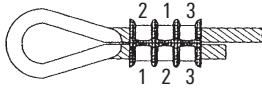


NICOPRESS Installation Safety

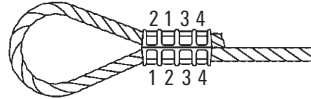
Proper press sequences

If making three or more presses, it's important to press in the recommended sequences illustrated. The most important sequences to avoid are ones which press an area on the sleeve in-between two previous presses as illustrated. **Reason:** once two outer presses are formed followed by pressing an interior position, the middle press will cause sleeve material to push (or flow) against the previously pressed outer positions possibly breaking wires and/or compromising the grip strength of the two outer presses.

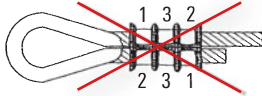
Recommended press sequences for a 3-press sleeve



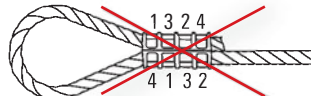
Recommended press sequences for a 4-press sleeve



NOT Recommended press sequences for a 3-press sleeve



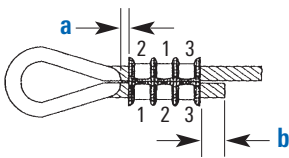
NOT Recommended press sequences for a 4-press sleeve



Proper wire rope end protrusion "tail" and thimble clearance

When making an eye-splice, extend the rope cut-end a sufficient distance (b) out of the sleeve so when pressing has completed, some portion of the cut end (or "tail") remains outside the sleeve. **Reason:** the material flows and lengthens the sleeve as it's pressed and may cause the wire rope end to retract inside the sleeve. If the wire has retracted, the gripping strength cannot be predicted since less rope is gripped by the sleeve, which may reduce the gripping strength between the wire rope and sleeve.

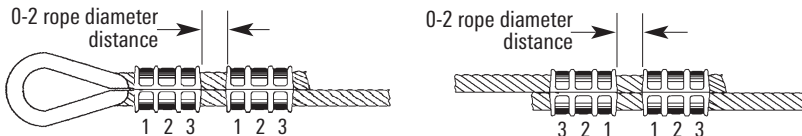
When using a thimble, position the sleeve from the thimble a distance of at least 1/2 of the wire rope diameter (a). **Reason:** when swaging, material flow tends to lengthen the sleeve which may cause the sleeve to contact the thimble – possibly damaging the wire rope wires and/or compromising the grip strength of the sleeve. Proper press sequences also are shown for the three-press sleeve illustrated below.



Refer to Technical Bulletin-1 for proper press sequences, wire rope end protrusion, and thimble clearance for oval sleeve eye splices.

Proper construction of multiple sleeve eye and lap splices

When it's necessary to use multiple sleeves for special eye or lap splices, it's always better to keep the sleeves as close as possible to prevent one intermediate rope from becoming longer than the other. If the recommended procedure for multiple sleeve installations is used, the pressed sleeves will act additively and perform reliably and consistently. If it's desired to install the second sleeve in direct contact with the first, the second sleeve must be pressed in the sequence shown below so the sleeve material flows outward, away from the interface during swaging. Recommended sleeve spacing and press sequences are illustrated below for lap and eye splices:



Refer to Technical Bulletin-4 for details regarding proper construction of eye and lap splices using multiple compression sleeves.

Go gauge usage

Gauging swaged sleeves is an important inspection process to determine if a sleeve has been pressed enough to ensure a full-strength connection to wire rope. Nicopress go gauges are provided with each tool. It's always recommended, while adjusting a hand tool, to gradually increase the compression of the tool to a point where the Nicopress "go-gauge" easily slides (or "goes") over the pressed sleeve resulting in an optimum swage compression.

It's a "go" gauge, not a "go-no-go" gauge

A Nicopress "go" gauge is a gauge designed to easily slide or "go" over a properly swaged section of sleeve to be sure a safe amount of compression has been reached. If the gauge tool doesn't slide easily over the swage, or doesn't go, the swage tool must be adjusted to press deeper to allow the gauge to freely pass or "go" over the swage. In theory, this would be an inspection tool to prevent under-pressing occurring during a swaging process.

Refer to Technical Bulletin-2 for "Go-Gauge" or "Go-No-Go" Gauge details.

