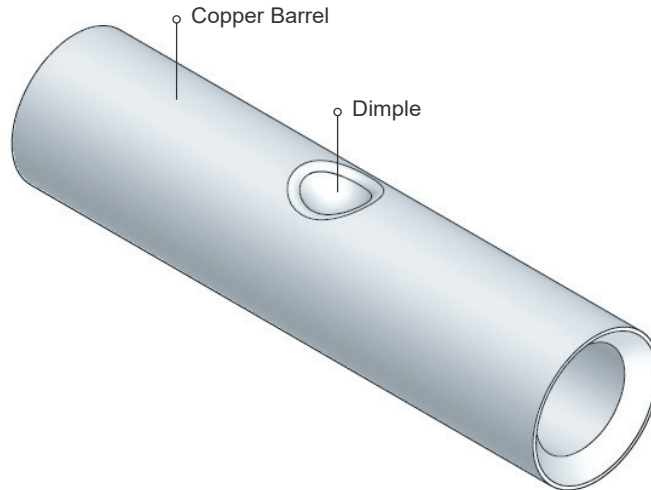


B07

CU-FLEX® Copper Crimp Link Installation Guide



B07 SELECTION TABLE - CU-FLEX COPPER CRIMP LINK					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
16	6.3	1 Crimp x 17.5mm			1.0			22
25	7.7	1 Crimp x 17.5mm			24			
35	9.2	1 Crimp x 17.5mm			24			
50	10.4	1 Crimp x 17.5mm			24			
70	11.5	1 Crimp x 17.5mm			27			
95	14.2	1 Crimp x 17.5mm			27			
120	16.5	1 Crimp x 14.0mm			34			
150	18.3	1 Crimp x 14.0mm	1 Crimp x 16.0mm		9.0	8.0		34
185	20.0	1 Crimp x 14.0mm	1 Crimp x 16.0mm		34			
240	23.1	2 Crimp x 10.0mm	1 Crimp x 16.0mm		44			
300	26.0	2 Crimp x 10.0mm	1 Crimp x 16.0mm	1 Crimp x 25.0mm	6.0	12.0	10.0	45
400	28.1	2 Crimp x 10.0mm	1 Crimp x 16.0mm	1 Crimp x 25.0mm				10.0
500	31.0		2 Crimp x 16.0mm	1 Crimp x 25.0mm		5.0	15.0	56
630	37.0		2 Crimp x 16.0mm	1 Crimp x 25.0mm				56

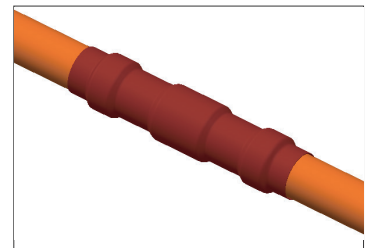
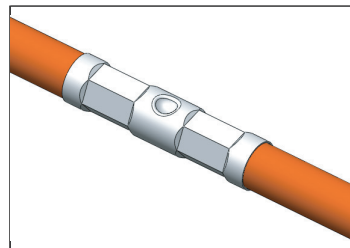
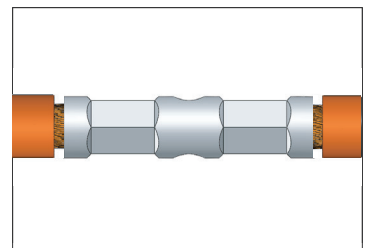
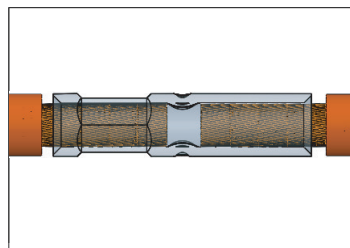
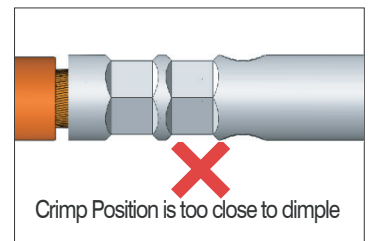
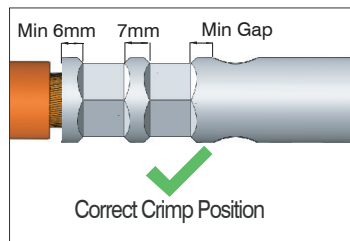
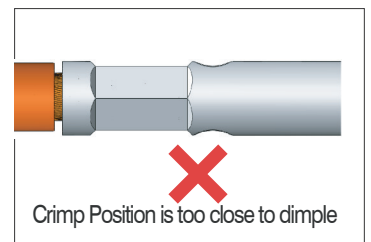
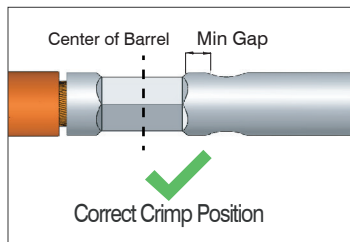
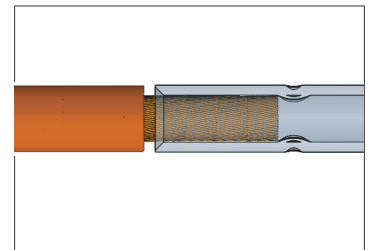
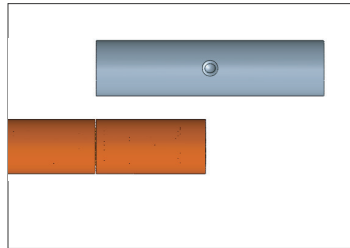
(*) In case of using dies with different length of crimp face from specified above, the total effective crimp length (crimp length x no. of crimp) should be equivalent or greater to maintain a secured mechanical and electrical connection.

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® Copper Crimp Links 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.

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CU-FLEX® Copper Crimp Link Installation Guide

- 1.** Select a suitable size of **CU-FLEX® Copper Crimp Link** by verifying that the conductor size marking on the lug and cable match. Mark stripping length on cable as specified on the B07 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 link making sure all strands are contained within the barrel. Do not twist the conductor.
- 4.** Select a suitable crimping tool with the correct crimp force and note the required No. of crimps as specified on the B07 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 B07 Selection Table.
- 5.** For hydraulic hex crimpers, place the link on the non-moving die and allow the other die to move up to crimp. **If more than 1 crimp is required (refer B07 Selection Table for more details), begin crimping from the center (dimple end) of the barrel to the open end.** Position the link to the correct crimp location on the barrel as specified on the B07 Selection Table. Do not crimp closer than the minimum specified gap from the dimple at the center.
- 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 6mm from the open end of the barrel.
- 7.** Repeat Steps 1-6 for the other end of the barrel.
- 8.** Check crimping result. Use a file if necessary to remove burrs to have a smooth crimp surface. Apply suitable **CU-FLEX® G01 Glue Lined Heatshrink** over the entire link to complete the crimping. Two layers of the heatshrink should be applied if the link is outside an enclosure. The heatshrink should cover both barrels and approximately 50mm of the cable jacket on either end.



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