



## Hand Swager (E0113-H600) Installation Instructions

The hand swager allows the user to swage by hand 1/8", 5/32" and 3/16" wire rope. This swager crimps the hand swage studs onto the wire rope. The following guide will take you step-by-step through the process of swaging your hand swage fittings, offering helpful tips and tricks along the way.

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Warning



Note

## Tools

### Required & Recommended



Hand Swager



After Swage Gauge



Safety Glasses



Work Gloves

## Tips for a Successful Installation

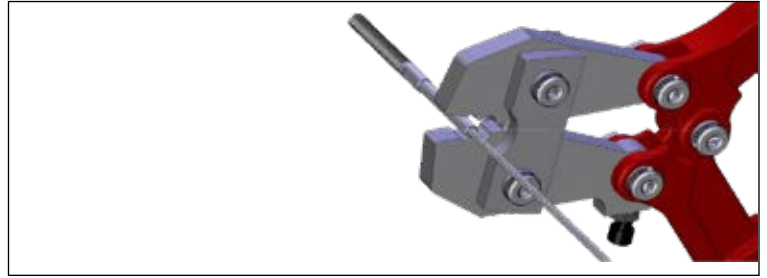
- Read the instructions completely before beginning the installation.
- Always wear personal protection equipment; safety glasses, work gloves, etc.



**ALWAYS WEAR APPROPRIATE PROTECTIVE EYEWEAR AND GLOVES WHEN WORKING WITH CABLE TO PREVENT INJURY. ALWAYS POINT THE TOOL AWAY FROM PEOPLE AND BE AWARE OF YOUR SURROUNDINGS.**

## Position the Swage Fitting & Cable

Place the swage stud into the proper opening on the swaging tool. Position the swage stud and leave approximately 1/8" from the end of the swage stud (See Figure A). **Do NOT attempt to crimp any closer to the end of the swage stud as this could severely weaken the fitting.** Insert the cable into the swage stud being sure to seat it to the full depth of the swage stud.



**Figure A.** Begin first crimp approximately 1/8" from the edge of the swage stud.

## Make the First Crimp

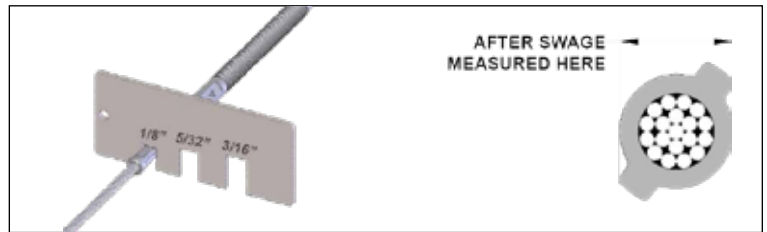
With the cable and swage stud both firmly in place, make the first crimp making sure that the tool closes completely around the fitting. It is very important that the swage is done properly. Under-swaging could cause the cable to slip while over-swaging can cause the swage stud to fail.

## Check the After Swage Dimensions

After making the first crimp, use the supplied gauge (included with the Hand Swager) to check the after swage dimension (See Figure B) to ensure that the crimp is done correctly. Adjust the tool accordingly before continuing per the prescribed instruction on the next page.



**SUNCOR'S AFTER SWAGE GAUGE (E0113-HG00) IS A HELPFUL TOOL TO MEASURE UNIFORM CRIMPS.**

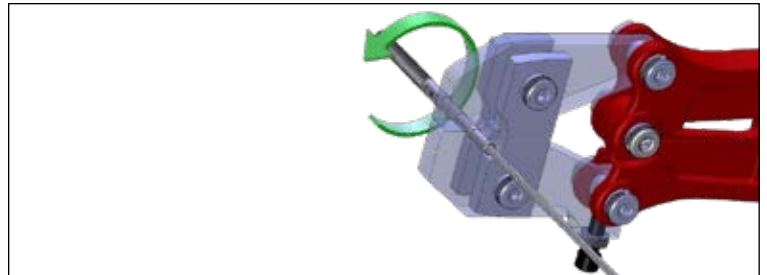


**Figure B.** Measure the fitting as shown after the first swage. Adjust the tool accordingly before completing any additional swaging.

## Make Second & Third Crimps

When you are satisfied that the tool is properly set up, continue on to make the second crimp. Rotating the fitting 180 degrees between crimps will help keep the terminal from bending (See Figure C). Make sure to leave approximately 1/8" between the previous swage. Make sure the tool closes completely to ensure the strongest swage possible.

