NYCRO-PRESS SPECIFICATIONS FOR SAFETY CABLING

Effective June 2015

Safety Cable Nycro-Press Sleeve Procedure

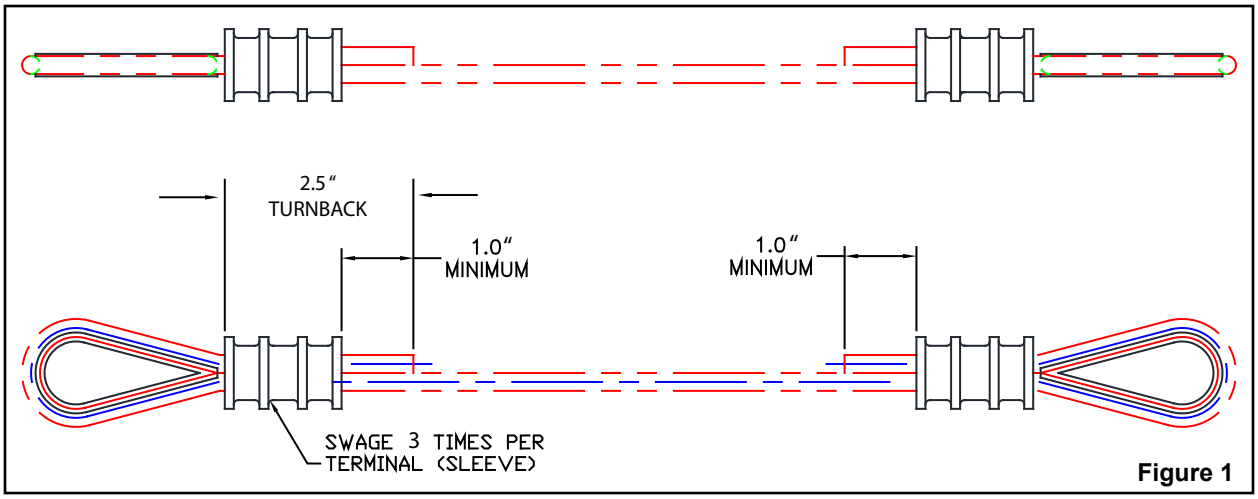
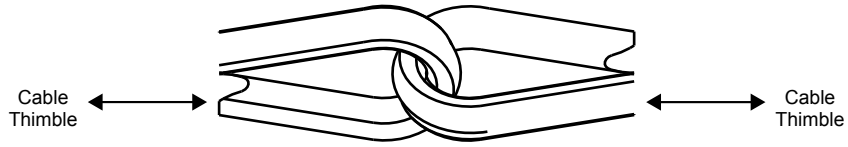


Figure 1



Inter Locking Turn-Back Eyes

Figure 2

Components Required - Part Number: CAMIRWA4133

¼" galvanized aircraft cable (Federal spec. #RR-W-410D, meeting military spec. #MIL-W-83420D for dimensional tolerance and strength).

Thimbles (for loads exceeding 200 lbs. [91 kg.])

¼" copper oval Nycro-Press sleeves.

Nycro-Press sleeve gauge.

Figure 3

Threading Procedure

STEP 1. Slide thimbles together as shown in (Figure 2) Above.

STEP 2. Turn back a minimum of 2.5" (63.5 mm) of the ¼" cable rope on the thimble or loop as shown in (Figure 1).

STEP 3. Assemble components together as shown in (Figure 3) leaving a minimum of 1 .00" (25.4 mm) of the ¼" cable rope "dead-end" protruding out of the Nycro-Press sleeves as shown in (Figure 1 & 3).

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STEP 4. Using a hand or powered swage press, press the Nycro-Press sleeve (3) times as shown in (Figure 1 & 3).

STEP 5. Using a sleeve press gage (Figure 5), check Nycro-Press sleeve clearances using the ¼" Oval Sleeve slot and check for proper press as shown in (Figure 4).

