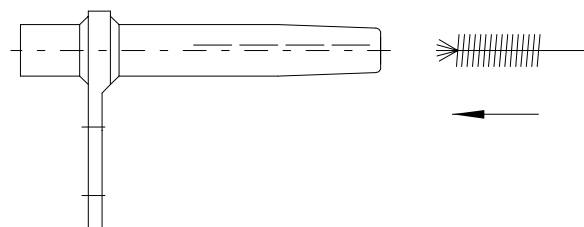


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1. Make sure the clamp matches the conductor.
2. If the aluminium tube of the dead end clamp is filled with grease, proceed with Nr. 4.  
If not, brush the inside of the tube with a circular steel brush (brush diameter bigger than the inner tube diameter) and clean it with cotton waste (Picture 1).  
Proceed immediately with Nr. 3 (max. 30 seconds).

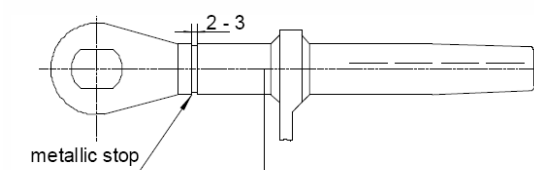


**Picture 1**

3. Put contact grease on the inner surface of the aluminium tube of the dead end clamp by using a tube brush. The brushed area must be completely covered with grease.  
Then fill the tube with contact grease.

4. Straighten the conductor.

5. If the clevis or eye connection is already compressed on the aluminium tube, proceed with Nr. 8.  
If not, push the clevis or eye connection into the aluminium tube until a gap of 2 to 3 mm remains between the tube end and the metallic stop (Picture 2).



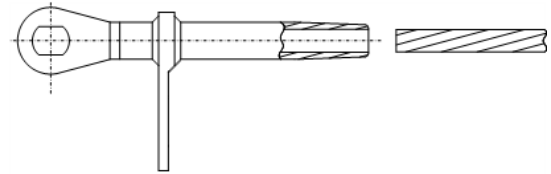
**Picture 2**

6. Align the clevis or eye connection with the jumper tongue (Picture 2.)
7. Compress the aluminium tube of the dead end clamp with the compression tool specified on the drawing. The section between the clevis or eye connection and the jumper tongue shall be compressed continuously and overlapping as marked on the sleeve (Picture 2). See Nr. 25 to check the compression.
8. Brush the surface of the aluminium conductor with a steel brush at a length corresponding to that of the aluminium tube and clean it with cotton waste.  
Proceed immediately with Nr. 9 (max. 30 seconds).

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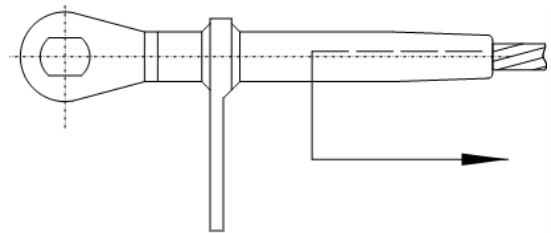
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9. Push the greased aluminium tube of the dead end clamp with the conically shaped sleeve end over the end of the conductor until it butts up against the end of the clevis or eye connection (Picture 3). Make sure the conductor is pushed inside the tube as far as possible.



**Picture 3**

10. Compress the aluminium tube of the dead end clamp with the compression tool specified on the drawing. The area between the jumper tongue towards the conductor shall be compressed in the order of the compression marks on the aluminium tube, starting from the tongue and moving towards the tube end (Picture 4). See Nr. 25 to check the compression.



**Picture 4**

11. The Jumper tube (aluminium tube with flat terminal) must be prepared as follows. If the tube is filled grease, proceed with Nr. 13.  
If not, brush the inside of the tube with a circular steel brush (brush diameter bigger than the inner tube diameter) and clean it with cotton waste.  
Proceed immediately with Nr. 12 (max. 30 seconds).

12. Put contact grease on the inner surface of the jumper tube by using a tube brush. The brushed area must be completely covered with grease.  
Then fill the tube with contact grease.

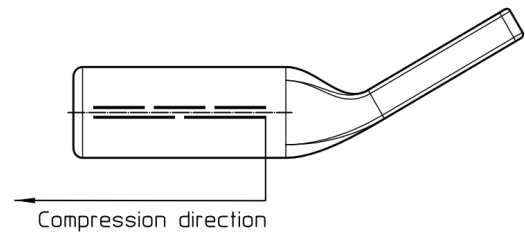
13. Brush the surface of the jumper conductor with a steel brush at a length corresponding to that of the jumper tube and clean it with cotton waste.  
Proceed immediately with Nr. 14 (max. 30 seconds).

14. Push the jumper conductor into the greased jumper tube until it butts up against the end of the tube. Make sure the conductor is pushed inside the tube as far as possible.

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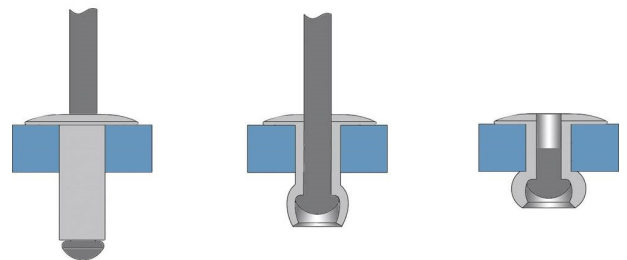
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15. Compress the jumper tube with the compression tool specified on the drawing. The jumper tube shall be compressed in the order of the compression marks on the tube, starting from the tongue and moving towards the tube end. See Nr. 25 to check the compression.



