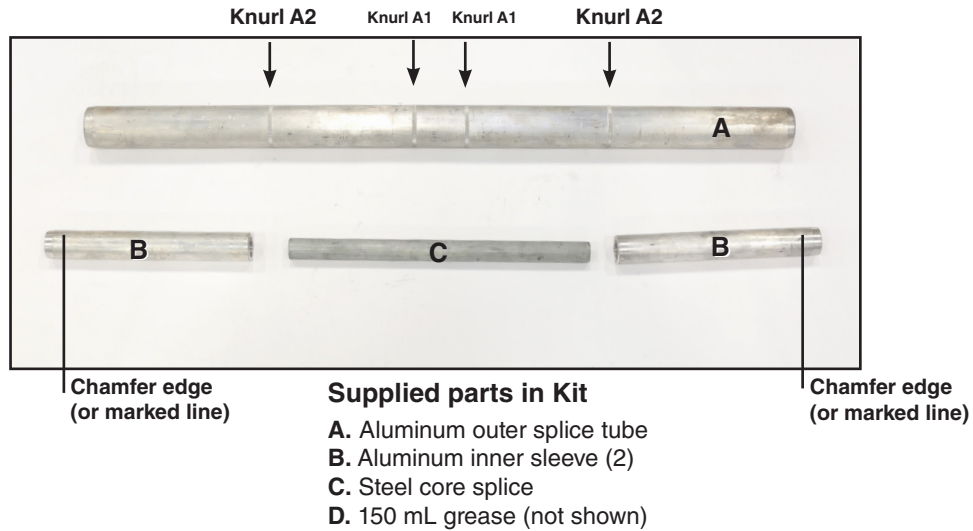




# Compression Splice Assembly for ACFR Conductor

Be sure to read and completely understand this procedure before applying product.  
Be sure to select the proper size PREFORMED™ product before application.



**Chart A - Compression Die Information**

Conductor	Compression Die for Aluminum Components	Compression Die for Steel Components
ACFR 182/28-FA-TT	43.0 A/F	24.5 A/F
ACFR 237/37-FA-TT		25.4 A/F
ACFR 245/37-FA-RR		24.6 A/F
ACFR 267/37-FA-TT		25.4 A/F
ACFR 281/37-FA-TT		
ACFR 302/37-FA-RR		
ACFR 312/37-FA-TT		
ACFR 325/37-FA-TT	56.5 A/F	26.0 A/F
ACFR 470/56-FA-TT		
ACFR 492/56-FA-TT		
ACFR 540/56-FA-TTT		
ACFR 679/56-FA-TTT		
ACFR 665/71-FA-TTT		

### Step #1

Measure and mark 203 mm (8") from the end of one of the conductors to be spliced. Apply tape just past the mark to secure outer strands during the cutting procedure in Step 2.



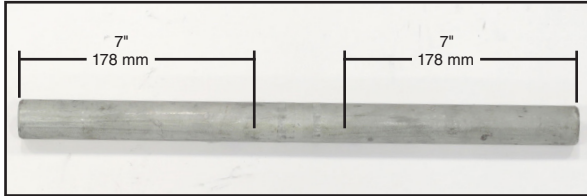
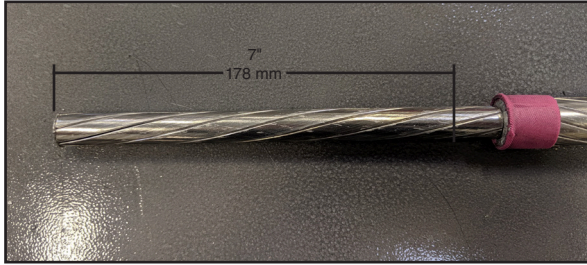
### Step #2

Using a conductor cutting tool, remove the outer strands of aluminum up to the 203 mm (8") mark. The innermost layer of aluminum strands should not be removed, but it is acceptable if these are scored by the cutting tool.



**Step #3**

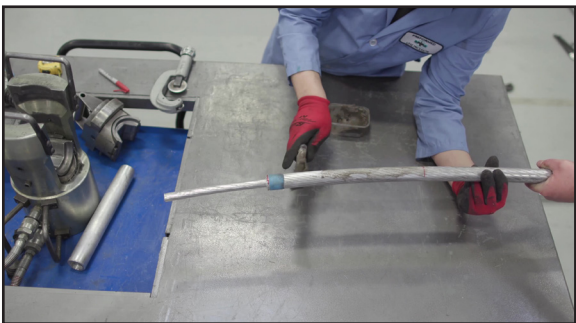
Measure and mark 178 mm (7") from the end of the conductor, and from each end of the steel core splice.

**Step #4**

With an aluminum inner sleeve held 9.5 mm (3/8") from the end of the outer aluminum strands, mark the length to the end on the conductor.

**Step #5**

Using a wire brush, clean the conductor up to the mark made in the previous step. Apply the supplied grease evenly to this entire area.

**Step #6**

Slide the aluminum outer tube onto the conductor, past the mark made in Step 4.

**Step #7**

With the tapered end facing the conductor, slide the inner sleeve up to the mark made in Step 4. Then clean the sleeve and apply grease evenly to the outer surface.