NOTE: Sleeve gage should slide over swagger without applying any force.

Figure 4

Figure 5

NYCRO-PRESS SPECIFICATIONS FOR SAFETY CABLING

NYCRO-PRESS HAND TOOLS FOR *NICOPRESS* OVAL AND STOP SLEEVES

# 17-BA	# 51-B4-887	# 51-F2-850	# 3-C-887	# 3-G9-950
# 17-B4B	# 51-C-887	# 51-Q-929	# 3-G-887	# 3-H5-950
# 31-B	# 51-G-887	# 51-MJ	# 3-M-850	# 3-Q-929
# 31-B4	# 51-M-850	# 63V-XPM	# 3-P-850	# 3-MJ
# 32-VC:VG	# 51-P-850	# 64-CGMP	# 3-X-850	# 3V-CGMP
# 33V-CGB4	# 51-X-850	# 63V-XPM/Cutter	# 3-F2-850	# 3V-F6:X:M
	# 51-Y-850	# 64-CGMP/Cutter	# 3-F2-950	# 3V-XPM
			# 3-F6-950	

NYCRO-PRESS BENCH TOOL HEADS

The heads used in bench tools are the same as the "heads only" of corresponding *Nycro-press hand tools as follows:*

No. 510 Bench Tool Heads

# 51-B4-887 Head	# 51-X-850 Head	# 63V-XPM Head
# 51-C-887 Head	# 51-Q-929 Head	# 64-CGMP Head
# 51-G-887 Head	# 51-Y-850 Head	
# 51-M-850 Head	# 51-F2-850 Head	
# 51-P-850 Head	# 51-MJ Head	

No. 510 Bench Tool Heads are completely interchangeable with each other

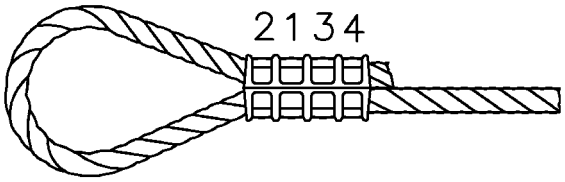
No. 300 Bench Tool Heads

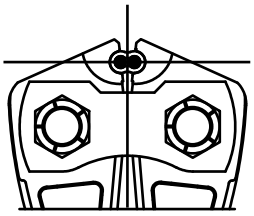
# 3-C-887 Head	# 3-F2-850 Head	# 3-Q-929 Head
# 3-G-887 Head	# 3-F2-950 Head	# 3-MJ Head
# 3-M-850 Head	# 3-F6-950 Head	# 3V-CGMP Head
# 3-P-850 Head	# 3-G9-950 Head	# 3V-F6:X:M Head
# 3-X-850 Head	# 3-H5-950 Head	# 3V-XPM Head

No. 300 Bench Tool Heads are completely interchangeable with each other

MAKING SPLICES WITH *NYCRO-PRESS* OVAL SLEEVES

To make EYE SPLICES, pull enough cable through the sleeve so that the end will still protrude after swaging. Line up the sleeve between the tool jaws as shown with the long axis crosswise to the jaws.

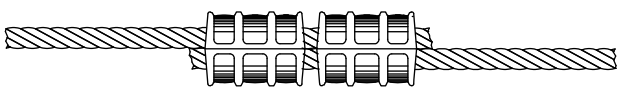




Using the proper *NYCROPRESS* tool, swage the sleeve with the correct number of presses, spacing the presses evenly on the sleeve. If more than 1 compression is required per sleeve, use the pressing sequence shown above. Tables which follow list the number of presses required for each sleeve. Space crimps apart as shown, except where overlapped presses are specified. Overlapped presses are specified for sleeves that need more than one press, but do not have room for two complete presses. Overlapped presses should compress all of the sleeve. To properly install, it is important the sleeve be fully and correctly pressed. To check this, use the gauge furnished with the tool on a completed sleeve press. Sleeves should enter slot freely. Adjust tool if sleeve does not enter gauge. (See Page 4 for information on using the gauge and adjusting tools.)

