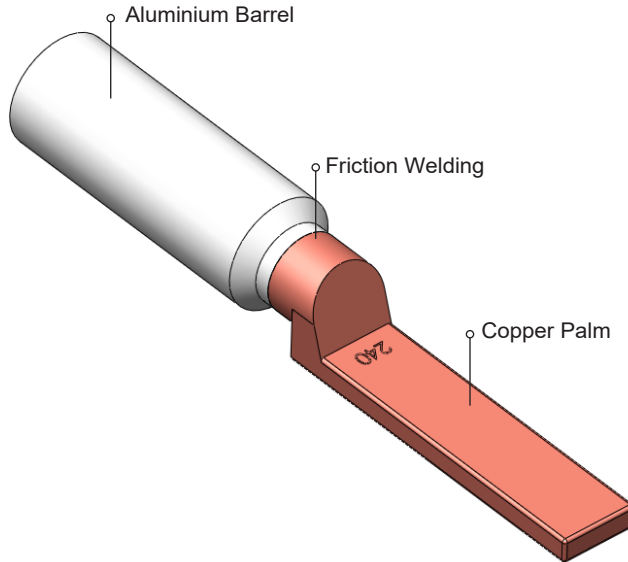


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ALI-FLEX® Long Palm Bi-Metallic Lug Installation Guide



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

B27 SELECTION TABLE - ALI-FLEX LONG PALM LUG					Crimp Distance from Barrel Front Edge	Stripping Length of Cable Insulation	Maximum stud hole Ø allowed to be drilled on palm	
Conductor Size	Die A/F	Hydraulic Tools - Hexagonal Die No. of Crimp x Crimp Face Length*						
mm ²	mm	12-13 tonne	25 tonne	60 tonne	mm	mm	mm	
16	9.0	2 Crimps x 22.0mm	Use Adaptor and Standard 12 Tonne Dies	Use Adaptor and Standard 12 Tonne Dies	10	67	8.5	
25	9.0	2 Crimps x 22.0mm				67	8.5	
35	13.2	2 Crimps x 22.0mm				67	10.5	
50	17.3	3 Crimps x 22.0mm				97	13.0	
70	17.3	3 Crimps x 22.0mm				97	13.0	
95	17.3	3 Crimps x 22.0mm				97	13.0	
120	17.3	3 Crimps x 22.0mm				97	13.0	
150	22.0	3 Crimps x 18.0mm				85	13.0	
185	22.0	3 Crimps x 18.0mm				85	13.0	
240	28.4	3 Crimps x 18.0mm				85	17.0	
300	28.4	3 Crimps x 18.0mm	1 Crimp x 50.0mm	85	17.0			
400	39.0		2 Crimp x 25.0mm	1 Crimp x 50.0mm	10 (25T)/13 (60T)	70	17.0	
500	43.2				1 Crimp x 50.0mm	13	70	17.0
630	43.2				1 Crimp x 50.0mm		70	17.0

(* 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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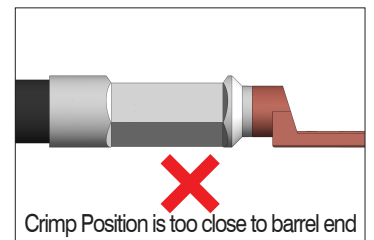
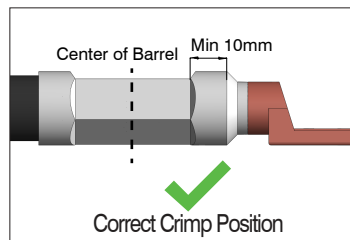
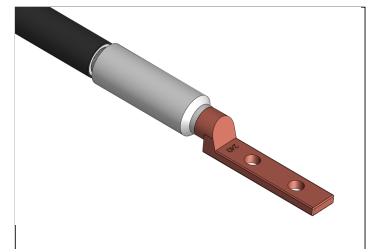
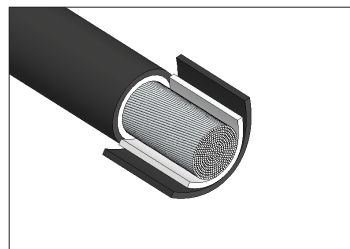
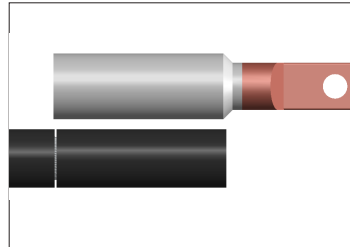
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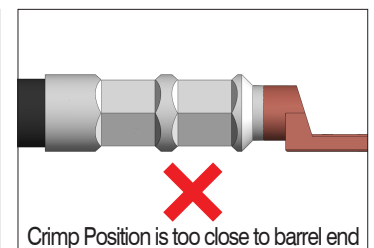
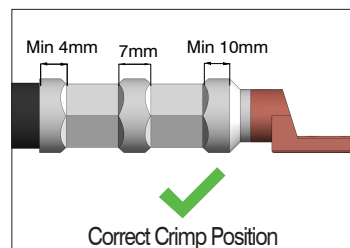
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ALI-FLEX® Long Palm Bi-Metallic Lug Installation Guide

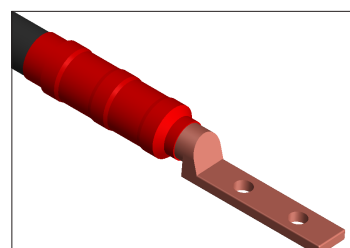
- 1.** Select a suitable size of **ALI-FLEX® Long Palm Bi-Metallic Lug** by verifying that the conductor size marking on the lug and cable match. **Drill out the necessary holes on the palm.** Mark stripping length on cable as specified on the B27 Selection Table.
Mark stripping length on cable as specified on the B27 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 B27 Selection Table (12-13 Tonne, 25 Tonne or 60 Tonne). Choose the appropriate Aluminium die by referring to the correct A/F (across flats) die size on the B27 Selection Table. The correct A/F size is also printed on each B27 lug. **Please note that the mm² cable size markings on AF dies from brands other than TriCab, have no relationship to the mm² 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 B27 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 B27 Selection Table. Do not crimp closer than 10mm 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 4mm 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 **ALI-FLEX® G03 Glue Lined Heatshrink** to complete the crimping. The heatshrink should cover the entire Aluminium barrel and approximately 50mm of the cable jacket.



Single Crimped Method



Multiple Crimped Method



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