**Picture 5**

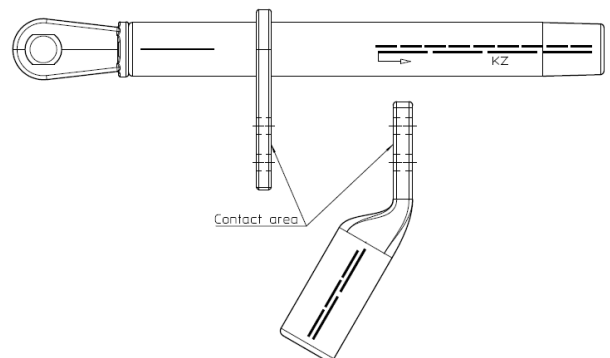
16. If there is no pre-drilled hole in the aluminium tube of the dead end clamp, Nr. 16 and Nr. 17 can be skipped. If there is a pre-drilled hole, inject the contact grease through the hole, until the hollow space is completely filled.



**Picture 6**

17. Insert a POP IMEX rivet into the hole and apply steady pressure to the handle of the riveting tool until the mandrel breaks and the hole is sealed (Picture 6).

18. Clean the contact areas of the bolted connection between the jumper tube and the compression dead end clamp with a steel brush and clean the areas with cotton waste (Picture 7). Proceed immediately with Nr. 19 (max. 30 seconds).



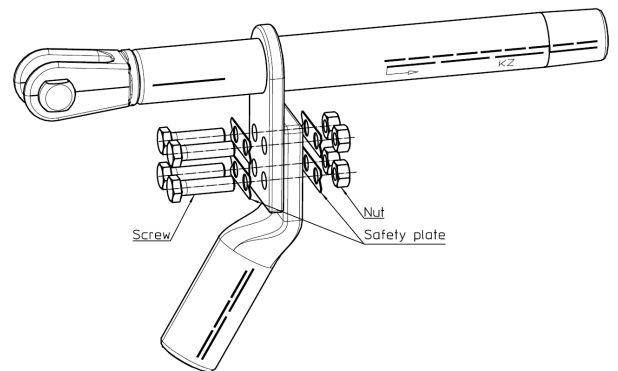
**Picture 7**

19. Grease both contact areas with the contact grease (Picture 7).

20. Determine whether the product is delivered with safety plates or spring washers.  
If the product is delivered with safety plates, continue with Nr. 21 and Nr. 22, and ignore Nr. 23.  
If the product is delivered with spring washers, ignore Nr. 21 and Nr. 22, and continue with Nr. 23.

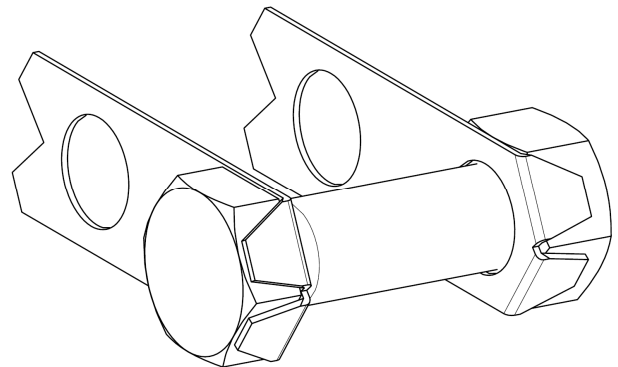
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21. Turn the screws in the tightening direction to align the two side faces of the screw head with the two flaps of the safety plates. Tighten the M12 nuts to the bolts with 75 Nm (Picture 8).



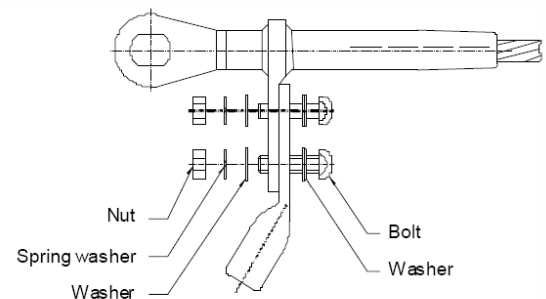
**Picture 8**

22. Bend the two flaps of the safety plates with a flat screwdriver or similar tool towards the screws and nuts can no longer turn (Picture 9).



**Picture 9**

23. Insert the bolts with washers and spring washer and tight the M12 nuts with 75 Nm (Picture 10).



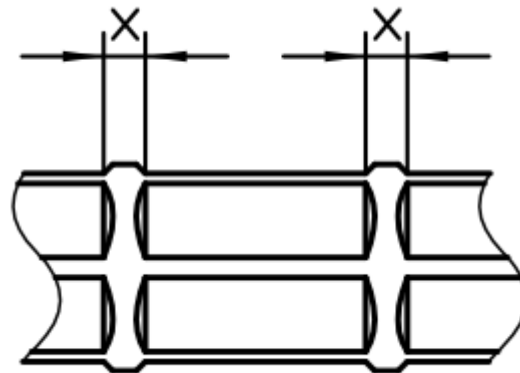
**Picture 10**

24. If necessary, remove sharp edges with a double-cut file or sandpaper.

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25. Check the compression as follows:
- a. Verify that the right die was used according to the drawing.
  - b. Verify that the dies closed completely and that the maximum pressure of the compression head was reached during compression
  - c. Verify that the number of compressions matches the number of compressions on the drawing.
  - d. Verify that the distance between the compressions is equal to or greater than the distance indicated on the drawing (Picture 11).



Picture 11

**Important:**

The brushing, cleaning and immediate greasing of the aluminium surfaces is crucial to remove the oxide layer and to ensure a reliable electric contact.

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