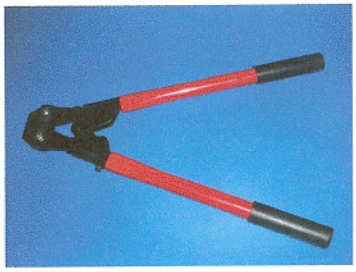
SCS Stainless Cable Solutions

Hand Swage Tensioning Terminal Instructions:

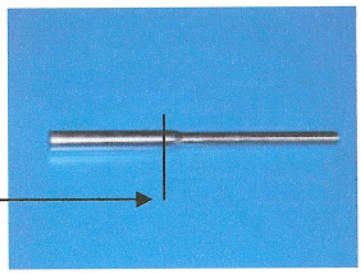
Step #1: Organize Tools

1: Hand Swaging Tool * Rental
2:C9 Felco Cable Cutter Rental
3: Permanent Marker
4: Personal Protective Equipment
5: Micrometer or Caliper **
6: Grinder with cut off disc, dremel tool or hacksaw
7: Bastard File
8: Vise Grips
9: Husky 10 mm &11mm box end ratchet wrenches

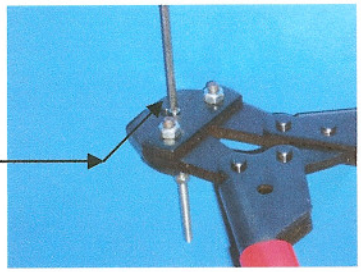


*Failure to use the proper SCS swaging tool to hand swage SCS fittings voids all warranties.
**After swage dimensions must be:

- .185 for 1/8" cable
- .265 for 3/16" cable



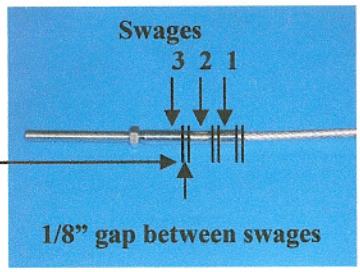
Step #2: Pull the cable tight against the termination fitting on the opposite termination post. Line up the cable and hold the fitting on the side of the post on the corresponding hole. Leave 1/2" of threaded stud exposed on the outside face of the post. Mark the cable at the BOTTOM of the swage. Cut the cable on the mark with the Felco C9 rental tool.
Note: Open all turnbuckles 50 % before you hand swage the opposite end.



Step #3: Slide the cable into the fitting 1/4" and bend the cable slightly. Push the cable into the fitting until it bottoms out on the inside of the swage. Mark the cable at the edge of the fitting to insure that the cable does not slip out while hand swaging the terminal.

Step #4: Hand swage the first crimp starting 1/8" from the cable edge of the fitting. Use correct die hole for the proper size fitting. The small hole is for 1/8" fittings and the large hole is for 3/16".

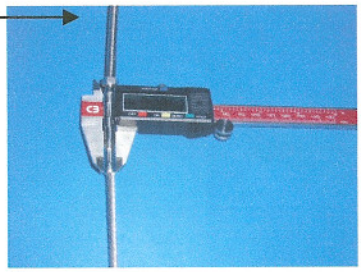
SCS Hand Swage Tensioning Terminals are designed for low load applications. The fittings when installed properly are rated to 50 % of 7X7 cable construction. HSTT's are not recommended in commercial applications where they will be subject to abuse.



Step #5: Move the swaging tool up the fitting to the second swage position. Insure there is a 1/8" gap between all **THREE** hand swage crimps. Rotate the tool or fitting 90 degrees before each hand swage this prevents the "banana effect". **The HSTT must be hand swaged THREE times.**

Step #6: Check all after swage dimensions on your fittings.

- .185" for 1/8" cable
- .265" for 3/16" cable



Step #7: Slide the HSTT into the 5/16" hole in your posts. Place a washer and nut on the back side. Grip the cable with vise grips and a small scrap of leather to prevent the cable from spinning and being damaged. Tension all the tensioning nuts (10mm)on the HSTT to 150 lbs per cable.*
*A tension gauge is available for rent upon request.

Step #8: Repeat **Steps #2 - #7** for the rest of your cables. Tension the cables from the inside out working back and forth .You might have to re-tension some center cables when finished.

Step #9: Place sacrificial nuts on all the bolts and tighten slightly. Cut the excess bolt off with 1/8" cut off disc on grinder or like tool. WEAR SAFETY GLASSES! File any remaining burrs on the end of the bolt.

Step #10: Remove the sacrificial nuts and install finished acorn nuts (11mm).

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