

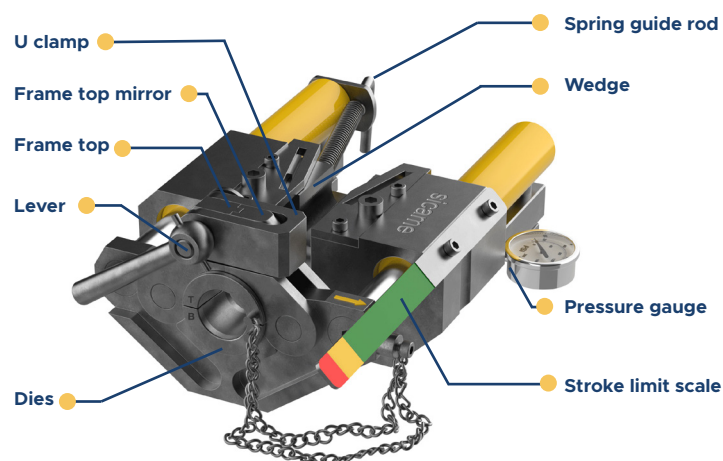
Dead end clamp with Swage Drawing Technology (SDT)

Installation instruction: IN-GLS-DEC-SDT-240312 - B

Collect the required parts

 Dead end clamp		
 Swage Drawing Tool	 Dies	 Hand gloves
 HT grease	 Lubricating agent	 Marker
 Cutter	 Measuring tape	 Synthetic brush
 Stainless steel brush	 Emery paper	 Vernier caliper

Swage Drawing Tool



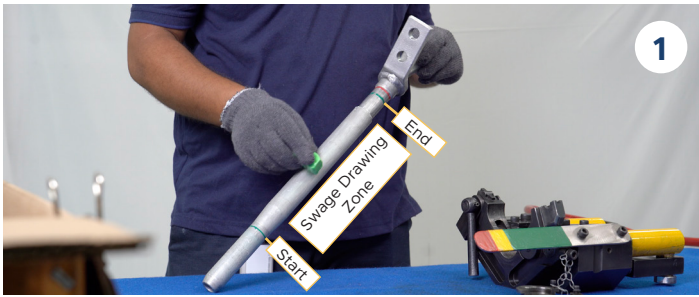
ATTENTION !

- Ensure that the internal surfaces of the dies are cleaned, using the stainless steel wire brush if necessary
- Ensure all the hydraulic hoses are connected intact

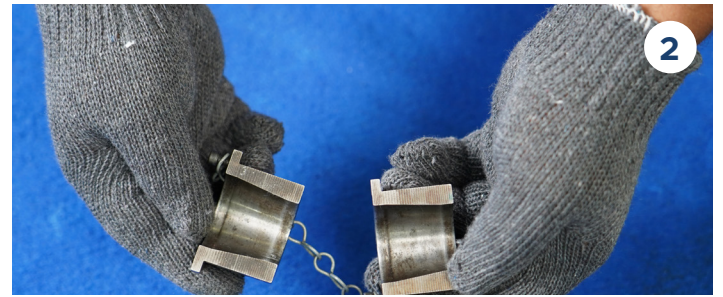


Think Safety: The manufacturer's maximum safety limit for load rating is 500 kg/cm². Ensure that the stroke length does not exceed the green marking on the tool.

B	06-03-24	Steps and SDT tool diagram added	JPR	VIJ
A	20-12-23	Creation	JPR	VIJ
Rev	Date	Description	Prepared by	Chk & app by



Apply lubricant to the green-marked swage drawing zone on the outer surface of the dead-end clamp sleeve.



Before applying the lubricating agent, ensure that the inner surface of the dies is clean and free from any aluminium deposits. This is important to prevent failures or dead-end clamp bending during swaging.



Apply lubricating agent on inner surface of Die halves.



Mark the length with a measuring tape in accordance with the table below to grease the conductor.

Sl. No	Conductor Code	Dia of Cond.	Greasing length
1	ACCC DAMAN	Ø 14.15mm	360mm
2	ACCC VADODARA	Ø 11.96mm	360mm



Apply the high-temperature grease around the conductor in the marked zone.



Brush the HT grease gently on conductor by using the stainless-steel wire brush.



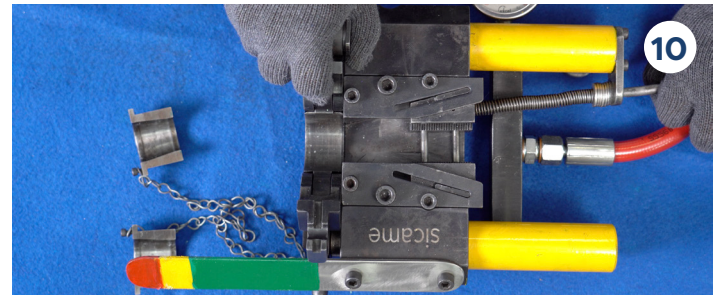
Remove the insulation tape from the end of the conductor and gently apply HT grease to the surface area.



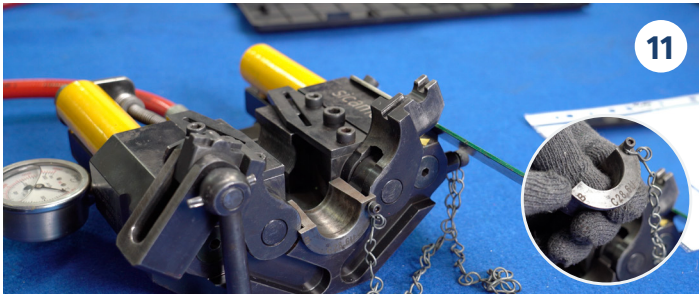
Ensure HT grease is applied around the conductor surface.



