

INSTALLATION INSTRUCTIONS CONVENTIONAL COMPRESSION SPLICES FOR ACSR CONDUCTORS

The conventional compression splice assembly consists of a steel sleeve and an aluminum splice body. Both parts are marked with die size, manufacturing date code and FARGO and catalog number. Aluminum body marks also include conductor type and size.

1. Prior to installation the conductor must be clean, straight and in lay. Any bend in conductor section to be spliced will tend to make the splice body bow during compression.
2. Conductor tensioning grips must be of a size and type approved by the conductor manufacturer.
3. Remove the protective plastic and end caps. Be sure the bores of the fittings are clear of foreign matter. Do not remove any of the grit coating inside the steel barrel. Insert the conductor into the tapered end of the aluminum splice body and slide the splice body over the conductor, allowing working room to install the steel splice sleeve on conductor core.
4. Cut-mark the aluminum strands at a distance, from conductor ends, equal to the depth of the bore in the steel sleeve plus $\sim 3/4"$ to allow for elongation of the steel sleeve barrel during compression. Tape wrap the aluminum strands on the span side of the cut mark. Expose the steel core by removing the aluminum strands to the cut mark. **Do not nick the steel strands while cutting away the aluminum strands.**
5. Mount the SH die set, specified on steel sleeve barrel, in press. Lubricate die faces and steel sleeve half to be compressed first with die lubricant stick or clean oil. Insert conductor core into the steel sleeve until it bottoms in the sleeve bore. With sleeve seated in one die half, make the first compression at the knurl mark on sleeve side with conductor core inserted. Continue compressions out to sleeve end. Overlap crimps slightly - to prevent the formation of ridges between adjacent crimps. Assure complete die closure with each crimp. Keep the steel sleeve straight during compression by keeping steel barrel lubricated and fully seat in one die half as dies close. A BOWED STEEL SLEEVE WILL BOW THE CONDUCTOR JOINT AND MAY PREVENT THE ALUMIMUNM BODY FROM SLIDING INTO PLACE. - Repeat the process to compress opposite side conductor core into the steel sleeve.
6. Mark conductor compression length, on both sides of the steel sleeve center, at a distance equal to half the length of the aluminum splice. Add a second set of marks, for centering the aluminum body, 4" beyond the compression zone marks.
7. With a clean stainless steel wire brush (V-brush type recommended), **aggressively brush** the conductor crimp zone on the joint side where the aluminum splice body is parked, up to the tape wrap holding strand ends in lay. Immediately apply a generous coat of **FARGO Joint Compound (Type UJC or HTJC)** over the just brushed conductor strands. Slide the aluminum splice body over the compound-coated area to near the tape-wrapped conductor end. Remove tape wrap. Wire brush the exposed end strands and immediately coat with HTJC.

CONTINUED ON REVERSE

8. **Aggressively brush** the strand ends, just beyond tape wrap, of the conductor on the second joint side and coat that small area with HTJC. Slide the aluminum body until it captures the first ¼" of the compound-coated conductor end. Remove tape wrap and aggressively brush the remaining crimp zone on second conductor side. Immediately apply a generous coat of UJC or HTJC over the just brushed conductor strands.
9. Slide the aluminum splice body over the steel sleeve until it is centered between the marks applied in step 6. Remove and set aside the splice body filler port plug.
10. With a caulking gun, inject **FARGO Joint Compound (UJC or HTJC)**, through the filler port, until compound begins to flow out between the aluminum body and conductor at one end of the splice. (See table below for approximate amount of compound required per splice). Hammer the aluminum plug / pin into the filler hole. Cut, or file, off any excess length of pin and peen end flush with aluminum barrel.
11. Mount the AH die set specified on the aluminum splice body in press and lubricate die faces and crimp zone with die lubricant stick, clean oil or clean plastic bag material. (If plastic used as lubricant, ensure that it wraps completely around the splice tube, fully covering both die face during each compression). Firmly seat the splice body in one die half and make the first compression at the knurl mark on first splice side. Make a second overlapping compression on first splice side. Move press to knurl mark on opposite splice side and make two overlapping crimps there.
12. At this point in the process (Steel sleeve fully crimped on core and two overlapping crimps on each side of Aluminum splice body), MINIMUM tension may be applied to remove conductor slack and help keep splice body straight during the remaining compressions.

NOTE: DO NOT CRIMP SPLICE IN THE REVERSE DIRECTION

13. Re-lubricate die faces and span-end crimp zones. Continue with overlapping compressions to the ends of the splice. Keep the compression zones well lubricated and keep aluminum body seated in one die half as dies close.
14. As compressions are completed, wipe off excess joint compound as it is expelled from the deadend body. Remove any die flash and file or sand for a smooth appearance.

FARGO type UJC-16 Joint Compound required (cartridges per fitting)														
Fitting Type	Catalog Series	Aluminum (AH) Die Size												
		75	76	20	24	27	30	34	36	38	40	42	44	48
FT Splice body	10	0.06	0.10	0.20	0.32	0.44	0.60	0.94	0.98	1.10	1.10	1.40	1.52	1.62