DMC Power
Cable Connector Assembly Instructions

Step 1: **CUT AND CLEAN THE END OF CABLE**

Confirm that the DMC Power Cable Connector fitting matches the cable size. Also, confirm that the Swage Tool matches the Cable Connector fitting size. Cut the cable so that the strand ends are even. Clean an area of 4 inches from the end of the cable by wire brushing (see picture 1). Visually inspect that all Aluminum Cable Connector fittings to verify that the inside surface is coated with AFC.

Step 2: **ASSEMBLE THE DMC POWER CABLE CONNECTOR FITTING WITH THE CABLE**

Slide the connector over the cable until the end of the cable bottoms out. Check to see, through the inspection hole, if the end of the cable is visible (see figure 1).

Step 3: **ASSEMBLE THE DMC POWER SWAGE TOOL**

Mount the Die Block onto the Power Unit and make sure it is locked in place with the pushpin or set screws. Slide the Power Unit and Head together.

Step 4: **CONNECT THE HYDRAULIC PUMP TO THE POWER UNIT**

Connect the DMC Power Swage Tool to the hydraulic pump via the quick disconnect (threaded or push-pull) fitting to the hydraulic hose line. Properly align the Head and the Power Unit such that the face is flush as shown in picture 2.

Step 5: **PERFORMING A SWAGE**

Position the Swage Tool over the DMC Power Cable Connector fitting. Ensure that the Swage Dies' teeth are between the Swage Line marks on the DMC Power Cable Connector fitting as shown in figure 1. Start the Hydraulic Pump to actuate the tool. Swaging is complete when the Die Block makes contact with the Head and the pressure reaches 10,000 psi. Disengage the Head from the Power Unit once the Die Block fully retracts.

Step 6: **INSPECT THE SWAGED CONNECTOR FITTING**

Use the Inspection Gauge to verify that the swage is good by positioning the Inspection Gauge on the swaged portion of the fitting as shown in figure 2. If there are no Inspection Gauges available, refer to table 1 for "Depth of Swage" dimensions for the swage inspection.

REPEAT STEPS 1 THROUGH 6 FOR EACH CABLE CONNECTOR FITTING END.

Visually inspect all Aluminum Cable Connector fittings to verify that the inside surface is coated with AFC. Copper Cable connectors do not need AFC.
Remove the Swage Dies when dirty and clean the slots with a wire brush to remove the excess build-up. Once cleaned, re-lubricate with DMC Power Swage Lube.
Refer to DMC Power Cable Connector Standard Operating Procedure QWI-DMCP-7.3-002 Rev "-" for more detailed information.
DO NOT USE ON ANY OTHER PRODUCT OTHER THAN DMC POWER FITTINGS.
DO NOT OPERATE THE DMC POWER SWAGE TOOL WITHOUT THE HEAD ASSEMBLY. IMPROPER USE MAY RESULT IN TOOL FAILURE AND/OR SERIOUS INJURY.

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Next Generation Power Connections

