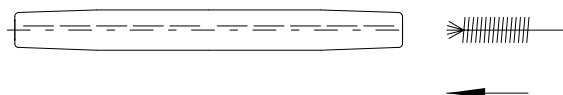


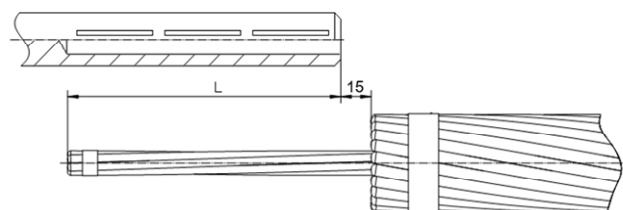
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COMPRESSION MIDSPAN JOINT FOR ACSR CONDUCTOR	

1. Make sure the clamp matches the conductor.
2. If the aluminium tube of the midspan joint 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).
3. Put contact grease on the inner surface of the aluminium tube by using a tube brush. The brushed area must be completely covered with grease. Then fill the tube with contact grease.



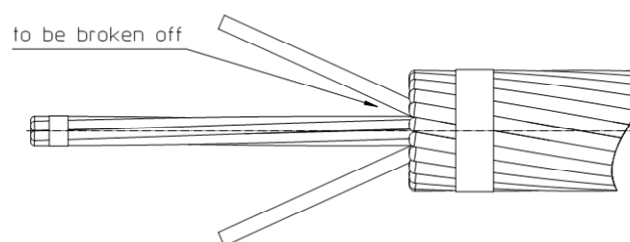
Picture 1

4. Straighten the conductor.
5. Marking of the length to be stripped. The stripping length shall correspond to the length of the hole of the steel sleeve plus approx. 15 mm (Picture 2). For conductors > Ø 40 mm the length can be plus 25 mm.



Picture 2

6. Fix the aluminium strands with a cable tie close to the mark (Picture 2). Cut off the aluminium strands perpendicular to the conductor axis using the stripping tool "RIGID". When cutting off the aluminium layers of the conductor, take care of the strand of the last layer. This strand shall not be completely cut through. These strands have to be broken off to avoid damaging the core layer or the steel core. Deburr the cut edges if necessary (Picture 3).



Picture 3

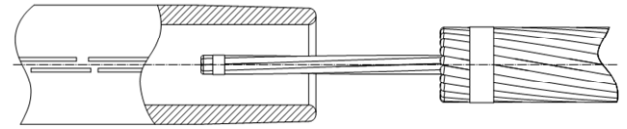
7. Clean the steel core with cotton waste and check that the steel strands are not damaged.
8. Brush the surface of the aluminium conductor with a steel brush at a length corresponding to that of the aluminium tube and clean it with cotton waste. Proceed immediately with Nr. 9 (max. 30 seconds).

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COMPRESSION MIDSPAN JOINT FOR ACSR CONDUCTOR

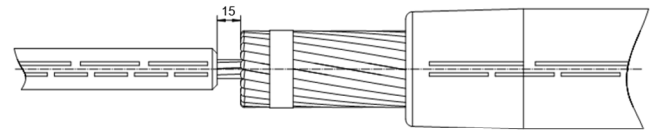
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9. Push the greased aluminium tube of the midspan joint with the conically shaped sleeve end over the end of the conductor (Picture 4). If a cable tie is used, it will be pushed back along the conductor.



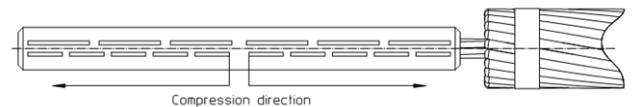
Picture 4

10. Insert the steel core of the conductor into the steel sleeve and push in the core, until the gap between the edge of the steel sleeve and the aluminium strands is approx. 15 mm (Picture 5). For conductors $> \varnothing 40$ mm the gap can be up to 25 mm.



Picture 5

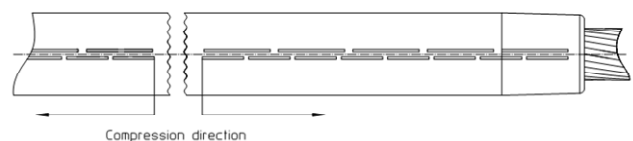
11. Compress the steel tube with the compression tool specified on the drawing. The compression shall be made in the order of the compression marks, starting at the side of the fixing point of the clamp and moving towards the end of the tube (Picture 6). The number of compressions are marked on the steel sleeve. See Nr. 18 to check the compression.



Picture 6

12. Push the aluminium tube of the midspan joint back, that the steel sleeve is exactly located in the middle.

13. Compress the aluminium tube of the midspan joint with the compression tool specified on the drawing. Compress in the order of the compression marks on the aluminium tube, starting from the inside and moving towards the tube end (Picture 7). See Nr. 18 to check the compression.



Picture 7

14. Repeat step 1 to 13 on the opposite side for the second conductor

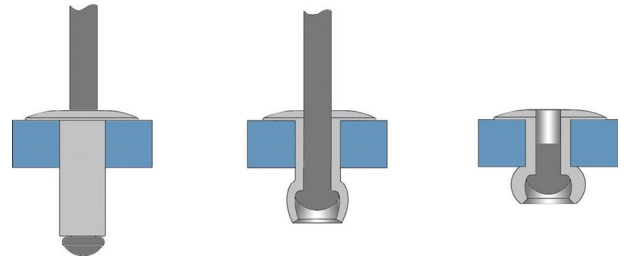
15. If there is no pre drilled hole in the aluminium tube of the midspan joint, Nr. 15 and Nr. 16 can be skipped.
If there is a pre drilled hole, inject the contact grease through the hole, until the hollow space is completely filled.

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16. 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 8).

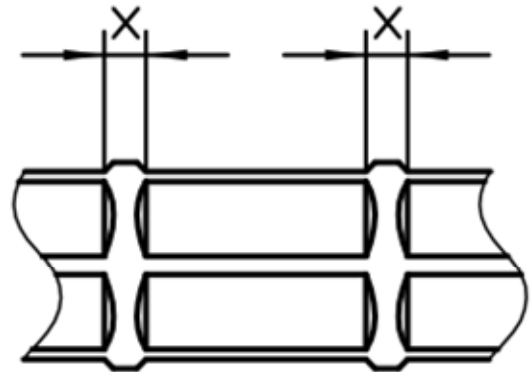


Picture 8

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

18. Check the compressions as follow:

- 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 9).



Picture 9

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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