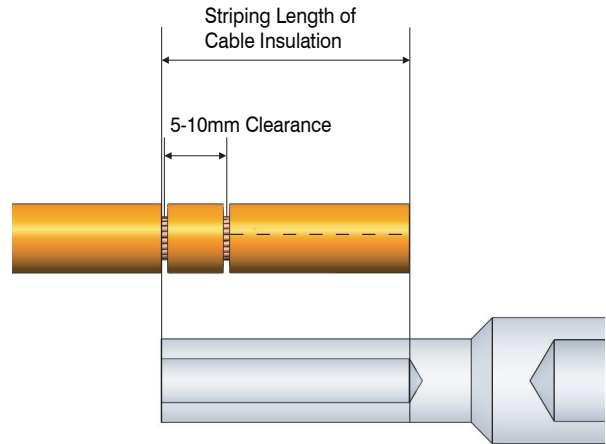


# B21

## ALI-FLEX® Bi-Metallic Reducing Link Installation Guide

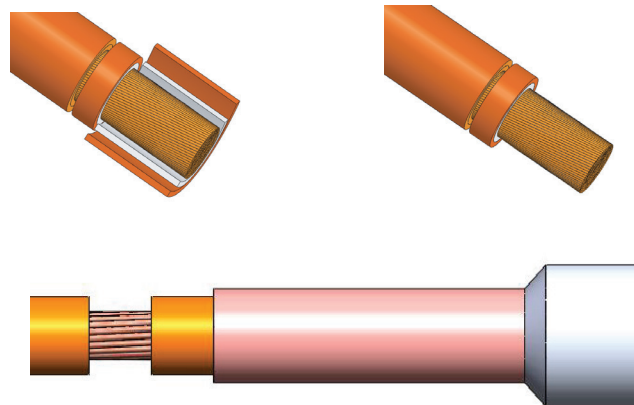
1. Select suitable size of **ALI-FLEX® Bi-Metallic Reducing Link** by verifying that the markings on the link and cables match.

Select the appropriate Copper Cable and mark the stripping length as specified in Table 1: Installation of Copper Conductor.



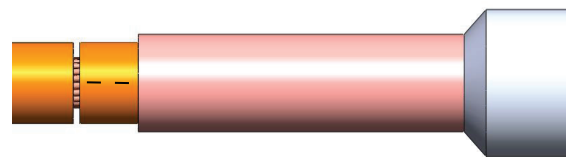
2. Carefully cut and strip the outer layers of the cable (sheathing, insulation, fleece tape). Be very careful not to nick or cut any strands of the conductor. Adjust the stripping tool so that it cuts close to the conductor but leaves a small amount of insulation to tear away by hand. This will help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

Place the link at the end of the copper conductor.



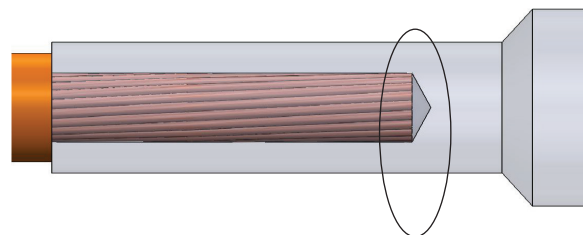
3. Gently push both the link and the remaining section until they meet the jacket.

Cut and remove the section specified by the dashed line.



4. Carefully insert the copper conductor into the end of the copper barrel making sure all strands are contained within the barrel.

Do not twist the conductor.

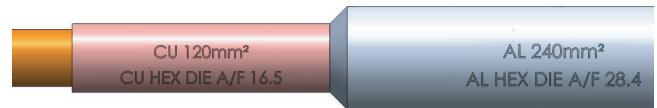


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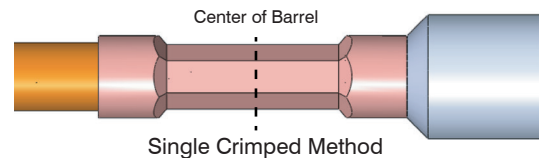
# B21

## ALI-FLEX® Bi-Metallic Reducing Link Installation Guide

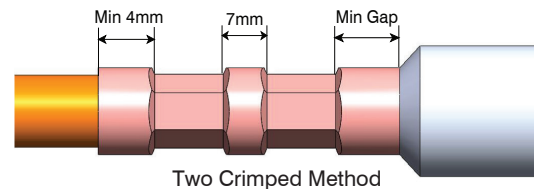
- 5.** Select a suitable crimping tool with the correct crimp force and note the required No. of crimps as specified on Table 1 (12, 25 or 60 Tonne). Choose the appropriate Copper die by referring to the correct A/F (across flats) die size on Table 1. The correct A/F size is also printed on the copper barrel of each B21 lug. **Please note that the mm<sup>2</sup> cable size markings on AF dies from brands other than TriCab, have no relationship to the mm<sup>2</sup> cable sizes for CU-FLEX or ALI-FLEX cables.**



