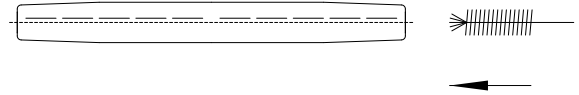


## ASSEMBLY INSTRUCTIONS

# COMPRESSION MIDSPAN JOINT FOR AAC & AAAC CONDUCTOR

## AI 038

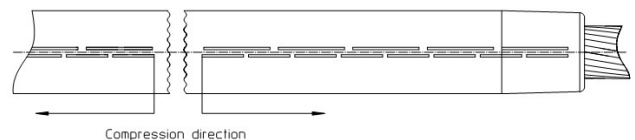
1. Make sure the clamp matches the conductor.
2. If the aluminium tube of the midspan joint is filled with grease, proceed with Nr. 4. If not, brush the inside of the tube with a circular steel brush (brush diameter bigger than the inner tube diameter) and clean it with cotton waste (Picture 1). Proceed immediately with Nr. 3 (max. 30 seconds).
3. Put contact grease on the inner surface of the aluminium tube of the midspan joint 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. 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. 6 (max. 30 seconds).
6. Push the greased aluminium tube of the midspan joint with the conically shaped sleeve end over the end of the conductor, that the end of the conductor is exactly located in the middle (Picture 2).
7. 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 3). See Nr. 12 to check the compression.
8. Repeat step 1 to 7 on the opposite side for the second conductor.
9. If there is no pre-drilled hole in the aluminium tube of the midspan joint, Nr. 9 and Nr. 10 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 1



Picture 2

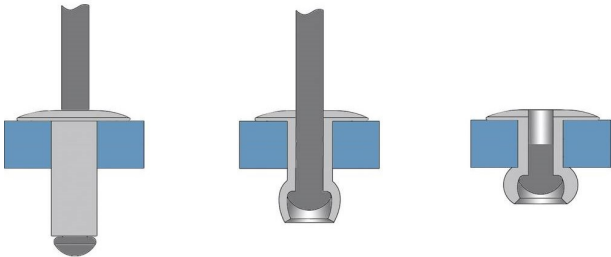


Picture 3

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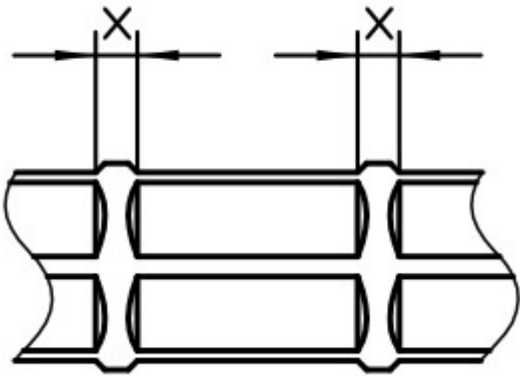
10. Insert a POP IMEX rivet into the hole and apply steady pressure to the handle of the riveting tool until the mandrel breaks and the hole is sealed (Picture 4).



Picture 4

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

12. 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 5).



Picture 5

**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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