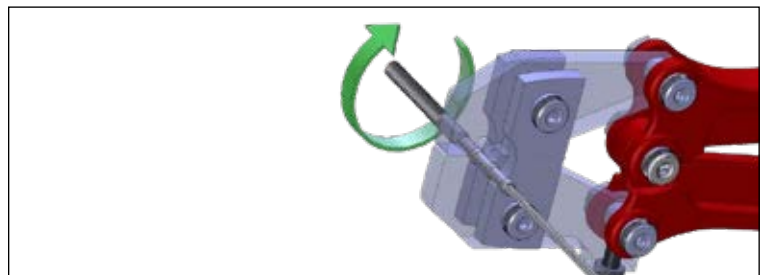
Upon completion of the second crimp, rotate the fitting back to its initial position (See Figure D). Leaving approximately 1/8" of space between the previous crimp, begin making the third swage.



**Figure C.** Rotate the fitting 180 degrees and leave approximately 1/8" of space between the previous crimp.



**DO NOT ATTEMPT TO CRIMP CLOSER THAN 1/8" FROM BASE OF THE TERMINAL AS THIS COULD SEVERELY WEAKEN THE FITTING.**



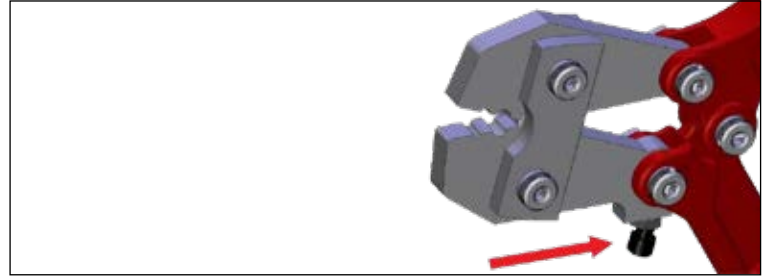
**Figure D.** Rotate the fitting back to its initial position and make the final crimp, leaving approximately 1/8" of space between the previous crimp.



**SUNCOR STAINLESS' HAND SWAGE LINE IS ACCEPTABLE USING ONLY 1/8" AND 3/16" CABLE. ONLY 1X19 CABLE SHOULD BE USED FOR CABLE RAILING APPLICATIONS. FOR 1/8" FITTINGS, 7X7, 7X19 OR 1X19 CABLE CONSTRUCTION IS ACCEPTABLE. 1X19 CABLE IS NOT ADVISABLE FOR 3/16" CABLE. THE ESTIMATED HOLDING PERCENTAGE IS 60-70% OF THE CABLE STRENGTH. NOT FOR USE ON STANDING RIGGING OR HIGHLOAD APPLICATIONS.**

## Assess the Need for Adjustment

Prior to using the Hand Swager, verify that the adjustment screw is backed off and the lock nut is in place (See Figure E). This can be done by looking at where the jaws meet at their tips. The tool will not “snap” closed when left loosely adjusted.



**Figure E.** Check to make sure that the adjustment screw is backed off and the lock nut is in place.

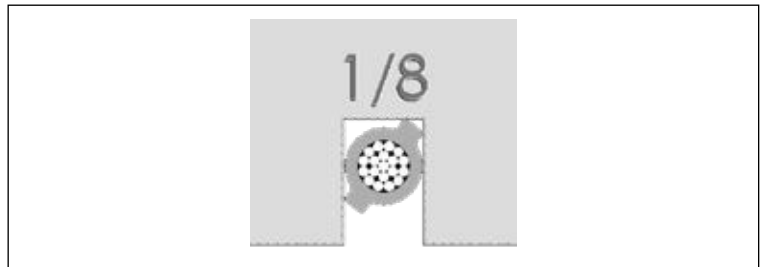
## Make the First Crimp

Make one (1) crimp per prescribed instruction on the previous page. As the crimping is being done, it should be possible to close the jaws fully with some resistance. If the tool is adjusted too tightly, it will not be able to close on the fitting.

## Make the First Crimp & Readjust if Necessary

Using the After Swage Gauge (included with the Hand Swager), check that the gauge goes over and around the crimp (See Figure F). If more pressure is needed to close the jaws around the fitting, unscrew the lock nut, and while the tool is **NOT** in use, tighten the adjustment screw approximately one (1) revolution or as many as needed to obtain the correct crimp. Retighten the locking nut.

Re-crimp and check with the gauge. The gauge should slip over the fitting when rotated in the gauge without being forced (See Figure F).



**Figure F.** The gauge should slip over the fitting when rotated in the gauge without being forced.