E0113-H001 "Mini" Hand Swager Instructions
The "mini" hand swager" allows the user to swage by hand 1/8" 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.

Warning Note

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Tools

Required & Recommended


"Mini" Hand Swager


9/16" Open Wrench

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

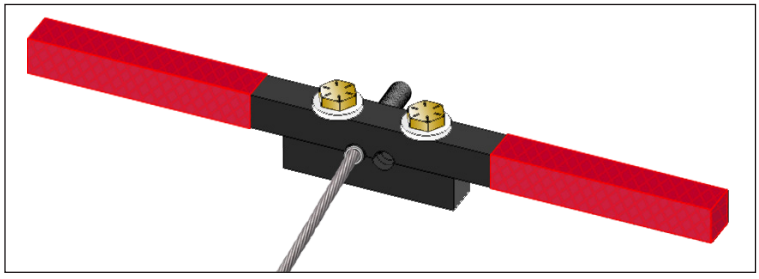

Figure A. Begin first crimp approximately 1/8" from end of swage terminal.

Operating the Swaging Tool

With the cable and terminal both firmly in place, begin making the first crimp. Using a 9/16" open or box wrench, alternate tightening the two crimping bolts until the two die blocks come together completely (*See Figure B*). When the swage is complete, loosen the bolts to remove and reposition the swage terminal. Measure the after swage dimension as shown (*See Figure C*) and compare it to the table (*See Figure D*).

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

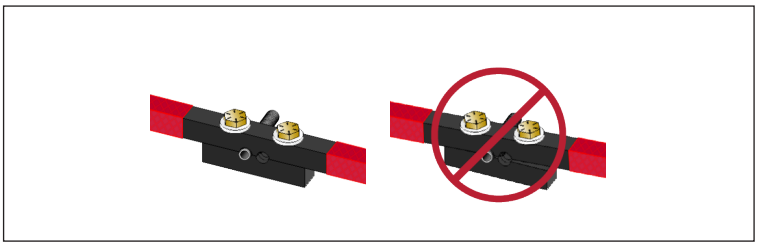

Figure B. Make sure the die blocks come together completely and that there is no space between them.

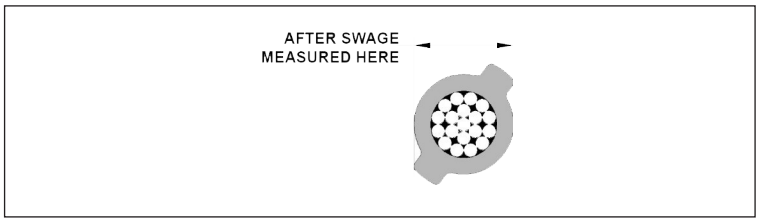

Figure C. Measure the after swage dimension as shown.

(1/8" Cable)	(3/16" Cable)
0.188 (3/16")	0.265 (17/64)"

Figure D. After swage dimensions.

Reposition the Swage Fitting

After making the first crimp, reposition the swage fitting leaving approximately 1/8" between the previous swage. **Rotate the fitting 180° in between each swage. This will help to keep the terminal from bending.** Take care not to swage over any portion of an existing crimp as this may seriously weaken the fitting. Follow the directions of the previous step to complete the next swage.

Finish All Swages

Repeat the above steps leaving approximately 1/8" between crimps until you have completed five (5) swages as shown (*See Figure E*). **Do NOT attempt to crimp closer than 1/8" from base of the terminal as this could severely weaken the fitting.**

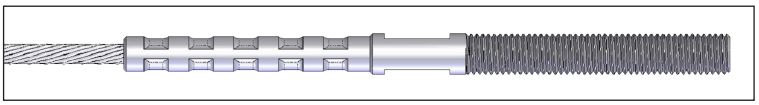

Figure E. Completed swage fitting with five crimps with approximately 1/8" space between crimps and ends of terminal.

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 HIGH LOAD APPLICATIONS.