**Step #8**

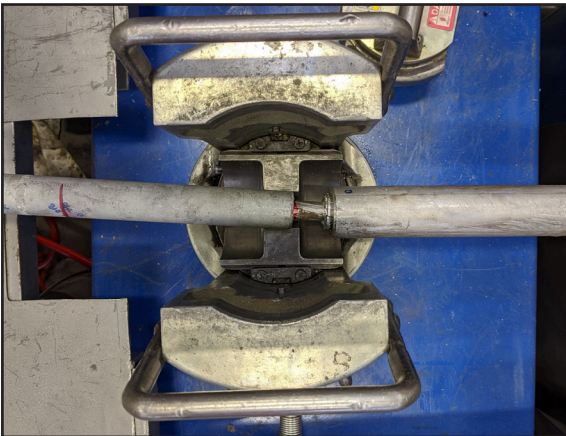
Slide one end of the core splice onto the conductor up to the 178 mm (7") mark made in Step 3.



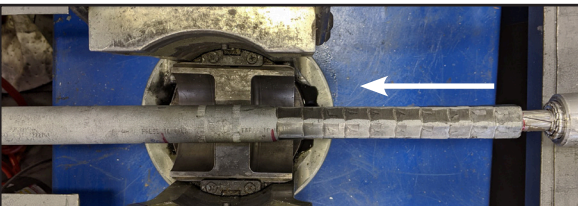
**Step #9** Install the appropriate compression die (see Chart A) for the steel core splice into a 60-ton or 100-ton press. Lubricate the dies and the area of the core splice to be compressed.



**Step #10** Align the end of the core splice with the chamfer in the compression die and ensure that the splice is straight within the die and level with it. Do not push or pull on the splice while compressing.



**Step #11** Begin compressions at the end of the steel core splice and continue up to the stop mark made at 178 mm (7"). Recommended overlap between compressions is 50% in order to avoid curvature of the tube.



**Step #12** Complete steps 1 – 5 and 7 for the other conductor to be spliced, and then slide the end into the core splice up to the 1748 mm (7") mark.



**Step #13** As with the other conductor, begin compressions at the end of the steel core splice and continue up to the stop mark made at 178 mm (7").

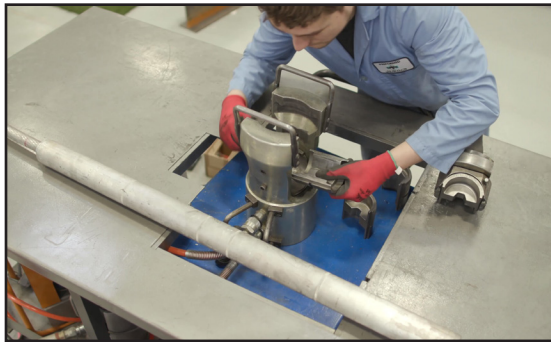


**Step #14** Check the A/F (Across the Flat) measurement to confirm correct compression (example 260SH100 has an A/F of 26.0 mm).

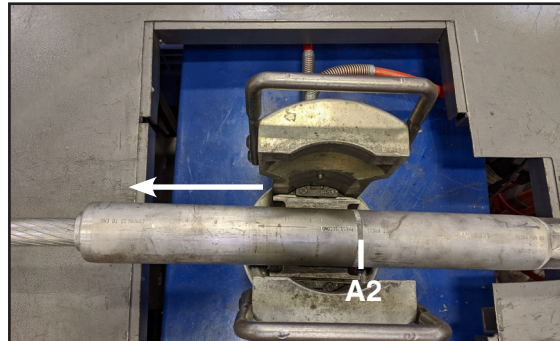
**Step #15** Slide the outer tube over the inner sleeves and realign the inner sleeves with the marks made on the conductor if necessary.



**Step #16** Install the appropriate compression die for the outer aluminum tube (see Chart A). Lubricate the dies and areas to be compressed.

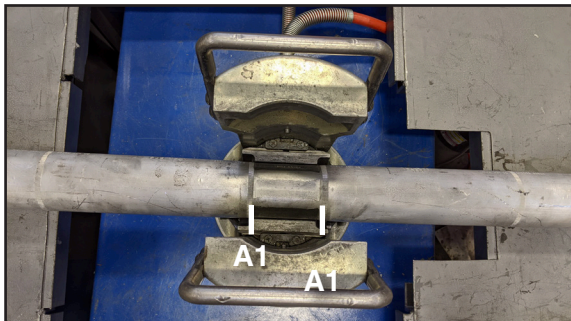


**Step #18** Continue making compressions starting from one of the "Press Second" knurl marks and working to the end of the outer tube. Recommended overlap between compressions is 50% in order to avoid curvature of the tube. Do not apply any load on the tube while compressing.



Press Second

**Step #17** Ensuring that the outer tube is straight within the die and level with it, make one compression between the two knurl marks in the middle of the tube.



**Step #19** Repeat this compression procedure for the other side of the outer tube. Check the across the flats measurement (A/F) to confirm correct compression (example 565AH100 has an A/F of 56.5 mm). Installation of the splice assembly is complete



## SAFETY CONSIDERATIONS

This application procedure is not intended to supersede any company construction or safety standards. This procedure is offered only to illustrate safe application for the individual. **FAILURE TO FOLLOW THESE PROCEDURES MAY RESULT IN PERSONAL INJURY OR DEATH.**

This product is intended for a single (one time) use and for the specified application. **Do not reuse or modify this product under any circumstances.**

This product is intended for use by trained technicians only. **This product should not be used by anyone who is not familiar with, and not trained to use it.**

When working in the area of energized lines, extra care should be taken to prevent accidental electrical contact. Be sure to wear proper safety equipment per your company protocol.

For proper performance and personal safety, be sure to select the proper size PREFORMED™ product before application.

PREFORMED products are precision devices. To ensure proper performance, they should be stored in cartons under cover and handled carefully.



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