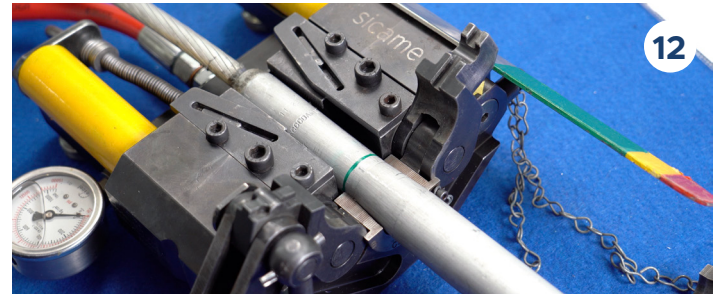
Insert the conductor into the dead end clamp up to the mark indicated in Step 4. Do not rotate the conductor to avoid birdcaging the aluminum strands.



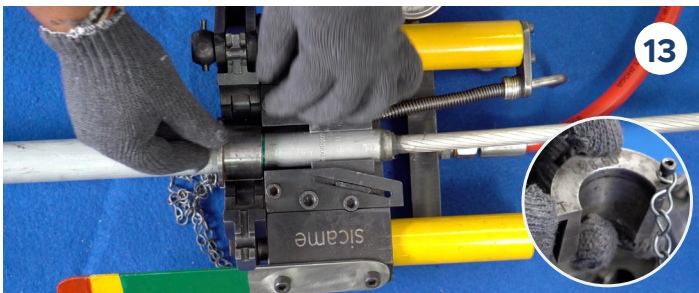
To place the die and dead end clamp, unlock the lever and spring guide rod in the swage drawing tool.



Fix the bottom half of the die (Marked as "B" on Die) on Swage Drawing tool appropriately.



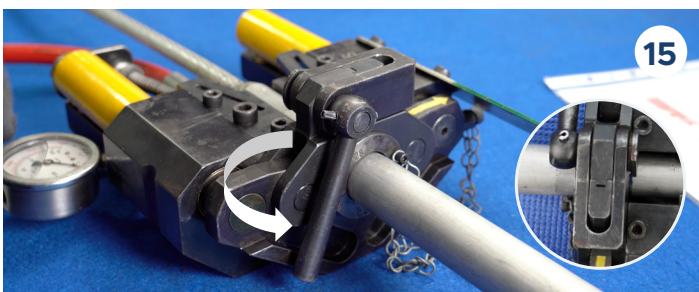
Fix the dead-end on swage drawing tool. Lock the wedges by using the spring guide rod.



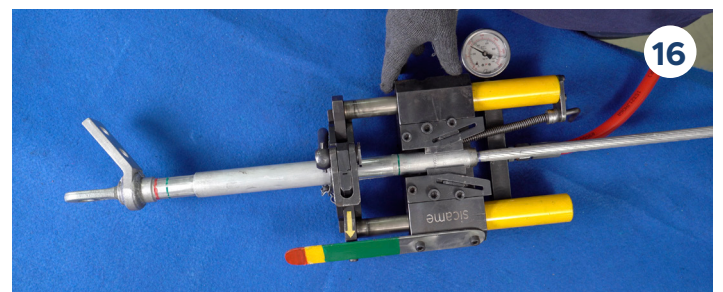
Fix the top half of the die appropriately (Marked as "T" on Die). Ensure the marked taper portion of dead-end clamp is placed on dies.



Lock the die and dead end clamp in Swage Drawing Tool by rotating the lever towards anti-clock direction.



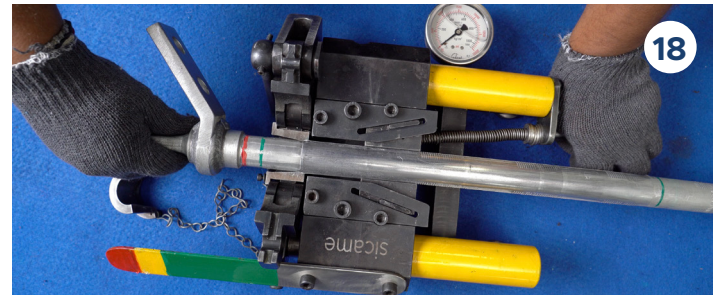
Rotate the lever until it stops to ensure proper closure of the dies. Align the frame top, frame top mirror, and U-Clamp parts as shown in the figure.



Begin drawing and complete the first stroke using the recommended stroke motion until the green color ends on the tool's stroke limit scale. While swaging, monitor the pressure gauge and ensure that it remains within the safety limit of $< 500 \text{ kg/cm}^2$.



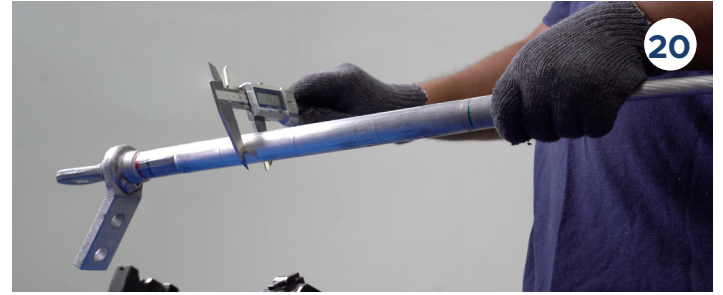
Repeat step 16 and swage until the green color marking (Swage drawing Zone) on the Dead end clamp. Do not exceed the swaging beyond the red color marking in the dead end clamp to avoid damage to the pad or welding.



To remove the dies and releasing wedges, unlock the lever and spring guide rod. Then, remove the swaged dead end clamp.



Clean the surface using Emery paper.



Verify that the achieved sleeve diameter meets the diameter requirement indicated in the drawing.