

B36

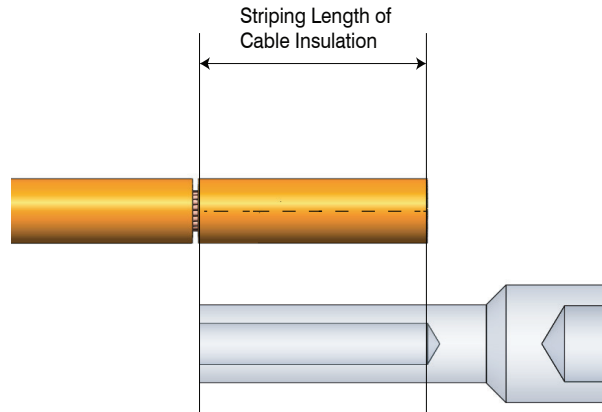
Copper Reducing Links Installation Guide

1. Select suitable size of **B36 Copper Reducing Link**

Double check by verifying the markings of copper conductor size on cable and link.

Mark stripping length on cable is specified in the Table 1.

Cut the sections marked with dashed lines in the figure.



2. 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.



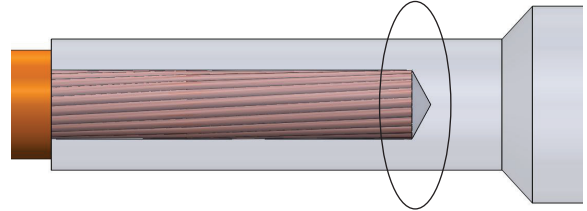
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- 4.** Carefully insert the copper conductor into the end of the copper barrel.

Do not twist the conductor.

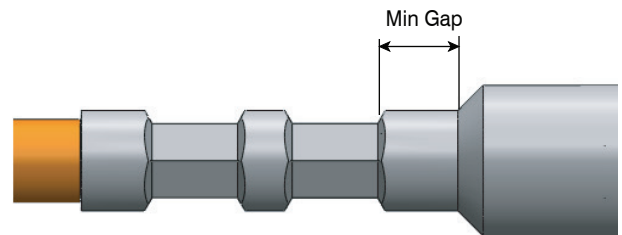


- 5.** Select a suitable crimping tool and die with correct A/F size and crimp force as per specified in the Table 1 below.

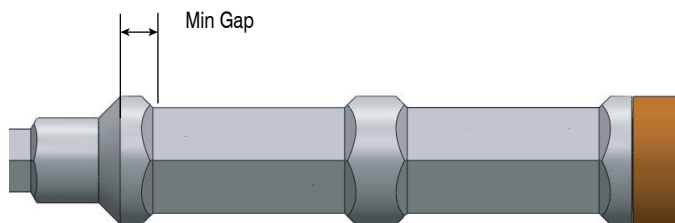
For hydraulic hex crimper, place the link on the top die and allow the other die to move up to crimp. Adjust the link to have a gap (shown in Table 1) between the crimp position and the copper barrel end.

Crimp until the full cycle is completed. Ensure that the dies are fully closed for sufficient crimping force.

Release ram and repeat the process if more than 1 crimp is required (Refer to Table 1).

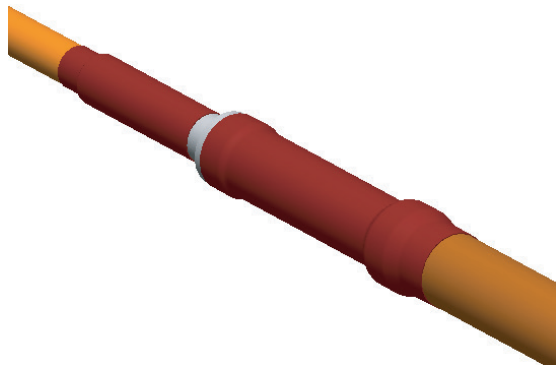


- 6.** Refer to Table 2 and repeat the Step 1 - 5 for the larger side.



- 7.** Check crimping result. Use filer if necessary to remove burrs to have a smooth crimp surface.

Apply suitable **G01 Thin Walled Heat-shrink** to complete the crimping.



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Table 1. Crimping Guide

Conductor Size	Copper Crimping Die			Stripping Length of Cable Insulation	Min Gap between Crimp Position and Copper Barrel End
	Die A/F	No. of Crimp x Crimp Face Length*			
		Hydraulic Tool - Hexagonal Die			
mm ²	mm	12-13 Tonne	60 Tonne	mm	mm
10	5.7	1 Crimp x 6.4mm	Use Adaptor and Standard 12 Tonne Die	21	7
16	6.3	1 Crimp x 17.5mm		21	7
25	7.7	1 Crimp x 17.5mm		21	7
35	9.2	1 Crimp x 17.5mm		24	10
50	10.4	1 Crimp x 17.5mm		24	10
70	11.5	1 Crimp x 17.5mm		40	8
95	14.2	1 Crimp x 17.5mm		40	8
120	16.5	2 Crimps x 14.0mm		40	8
150	18.3	2 Crimps x 14.0mm		40	8
185	20.0	2 Crimps x 14.0mm		55	12
240	23.1	3 Crimps x 10.0mm		55	12
300	26.0	3 Crimps x 10.0mm		1 Crimp x 25.0mm	55
400	28.1		1 Crimp x 25.0mm	55	12
500	31.0		1 Crimp x 25.0mm	55	12

(*) 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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