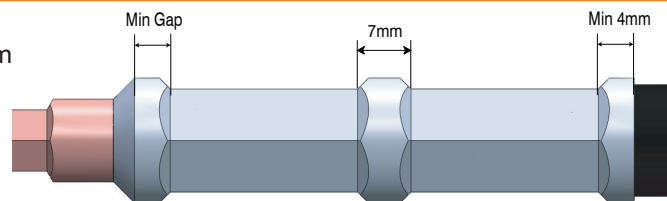
- 6.** For hydraulic hex crimpers, place the lug on the non-moving die and allow the other die to move up to crimp. **If more than 1 crimp is required (refer Table 1 for more details), begin crimping from the linked end of the barrel and work towards the open end.** Position the lug to the correct crimp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



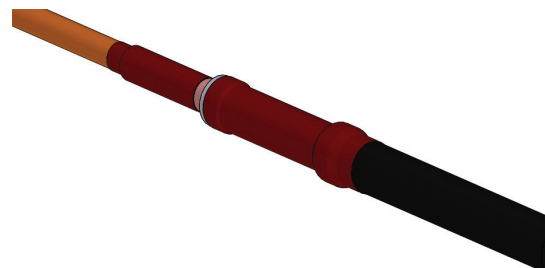
- 7.** Begin the crimping process and continue until the full cycle is complete. Make sure the dies are fully closed for sufficient crimping force. Release the ram and repeat the process if more than 1 crimp is required. Leave a 7mm gap between each crimp. Do not crimp closer than 4mm from the open end of the barrel.



- 8.** Refer Table 2 and repeat Steps 1-7 for the Aluminium conductor



- 9.** Check crimping result. Use a file if necessary to remove burrs to have a smooth crimp surface. Apply suitable **ALI-FLEX® G03 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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# B21

## ALI-FLEX® Bi-Metallic Reducing Link Installation Guide

Table 1. Installation of Copper Conductor

B21 CU SELECTION TABLE - ALI-FLEX BI-METTALIC REDUCING 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 <sup>2</sup>	mm	12-13 tonne	25 tonne	60 tonne	mm	
10	5.7	1 Crimp x 6.4.0mm	Use Adaptor and Standard 12 Tonne Dies	Use Adaptor and Standard 12 Tonne Dies	10	24	20	10
16	6.3	1 Crimp x 17.5mm			4			19
25	7.7	1 Crimp x 17.5mm			6			21
35	9.2	1 Crimp x 17.5mm			13			21
50 (AL-70)	10.4	1 Crimp x 17.5mm			5			22
50	10.4	1 Crimp x 17.5mm			15			40
70	11.5	1 Crimp x 17.5mm			15			40
95	14.2	1 Crimp x 17.5mm			10			40
120	16.5	2 Crimps x 14.0mm			1			40
150	18.3	2 Crimps x 14.0mm			1			40
185	20.0	2 Crimps x 14.0mm	1	55				
240	23.1	3 Crimps x 10.0mm	1	55				
300	26.0	3 Crimps x 10.0mm	1	55				
400	28.1	1 Crimp x 16.0mm	1	55				
500	31.0	1 Crimp x 16.0mm	1	55				

Table 2. Installation of Aluminium Conductor

B21 AL SELECTION TABLE - ALI-FLEX BI-METTALIC REDUCING 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*				
mm <sup>2</sup>	mm	12-13 tonne	25 tonne	60 tonne	mm	mm
16	9.0	1 Crimp x 22.0mm	Use Adaptor and Standard 12 Tonne Dies	Use Adaptor and Standard 12 Tonne Dies	10	32
25	9.0	1 Crimp x 22.0mm				32
35	13.2	1 Crimp x 22.0mm				32
50	17.3	2 Crimps x 22.0mm				60
70	17.3	2 Crimps x 22.0mm				60
95	17.3	2 Crimps x 22.0mm				60
120	22.0	2 Crimps x 18.0mm				60
150	22.0	2 Crimps x 18.0mm				60
185	28.4	2 Crimps x 18.0mm				60
240	28.4	2 Crimps x 18.0mm				60
300	39.0	2 Crimps x 25.0mm	1 Crimp x 50.0mm	13	70	
400	39.0		1 Crimp x 50.0mm	10(25T)/13(60T)	70	
500	43.2		1 Crimp x 50.0mm	13	70	
630	43.2		1 Crimp x 50.0mm		70	

(\* ) 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.

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