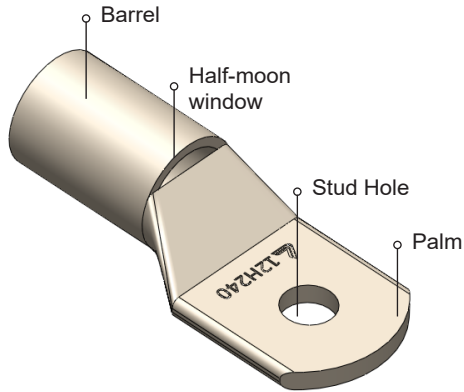


B05

CU-FLEX® Tinned Straight Copper Lug Installation Guide



Recommended Stud Tightening Torque

Bolt (AS 1110, Class 8.8)	Recommended Torque (Nm)
M5	5
M6	9
M8	22
M10	44
M12	77
M16	190

B05 SELECTION TABLE - CU-FLEX COPPER LUG					Crimp Distance from Barrel Front Edge			Stripping Length of Cable Insulation
Conductor Size	Die A/F	Hydraulic Tools - Hexagonal Die No. of Crimp x Crimp Face Length*			12-13 tonne	25 tonne	60 tonne	
mm ²	mm	12 - 13 tonne	25 tonne	60 tonne	mm	mm	mm	mm
6	4.4	1 Crimp x 6.4mm	Use Adaptor and Standard 12 Tonne Dies	Use Adaptor and Standard 12 Tonne Dies	1.0	8.0	10.0	9
10	5.7	1 Crimp x 6.4mm			2.0			10
16	6.3	1 Crimp x 17.5mm			In-line			19
25	7.7	1 Crimp x 17.5mm			1.0			21
35	9.2	1 Crimp x 17.5mm			2.0			21
50	10.4	1 Crimp x 17.5mm			3.0			22
70	11.5	1 Crimp x 17.5mm			5.0			24
95	14.2	1 Crimp x 17.5mm			8.0			27
120	16.5	1 Crimp x 14.0mm			9.0			30
150	18.3	1 Crimp x 14.0mm			1 Crimp x 16.0mm			14.0
185	20.0	1 Crimp x 14.0mm	1 Crimp x 16.0mm	12.0	15.0	32		
240	23.1	1 Crimp x 10.0mm	1 Crimp x 16.0mm	15.0	13.0	38		
300	26.0	2 Crimp x 10.0mm	1 Crimp x 16.0mm	1 Crimp x 25.0mm	13.0	10.0	42	
400	28.1	2 Crimp x 10.0mm	1 Crimp x 16.0mm	1 Crimp x 25.0mm	15.0	13.0	44	
500	31.0		1 Crimp x 16.0mm	1 Crimp x 25.0mm			48	
630	37.0		2 Crimp x 16.0mm	1 Crimp x 25.0mm			56	

(*) In case of using dies with different length of crimp face than specified above, the total effective crimp length (crimp length x no. of crimp) should be equivalent to maintain a secured mechanical and electrical connection.

This Installation Guide was designed with great care and proper testing before publication to ensure the product works perfectly with TriCab flexible cables. CU-FLEX® Tinned Straight Copper Lugs are specifically designed, tested and certified for use with TriCab CU-FLEX® cables only. TriCab is not liable for any errors, omissions, damages etc. due to improper use of this product, included but not limited to improper installation deviating from this Guide, safety and warning rules violation, using unsuitable cable other than TriCab flexible cable. TriCab reserves the right to modify this Installation Guide at any time without prior notice.

www.tricab.com



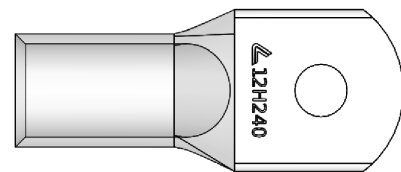
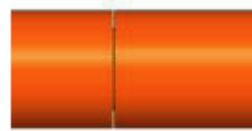
B05

CU-FLEX® Tinned Straight Copper Lug Installation Guide

METHOD 1

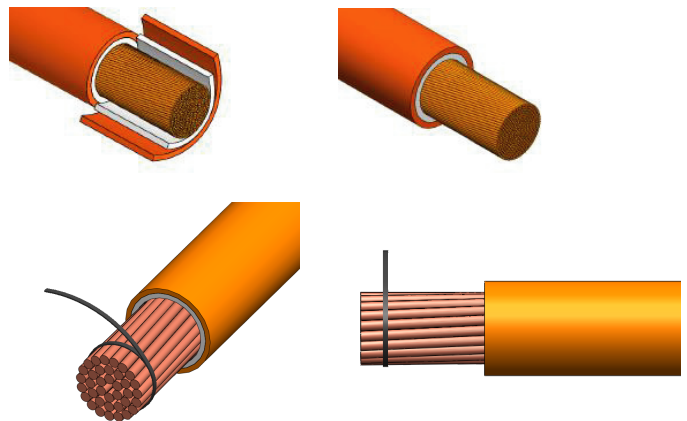
1. Select suitable size of **CU-FLEX® Tinned Straight Copper Lug** by verifying that the conductor size markings on the lug and cable match.