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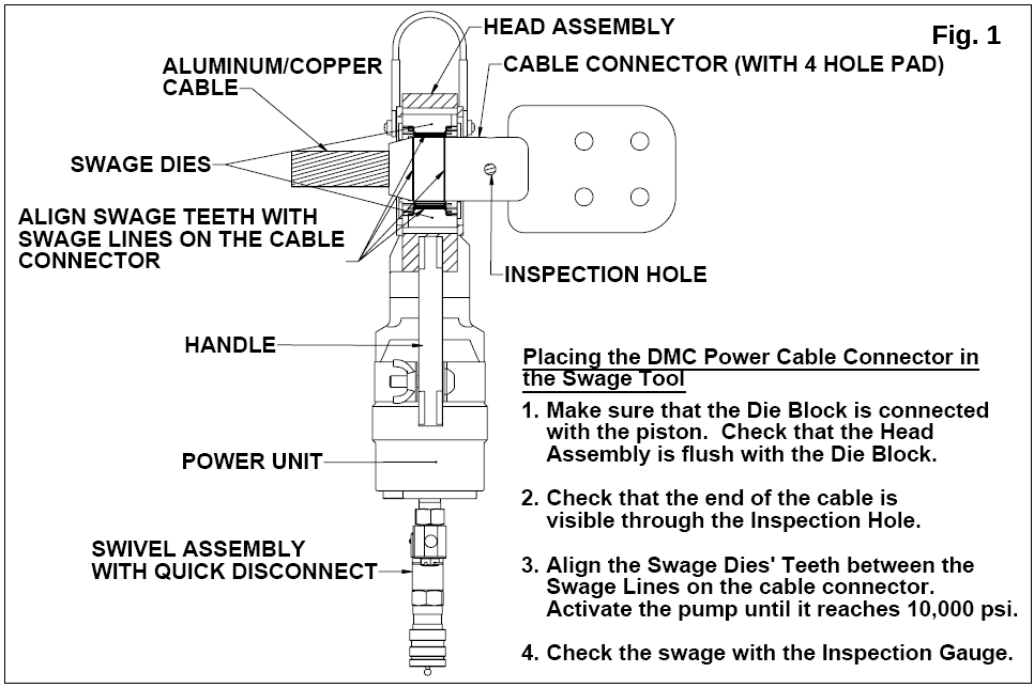
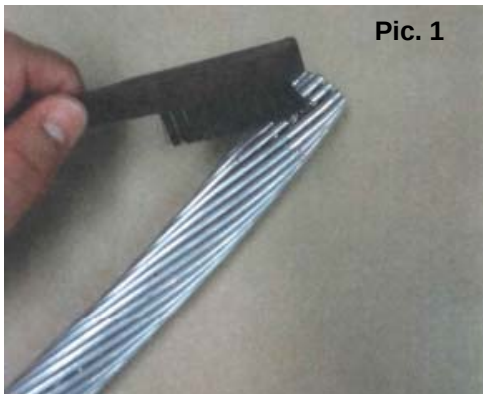


Fig. 1



Pic. 1

Cut the cable so that the ends are even. Clean an area of about 4" from the end

Pic. 2

Position the DMC Power Swage Tool making sure that the Swage Die teeth are aligned with the Swage Lines on the Cable Connector.

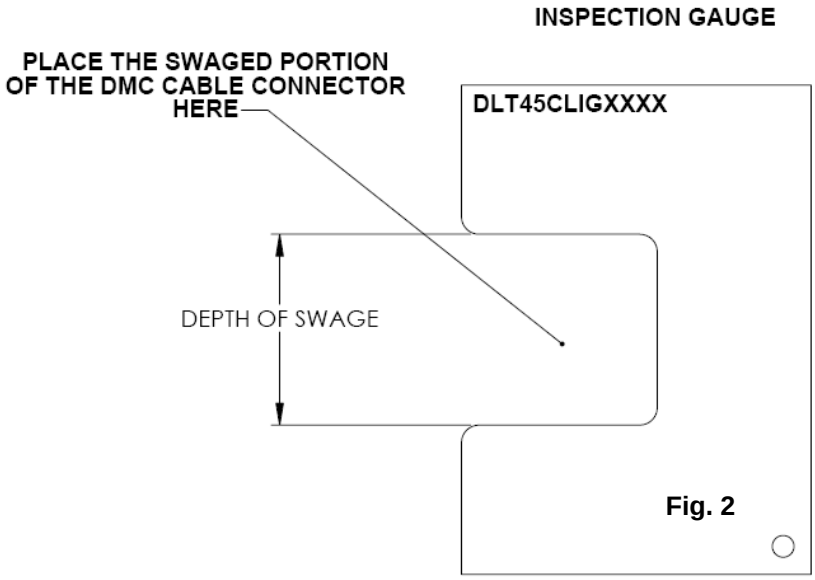


Fig. 2

Table 1

INSPECTION GAUGE PART NUMBER	CONNECTOR OD [in]	DEPTH OF SWAGE [in]
DLT45CLIG00010	0.75	0.705
DLT45CLIG02500	1.00	0.891
DLT45CLIG03975	1.25	1.127
DLT45CLIG05565	1.50	1.365
DLT45CLIG07155	1.75	1.596
DLT45CLIG08745	1.88	1.694
DLT45CLIG11130	2.00	1.835
DLT45CLIG15900	2.25	1.994
DLT58CLIG25000	2.75	2.417

Note: DLT58CLIG25000 is used when operating a Model 58 Power Unit P/N DLT58MAPW0000 with Head Assembly P/N DLT58CLHA25000.

Pic. 3

Verify the Swage using the Inspection Gauge.

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