ATLANTIS®
RAIL SYSTEMS

HANDISWAGE™

Hand Swager (E0113-H600) Installation Instructions

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

Make the First Crimp

With the cable and swage stud both firmly in place, make the first crimp making sure that the tool closes completely around the fitting. It is very important that the swage is done properly. Under-swaging could cause the cable to slip while over-swaging can cause the swage stud to fail.

Check the After Swage Dimensions

After making the first crimp, use the supplied gauge (included with the Hand Swager) to check the after swage dimension (*See Figure D*) to ensure that the crimp is done correctly. Adjust the tool accordingly before continuing per the prescribed instruction on the back page.

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 degrees between crimps will help keep the terminal from bending (*See Figure B*). Make sure to leave approximately 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 1/8" of space between the previous crimp, begin making the third swage. **Do *NOT* attempt to crimp closer than 1/8" from base of the terminal as this could severely weaken the fitting.**

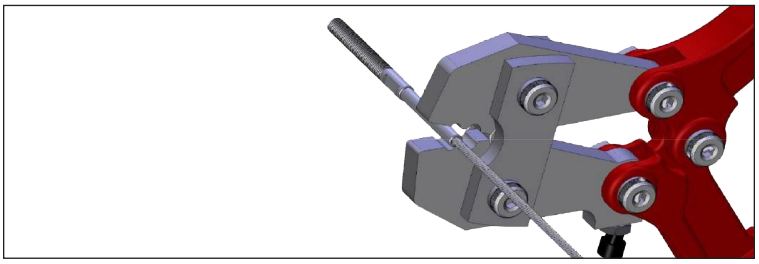

Figure A. Begin first crimp approximately 1/8" from the edge of the swage stud.

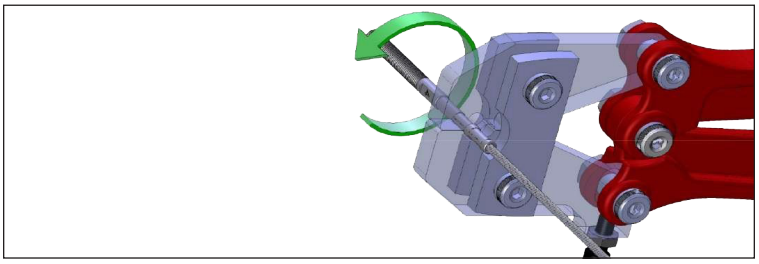

Figure B. Rotate the fitting 180 degrees and leave approximately 1/8" of space between the previous crimp.

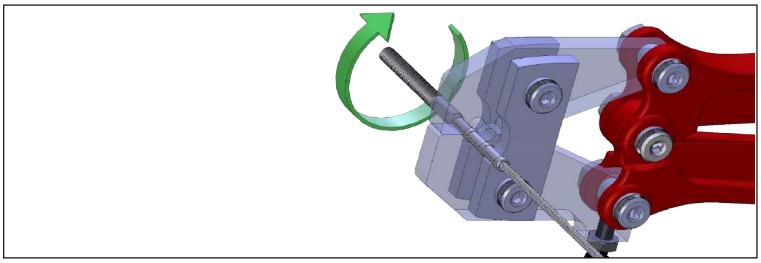

Figure C. Rotate the fitting back to its initial position and make the final crimp, leaving approximately 1/8" of space between the previous crimp.

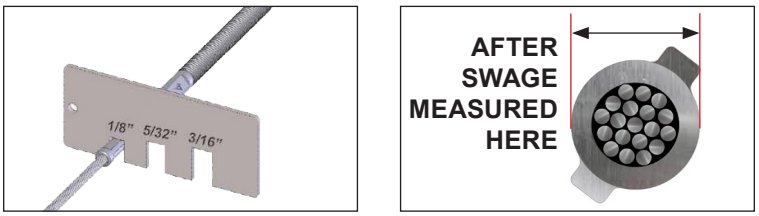

Figure D. Measure the fitting as shown after the first swage. Adjust the tool accordingly before completing any additional swaging.

NOT FOR USE ON STANDING RIGGING OR HIGH LOAD APPLICATIONS.

ATLANTIS RAIL'S HAND SWAGE LINE IS ACCEPTABLE USING ONLY 1/8", 5/32" AND 3/16" CABLE. ONLY 1X19 CABLE SHOULD BE USED FOR CABLE RAILING APPLICATIONS. FOR 1/8" AND 5/32" 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.

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Hand Swager (E0113-H600) Adjustment Instructions

Assess the Need for Adjustment

Prior to using the Hand Swager, verify that the adjustment screw is backed off and the lock nut is in place (*See Figure E*). This can be done by looking at where the jaws meet at their tips. The tool will not "snap" closed when left loosely adjusted.

Make the First Crimp

Make one (1) crimp per prescribed instruction on the front page. As the crimping is being done, it should be possible to close the jaws fully with some resistance. If the tool is adjusted too tightly, it will not be able to close on the fitting.

Make the First Crimp & Readjust if Necessary

Using the After Swage Gauge (included with the Hand Swager), check that the gauge goes over and around the crimp (*See Figure F*). If more pressure is needed to close the jaws around the fitting, unscrew the lock nut, and while the tool is ***NOT*** in use, tighten the adjustment screw approximately one (1) revolution or as many as needed to obtain the correct crimp. Re-tighten the locking nut.

Re-crimp and check with the gauge. The gauge should slip over the fitting when rotated in the gauge without being forced (*See Figure F*).

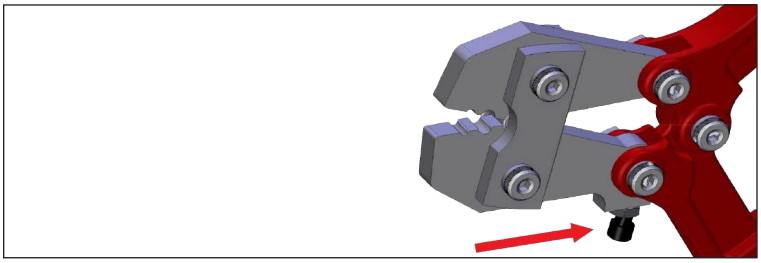

Figure E. Check to make sure that the adjustment screw is backed off and the lock nut is in place.

Figure F. The gauge should slip over the fitting when rotated in the gauge without being forced.