For maximum holding strength: Use *NYCROPRESS* Plain Copper Oval Sleeves or Zinc Plated Copper Oval Sleeves on Galvanized Steel Aircraft Cable. Use *NYCROPRESS* Tin Plated Copper Oval Sleeves or Stainless Steel Oval Sleeves on Stainless Steel Aircraft Cable.

LAP SPLICES can also be made with *NYCROPRESS* Oval Sleeves. Usually 2 sleeves are needed to develop full strength. A short space should be kept between the sleeves as shown. The cable ends should protrude after swaging.



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HAND TOOLS AND NO. 300 BENCH TOOL HEADS FOR OVAL SLEEVES					
CABLE SIZE	**SLEEVE NUMBER**	**HAND TOOL NUMBER**	**300 BENCH TOOL HEAD NUMBER**	**TOOL GROOVE**	**PRESSES REQUIRED**
3/64	168-1.5-VB4	3-B4-887	3-B4-887 HEAD	OVAL B4	1
1/16	168-2-VB4	3-B4-887	3-B4-887 HEAD	OVAL B4	1
	18-1-C; 28-1-C; 188-2-VC; 428-2-VC	3-C-887; 3V-CGMP	3-C-887 HEAD; 3V-CGMP HEAD	OVAL C	1
3/32	168-3-VC	3-C-887	3-C-887 HEAD	OVAL C	1
	18-2-G; 28-2-G; 428-3-VG	3-G-887; 3V-CGMP	3-G-887 HEAD; 3V-CGMP HEAD	OVAL G	1
	188-3-VG	3-G-887; 3V-CGMP	3-G-887 HEAD; 3V-CGMP HEAD	OVAL G	2 (overlapped)
1/8	168-4-VG	3-G-887	3-G-887 HEAD	OVAL G	1
	18-3-M; 28-3-M; 188-4-VM; 428-4-VM	3-M-850	3-M-850 HEAD	OVAL M	1
		3V-CGMP; 3V-XPM; 3V-F6:X:M	3V-CGMP HEAD; 3V-XPM HEAD; 3V-F6:X:M HEAD	OVAL M	2
		3-MJ	3-MJ HEAD	M	2
5/32	168-5-VM	3-M-850	3-M-850 HEAD	OVAL M	2 (overlapped)
	18-4-P; 28-4-P; 188-5-VP; 428-5-VP*	3-P-850	3-P-850 HEAD	OVAL P	1*
		3V-CGMP; 3V-XPM	3V-CGMP HEAD; 3V-XPM HEAD	OVAL P	2
3/16	18-6-X; 28-6-X; 188-6-VX; 428-6-VX	3-X-850; 3V-XPM; 3V-F6:X:M	3-X-850 HEAD; 3V-XPM HEAD 3V-F6:X:M HEAD	OVAL X	2
7/32	168-7-VX	3-X-950	3-X-950 HEAD	OVAL X	4
	18-8-F2; 28-8-F2; 428-7-VF2	3-F2-850	3-F2-850 HEAD	OVAL F2	2
* 1/4	168-8-VF2	3-F2-950	3-F2-950 HEAD	OVAL F2	5
	18-10-F6; 28-10-F6; 188-8-VF6; 428-8-VF6	3-F6-950; 3V-F6:X:M	3-F6-950 HEAD; 3V-F6:X:M HEAD	OVAL F6	3
5/16	18-13-G9; 28-13-G9; 428-10-VG9	3-G9-950	3-G9-950 HEAD	OVAL G9	4
	188-10-VG92	3-G9-950	3-G9-950 HEAD	OVAL G9	4
3/8	18-23-H5; 28-23-H5; 428-12-VH5	3-H5-950	3-H5-950 HEAD	OVAL H5	4
	188-12-VH5	3-H5-950	3-H5-950 HEAD	OVAL H5	4

* Knight products utilized.

