

HANDISWAGE

WARNING: 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 proper opening on swaging tool. Position the terminal as illustrated in *Figure A* leaving approximately $\frac{1}{8}$ " 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.

MAKE FIRST CRIMP

With the cable and terminal both firmly in place, make the first crimp making sure that the tool closes completely around the fitting. Whether you're using the mini or the full size tool, it's important that the swage is done properly. Under-swaging could cause the cable to slip while over-swaging can cause the terminal to fail.

CHECK THE AFTER SWAGE DIMENSION

After making the first crimp, use the attached gauge to check the after swage dimension (see *Figure D*) to ensure that the crimp is done correctly. Adjust the tool accordingly before continuing on.

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° (see *Figure B*) between crimps will help keep the terminal from bending. Make sure to leave approximately $\frac{1}{8}$ " 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 C*). Leaving approximately $\frac{1}{8}$ " of space between the previous crimp begin making the third swage. **Do NOT attempt to crimp closer than $\frac{1}{8}$ " from base of the terminal as this could severely weaken the fitting.**

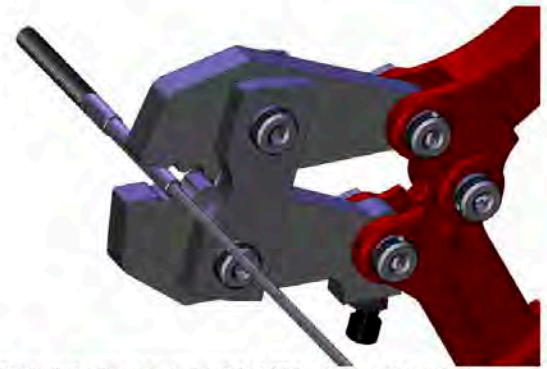


Figure A. Begin first crimp approximately $\frac{1}{8}$ " from edge of terminal

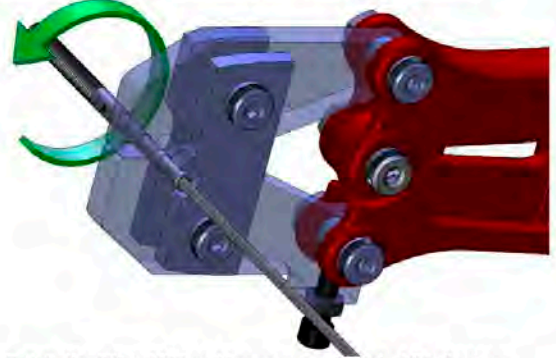


Figure B. Rotate the fitting 180° and leave approximately $\frac{1}{8}$ " of space between previous crimp

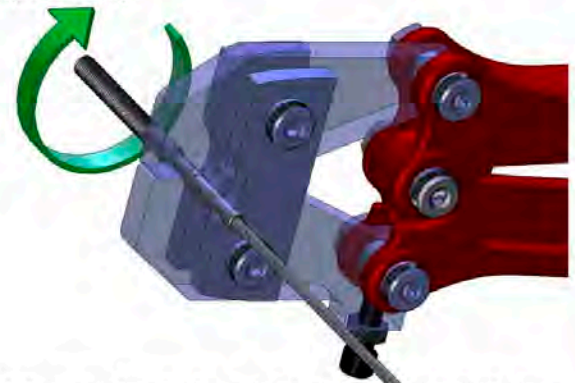


Figure C. Rotate the fitting back to its initial position and make the final crimp leaving approximately $\frac{1}{8}$ " of space between previous crimp



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

703 SERIES ($\frac{1}{8}$ " CABLE)	705 SERIES ($\frac{3}{16}$ " CABLE)
0.188 ($\frac{3}{16}$ ")	0.265 ($\frac{17}{64}$ ")

Table E. After swage decimal dimensions

NOTE: Atlantis Rail hand swage line is acceptable using only $\frac{1}{8}$ " or $\frac{3}{16}$ " cable. For $\frac{1}{8}$ " fittings, 7x7, 7x19 or 1x19 cable construction is acceptable however 1x19 cable is not advisable for $\frac{3}{16}$ " cable. The estimated holding percentage is 60-70% of cable strength.
NOT FOR USE ON STANDING RIGGING OR HIGH LOAD APPLICATIONS