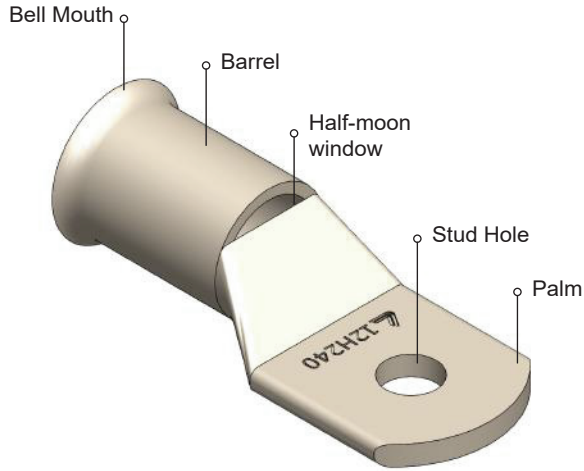


B06

CU-FLEX® Bell Mouth Tinned 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 |

| B06 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 | | | 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 | | | 3.0 | | | 21 |
| 50 | 10.4 | 1 Crimp x 17.5mm | | | 5.0 | | | 22 |
| 70 | 11.5 | 1 Crimp x 17.5mm | | | 10.0 | | | 24 |
| 95 | 14.2 | 1 Crimp x 17.5mm | | | 14.0 | | | 27 |
| 120 | 16.5 | 1 Crimp x 14.0mm | | | 10.0 | | | 30 |
| 150 | 18.3 | 1 Crimp x 14.0mm | | | 1 Crimp x 16.0mm | | | 10.0 |
| 185 | 20.0 | 1 Crimp x 14.0mm | 1 Crimp x 16.0mm | 14.0 | 10.0 | 32 | | |
| 240 | 23.1 | 1 Crimp x 10.0mm | 1 Crimp x 16.0mm | 10.0 | 15.0 | 38 | | |
| 240L | 23.1 | 2 Crimp x 10.0mm | 1 Crimp x 16.0mm | 10.0 | 13.0 | 48 | | |
| 300 | 26.0 | 2 Crimp x 10.0mm | 1 Crimp x 16.0mm | 1 Crimp x 25.0mm | 15.0 | 10.0 | 42 | |
| 300L | 26.0 | 2 Crimp x 10.0mm | 1 Crimp x 16.0mm | 1 Crimp x 25.0mm | 15.0 | 10.0 | 48 | |
| 400 | 28.1 | 2 Crimp x 10.0mm | 1 Crimp x 16.0mm | 1 Crimp x 25.0mm | 8.0 | 15.0 | 44 | |
| 500 | 31.0 | | 1 Crimp x 16.0mm | 1 Crimp x 25.0mm | | | 48 | |
| 500L | 31.0 | | 2 Crimps x 16.0mm | 1 Crimp x 25.0mm | | | 56 | |
| 630 | 37.0 | | | 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.

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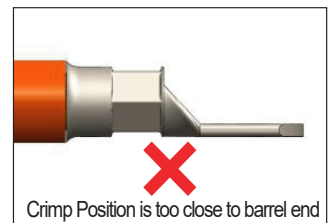
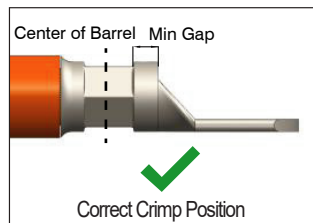
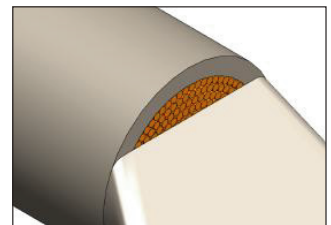
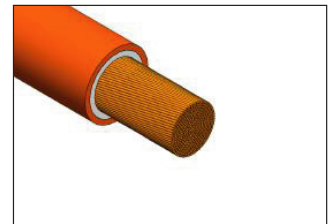
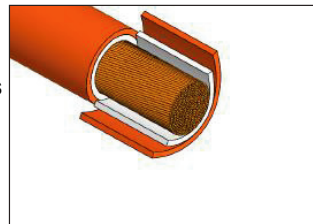
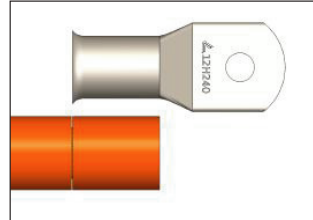
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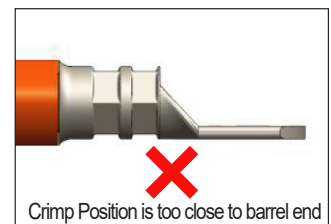
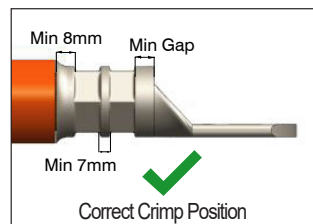
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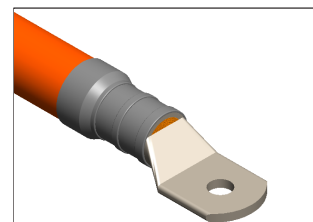
1. Select a suitable size of **CU-FLEX® Bell Mouth Tinned Copper Lug** by verifying that the conductor size marking on the lug and cable match. Mark stripping length on cable as specified on the B06 Selection Table.
2. Carefully cut and strip outer layers of the cable (sheathing, insulation, fleece tape). 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.
3. Carefully insert the conductor into the lug making sure all strands are contained within the barrel. Do not twist the conductor. Use half-moon window to check if conductor is fully inserted into the barrel.
4. Select a suitable crimping tool with the correct crimp force and note the required No. of crimps as specified on the B06 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 on the B06 Selection Table.
5. 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 B06 Selection Table for more details), begin crimping from the front end (palm end) of the barrel to the open end.** Position the lug to the correct crimp location on the barrel as specified on the B06 Selection Table. Do not crimp closer than the minimum gap specified in the B06 Selection Table from the front end of the barrel.
6. 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.
7. Check 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



Single Crimped Method



Multiple Crimped Method



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