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NOTES AND SAFETY REMINDERS

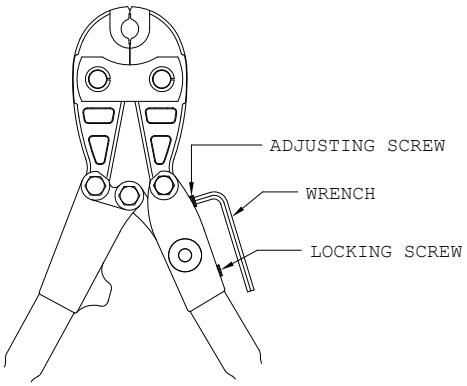
Sleeve pressing with No. 63V-XPM/Cutter tool or No. 64-CGMP/Cutter tool is done the same way as with No. 63V-XPM tool or No. 64-CGMP tool respectively.

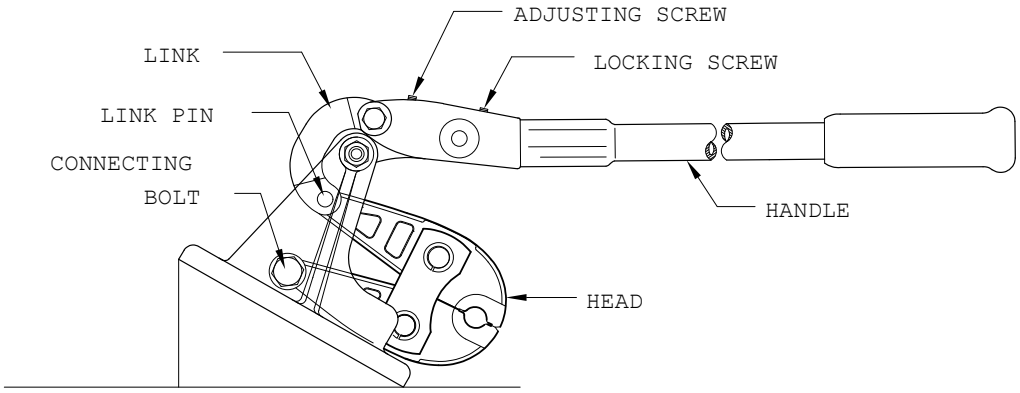
Proof testing is recommended whenever the possibility of personal injury or property damage exists.
ALWAYS WEAR SAFETY GLASSES WHEN TOOL IS BEING USED.

Nycropress hand tools are designed to be used with Nycropress sleeves. Swaging non-Nicopress sleeves, other materials and other items should not be attempted as it may cause damage to equipment and/or injury to personnel.

ADJUSTMENT FOR HAND TOOLS

Open handles, loosen locking screw two turns. Turn adjustment screw 1/4 of a turn clockwise. After adjustment, tighten locking screw. Swage sleeve on wire and check with gauge. Repeat if necessary. Clean and oil periodically. Except for some spring at final closing, "empty" tool should work freely. The No. 17-BA and 17-B4B tools are not adjustable.





NO. 300 BENCH TOOL AND NO. 510 BENCH TOOL: ADJUSTING AND CHANGING HEADS

To remove the tool head: (1) Raise the handle to full open position. (2) Remove connecting bolt (see illustration). (3) Pull head out to expose link pin and remove it. To install a tool head, follow the reverse of this procedure. Always check tool adjustment when changing heads (see below).

To adjust the tool, raise the handle to the full open position, loosen the locking screw two turns. Turn adjustment screw 1/4 of a turn clockwise. After adjustment, tighten locking screw. Swage sleeve on wire and check with gauge. Repeat if necessary. Clean and oil periodically. Except for some spring at final closing, "empty" tool should work freely.