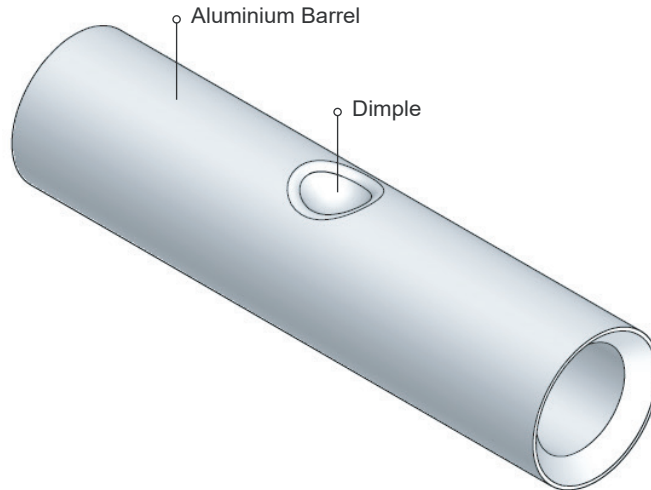


# B24

## ALI-FLEX® Aluminium Crimp Link Installation Guide



B24 SELECTION TABLE - ALI-FLEX CRIMP LINK				Crimp Distance from Dimple 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	60 tonne	mm	mm
16	9.0	1 Crimp x 22.0mm	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	17.3	2 Crimps x 22.0mm			60
150	22.0	2 Crimps x 18.0mm			60
185	22.0	2 Crimps x 18.0mm			60
240	28.4	2 Crimps x 18.0mm			60
300	28.4	2 Crimps x 18.0mm			70
400	39.0		1 Crimp x 50.0mm	13	70
500	43.2		1 Crimp x 50.0mm		70
630	43.2		1 Crimp x 50.0mm		70

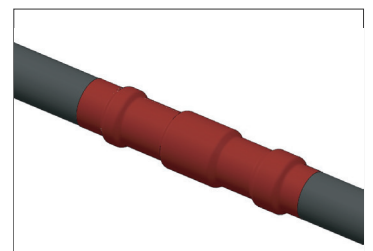
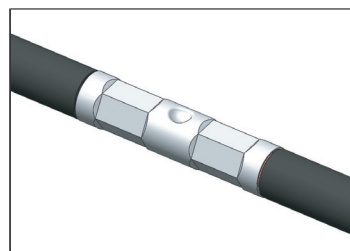
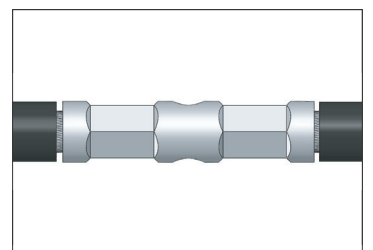
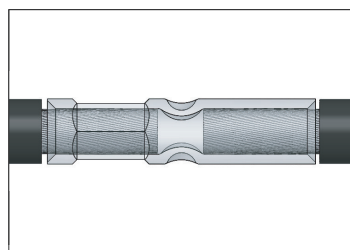
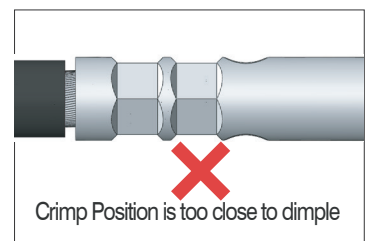
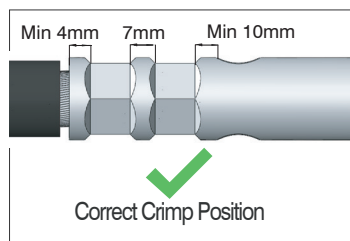
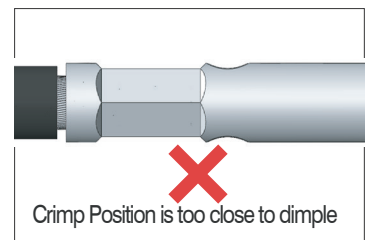
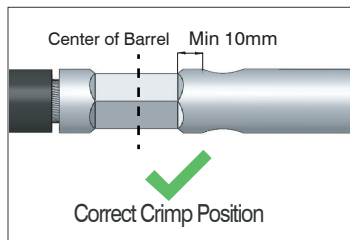
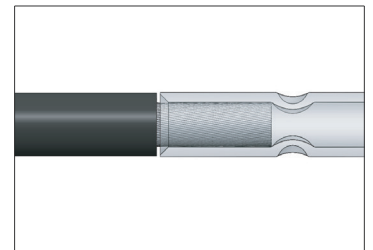
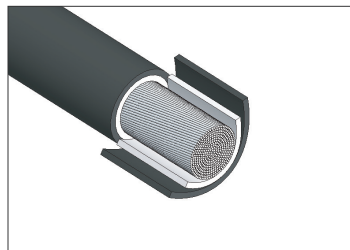
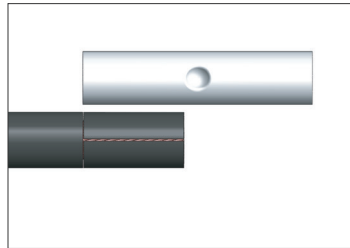
(\* ) In case of using dies with different length of crimp face from specified above, the total effective crimp length (crimp length x no. of crimp) should be equivalent or greater to maintain a secured mechanical and electrical connection.

This Installation Guide was designed with great care and proper testing before publication to ensure the product works perfectly with TriCab flexible cables. ALI-FLEX® Aluminium Crimp Links are specifically designed, tested and certified for use with TriCab ALI-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.

# B24

## ALI-FLEX® Aluminium Crimp Link Installation Guide

1. Select a suitable size of **ALI-FLEX® Aluminium Crimp Link** by verifying that the conductor size marking on the lug and cable match. Mark stripping length on cable as specified on the B24 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.
4. Select a suitable crimping tool with the correct crimp force and note the required No. of crimps as specified on the B24 Selection Table (12-13 Tonne or 60 Tonne). Choose the appropriate Aluminium die by referring to the correct A/F (across flats) die size on the B24 Selection Table. The correct A/F size is also printed on each B24 link. **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 ALI-FLEX cables.**
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 B24 Selection Table for more details), begin crimping from the center (dimple end) of the barrel to the open end.** Position the lug to the correct crimp location on the barrel as specified on the B24 Selection Table. Do not crimp closer than 10mm 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 4mm 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 **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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