Mark the stripping length on cable as specified on the B05 Selection Table.



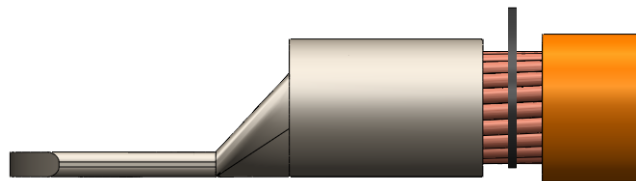
2. Carefully cut and strip the outer layers of the cable (sheathing, insulation, fleece tape). Be very careful not to nick or cut any strands of the conductor. Adjust the stripping tool so that it cuts close to the conductor but leaves a small amount of insulation to tear away by hand. This will help protect the fine wires during the stripping process.

Use a standard nylon cable tie (installed the opposite way so that it does not lock) to hold the flared end of the conductors together.



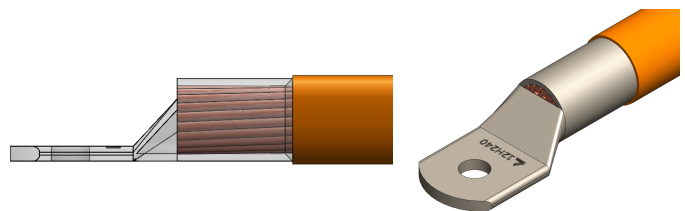
3. Carefully insert the copper conductor into the lug, while holding the conductor strands together with the cable tie. Make sure all strands are contained within the barrel. Do not twist the conductor.

Loosen up and remove the cable tie.



4. Carefully push the conductor into the end of the barrel. Use the half-moon window to check if conductor is fully inserted into the barrel.

Do not twist the conductor.



This Installation Guide was designed with great care and proper testing before publication to ensure the product works perfectly with TriCab flexible cables. CU-FLEX® Tinned Straight Copper Lugs are specifically designed, tested and certified for use with TriCab CU-FLEX® cables only. TriCab is not liable for any errors, omissions, damages etc. due to improper use of this product, included but not limited to improper installation deviating from this Guide, safety and warning rules violation, using unsuitable cable other than TriCab flexible cable. TriCab reserves the right to modify this Installation Guide at any time without prior notice.

www.tricab.com

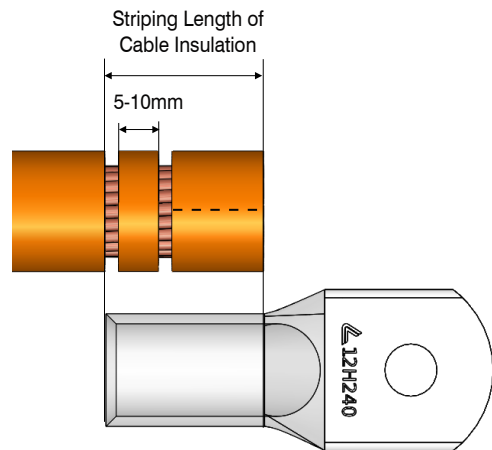
B05

CU-FLEX® Tinned Straight Copper Lug Installation Guide

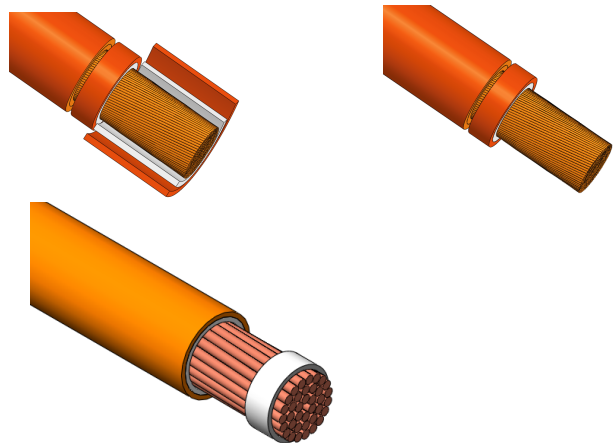
METHOD 2

1. Select suitable size of **CU-FLEX® Tinned Straight Copper Lug** by verifying that the conductor size markings on the lug and cable match.

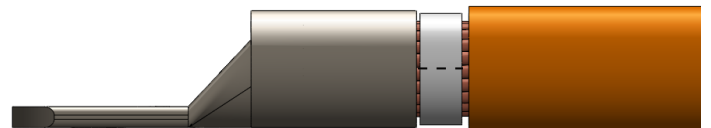
Mark the stripping length on cable as specified on the B05 Selection Table.



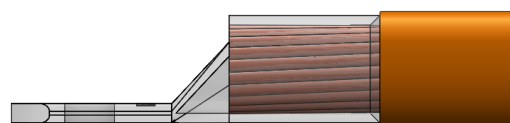
2. Carefully cut and strip the outer layers of the cable (sheathing, insulation, fleece tape). Be very careful not to nick or cut any strands of the conductor. Adjust the stripping tool so that it cuts close to the conductor but leaves a small amount of insulation to tear away by hand. This will help protect the fine wires during the stripping process. Strip the jacket of the separate section and move the remaining piece of insulation towards the end of the conductor. This will help hold the conductor ends together.



