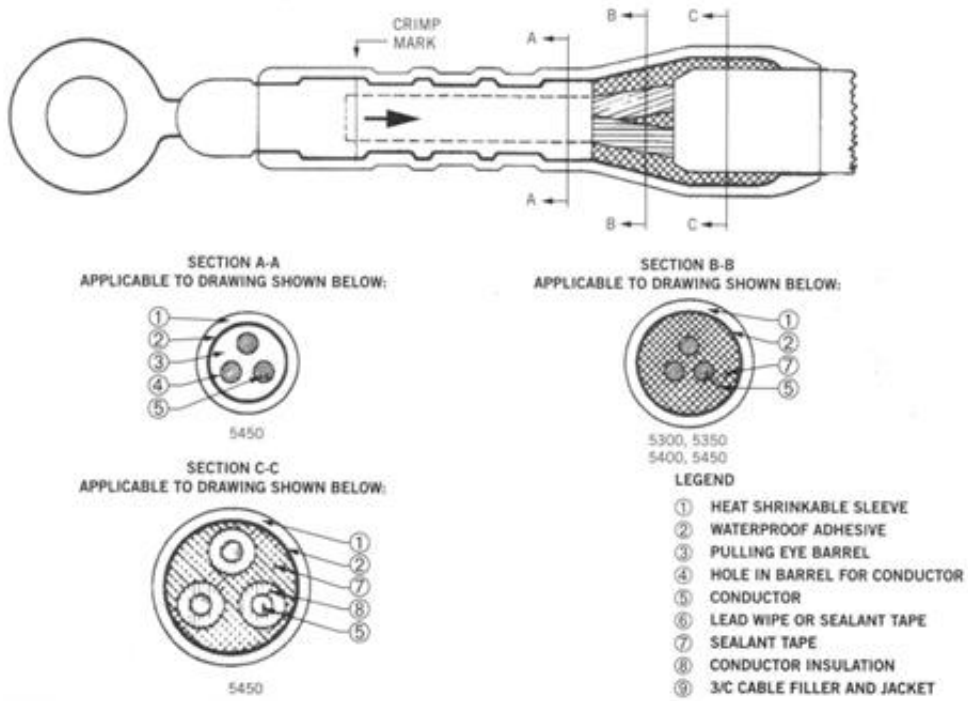


## ASSEMBLY INSTRUCTIONS - SOLID DIELECTRIC CABLES

1. Strip cable to **"Stripping Distance" (SD)** shown in table.
2. Pencil insulation of individual conductors at a 30° angle or less.
3. Insert and bottom one conductor into Pulling Eye and mark the insertion on each conductor.
4. Apply waterproofing cement to all bared conductors from the mark {Step #3} back over the penciled insulation, and two inches over 1/C cable insulation. On Multi-conductor Cables, apply cement over just the cut end of Cable.
5. Wrap all cemented areas of each cable with one half-lapped turn of sealant tape. On Multi-conductor Cables, insert a rounded strip of sealant tape between the conductors.
6. Insert conductors into Pulling Eye until bottomed. When Pulling Eye has a common barrel for ail conductors, bunch the conductors together, using a hose clamp if necessary, until they can be pushed into the barrel. Once the conductors have been started into the barrel, tap the eye with a brass or leather hammer to bottom the conductors.

### ALCOA DIES 60 TON PRESS

| ALCOA | UII | MATERIAL DIAMETER |
|---|---|---|
| 6012SH (aka 6011AH) | 76 | 1" |
| 6020AH | 99 | 1 1/4" |
| 6024AH | 115 | 1 1/2" |
| 6027AH | 140 | 1 3/4" |
| 6030AH | 160 | 2" |
| 6034AH | 189 | 2 1/4" |
| 6040AH | 204 | 2 1/2" |
| Custom Die Size | 243 | 3" |

7. Crimp, with press rated at least 60 tons for all die sizes. Use applicable die as determined from the die selection chart. Start crimps at the circumferential crimp mark and proceed with crimps in the direction shown by the arrow over "Crimping Distance" (C) shown in table. **Overlap crimps or space them not more than one quarter inch apart.** Make last crimp overlap the end of Pulling Eye by 1/4 to 1/2 the width of Crimping die. Sand or grind the extruded portion as necessary. Do not hammer to flatten this area.

8. Apply waterproofing cement generously to end of Pulling Eye, exposed surfaces of sealant tape, and on 3/C cable, back two inches over outer jacket. Fill each of the grooves with strips of sealant tape to form a cylindrical shape. On Multi-conductor Cables, build up the intervening space between the cut cable jacket and pulling eye with turns of sealant tape to form a cylindrical shape, extending over outer jacket.
9. Install Heat Shrinkable Sleeve by placing one end over the "factory" crimp mark (nearest the "eye"). The Heat Shrinkable Sleeve must be long enough to extend two inches beyond the sealant tape over the cable insulation or jacket. Apply heat source to sleeve by slowly moving back and forth all around the circumference, starting at sleeve center and moving towards "eye" end first, until waterproofing adhesive oozes out end of sleeve. Shrink other half of sleeve similarly.