
400MCM (19, 37)	1-400,000-L12	L12	8
500MCM (19, 37)	1-500,000-M62	M62	10
600MCM (37, 61)	1-600,000-M62	M62	11

TABLE V — COPPERWELD® TYPE CABLES

Cable Size	Sleeve Number	Die	Presses Per Half
3 # 8, 6M3	3-3/128-E8	E8	2
6M	3-6M-E8	E8	2
8M	3-8M-F6	F6	3
3 # 7, 10M, 5/16 (7 # 10)	3-7/102-F6	F6	3
3 # 6, 11/32 (7 # 9)	3-7/114-G3	G3	3
12.5M, 14M	3-12.5M-G9	G9	3
3 # 5,16M, 3/8 (7 # 8)	3-7/128-H52	H52	7
18M, 20M, 7/16 (7 # 7)	3-7/144-J82	J82	7
1/2 (7 # 6)	3-7/162-K42	K42	7
9/16 (7 # 5)	3-7/182-M12	M12	8
5/8 (7 # 4)	3-7/204-M12	M12	8
2F	1-2F-E8	E8	3
1F	1-1F-F6	F6	4*
1/0F	1-1/0F-G3	G3	4
2/0F	1-2/0-G9	G9	4
3/0F	1-3/0F-H5	H5	5
4/0F	1-4/0F-J2	J2	6
2A	3-2A-F6	F6	3

***Overlap Compressions As Necessary**

TABLE VI — ALUMOWELD® CABLES

Cable Size	Sleeve Number	Die	Presses Per Half
7 # 12, 6M	5-7/080-W	W	4
3 # 8, 7 # 11, 8M	5-7/093-E82	E82	6
7 # 10, 10M	5-7/104-F92	F92	5
3 # 6, 7 # 9, 12.5M	5-7/120-F62	F62	7
3 # 5, 7 # 8, 16M	5-3/182-G92	G92	8
7 # 7	5-7/145-J22	J22	11
7 # 6	5-7/165-M32	M32	14

TABLE VII — GALVANIZED STEEL CABLES

Cable Size	Sleeve Number	Die	Presses Per Half
1/4 (3) SM, HS	5-203/3-S	S	3
1/4 (7) HS, EHS	5-7/080-W	W	4
9/32 (7) HS, EHS	5-7/093-E82	E82	6
5/16 (3, 7) SM	5-7/104-W	W	3
5/16 (3, 7) HS, EHS	5-7/104-F92	F92	7
3/8 (7) SM	5-7/120-F62	F62	7
3/8 (3, 7) HS, EHS	5-7/120-G92	G92	8
7/16 (7) SM	5-7/145-G92	G92	8
7/16 (7) HS, EHS	5-7/145-J22	J22	11
1/2 (7) HS, EHS	5-7/165-M32	M32	14
8 B.W.G. (3) "80"-"130"	5-165/3-L	L	2
6 B.W.G. (3) "80"-"130"	5-203/3-S	S	3
4 B.W.G. (3) "80"-"130"	5-238/3-W	W	4

HOW TO INSTALL NON-ADJUSTABLE COMPRESSION TYPE DEAD-END FITTINGS ON CONDUCTOR
TABLE VIII — *NICOPRESS*® COMPRESSION FITTINGS

NICOPRESS® Part Number	Conductor Size	Die Number	Minimum Compressions
2956-J82	7/16 (7 No 7) H.S. COPPERWELD®	J82	7
2959-M12	4/0-E (7 COPPERWELD® & 12 Copper)	M12	8
2957-M12	9/16 (19 No 9) H.S. COPPERWELD®	M12	8

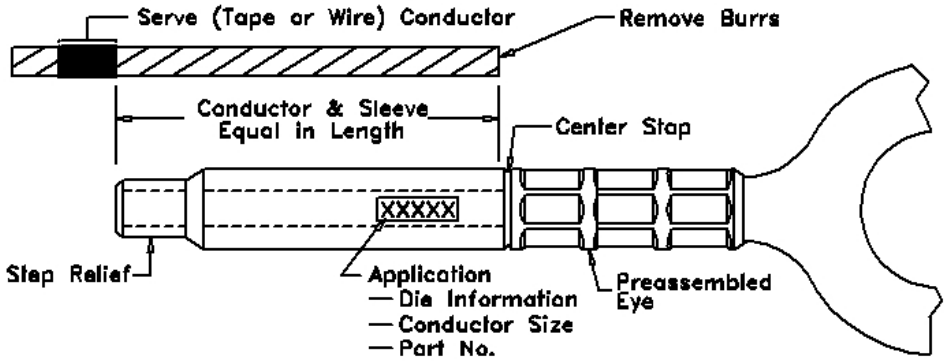
1.On Table 1A find the conductor or strand size to be terminated. Use only the Compression Dead-End Fitting recommended by ***NICOPRESS*®** Part Number for that conductor size.

2.Before cutting conductor, carefully serve (tape or wire) the conductor far enough from the end for the cut conductor to fill the depth of the sleeve to the center stop (Figure A). Taping indicates depth and also prevents unraveling. Conductor should be cut concentrically and cleanly — NO BURRS.

3.Clean Weathered or Blackened Conductor:

NOTE: Prior to assembly, conductor may be coated with ***NICOPRESS*®** Zinc Chromate Splicing Compound as an optional corrosion protection agent. Insert conductor into sleeve. Push forward until conductor stops at center stop. Do not repeatedly remove the conductor during assembly or excessively twist the conductor during insertion as this may cause excessive loss of abrasive inside the sleeve.

FIGURE A



4.Again, from Table 1A, select the proper installation Die Number for the conductor size. Begin compressing sleeve 1/8" from the center stop. Continue outward with presses the full length of the sleeve. Apply at least as many presses as indicated. If in doubt as to the required number of compressions, overlay crimps the full length of the sleeve, including the step relief at the end of the sleeve

5.Using the "GO" Type gauge supplied with each tool, check the depth of all compressions. If the pressed portion of the sleeve will not enter the gauge, check the output pressure of the pump. Re-press as required. Contact factory in the event of any problems.

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