3. Carefully insert the copper conductor into the lug, making sure all strands are contained within the barrel. Do not twist the conductor. Gently push both the lug and the remaining section until they meet the jacket. Cut and remove the section specified by the dashed line.



4. Carefully push the conductor into the end of the barrel. Use the half-moon window to check if conductor is fully inserted into the barrel. Do not twist the conductor.



This Installation Guide was designed with great care and proper testing before publication to ensure the product works perfectly with TriCab flexible cables. CU-FLEX® Tinned Straight Copper Lugs are specifically designed, tested and certified for use with TriCab CU-FLEX® cables only. TriCab is not liable for any errors, omissions, damages etc. due to improper use of this product, included but not limited to improper installation deviating from this Guide, safety and warning rules violation, using unsuitable cable other than TriCab flexible cable. TriCab reserves the right to modify this Installation Guide at any time without prior notice.

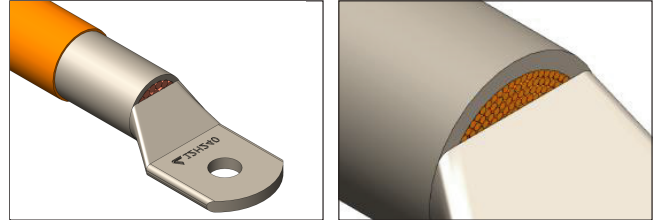
www.tricab.com



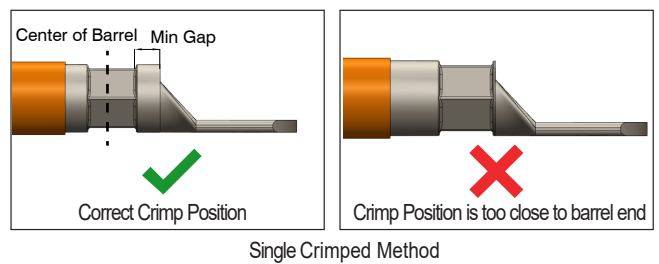
B05

CU-FLEX® Tinned Straight Copper Lug Installation Guide

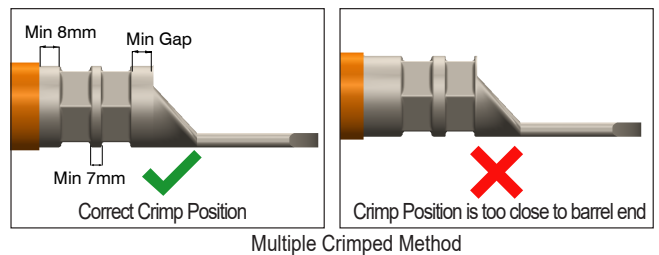
- 5.** Select a suitable crimping tool with the correct crimp force and note the required No. of crimps as specified on the B05 Selection Table (12-13 Tonne, 25 Tonne or 60 Tonne). Choose the appropriate Copper die by referring to the correct A/F (across flats) die size in the B05 Selection Table.



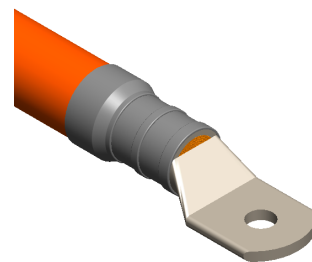
- 6.** For hydraulic hex crimpers, place the lug on the non-moving die and allow the other die to move up to crimp. **If more than 1 crimp is required (refer B05 Selection Table for more details), begin crimping from the front end (palm end) of the barrel and work towards the open end.** Position the lug to the correct crimp location on the barrel as specified in the B05 Selection Table. Do not crimp closer than the minimum gap specified in the B05 Selection Table from the front end of the barrel.



- 7.** Begin the crimping process and continue until the full cycle is complete. Make sure the dies are fully closed for sufficient crimping force. Release the ram and repeat the process if more than 1 crimp is required. Leave a 7mm gap between each crimp. Do not crimp closer than 8mm from the open end of the barrel.



- 8.** Check the crimping result. Use a file if necessary to remove burrs to have a smooth crimp surface. Apply suitable **CU-FLEX® G01 Heatshrink** to complete the crimping. The heatshrink should cover the entire Copper Barrel and approximately 50mm of the cable jacket



This Installation Guide was designed with great care and proper testing before publication to ensure the product works perfectly with TriCab flexible cables. CU-FLEX® Tinned Straight Copper Lugs are specifically designed, tested and certified for use with TriCab CU-FLEX® cables only. TriCab is not liable for any errors, omissions, damages etc. due to improper use of this product, included but not limited to improper installation deviating from this Guide, safety and warning rules violation, using unsuitable cable other than TriCab flexible cable. TriCab reserves the right to modify this Installation Guide at any time without prior notice.