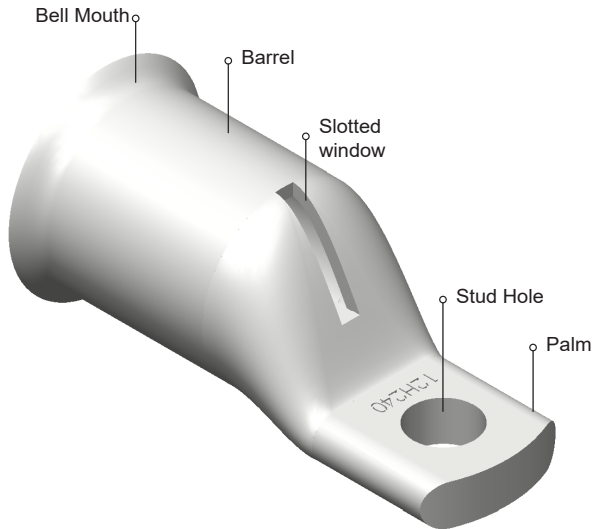


# B12

## CU-FLEX® Circuit Breaker Lug Installation Guide



Recommended Stud Tightening Torque

Bolt (AS 1110, Class 8.8)	Recommended Torque (Nm)
M5	5
M6	9
M8	22
M10	44
M12	77
M16	190

B12 SELECTION TABLE - CU-FLEX COPPER LUG					Crimp Distance from Barrel Front Edge			Stripping Length of Cable Insulation
Conductor Size	Die A/F	Hydraulic Tools - Hexagonal Die No. of Crimp x Crimp Face Length*			12-13 tonne	25 tonne	60 tonne	
mm <sup>2</sup>	mm	12 - 13 tonne	25 tonne	60 tonne	mm	mm	mm	mm
6	4.4	1 Crimp x 6.4mm	Use Adaptor and Standard 12 Tonne Dies	Use Adaptor and Standard 12 Tonne Dies	1.0			9
10	5.7	1 Crimp x 6.4mm			2.0			10
16	6.3	1 Crimp x 17.5mm			1.0			19
25	7.7	1 Crimp x 17.5mm						21
35	9.2	1 Crimp x 17.5mm			3.0			21
50	10.4	1 Crimp x 17.5mm						22
70	11.5	1 Crimp x 17.5mm			5.0			24
95	14.2	1 Crimp x 17.5mm						27
120	16.5	1 Crimp x 14.0mm			10.0			30
150	18.3	1 Crimp x 14.0mm						1 Crimp x 16.0mm
185	20.0	1 Crimp x 14.0mm	1 Crimp x 16.0mm	14.0	10.0	10.0	32	
240	23.1	1 Crimp x 10.0mm	1 Crimp x 16.0mm				38	
300	26.0	2 Crimp x 10.0mm	1 Crimp x 16.0mm	1 Crimp x 25.0mm	10.0	13.0	10.0	42
400	28.1	2 Crimp x 10.0mm	1 Crimp x 16.0mm	1 Crimp x 25.0mm				15.0
500	31.0		1 Crimp x 16.0mm	1 Crimp x 25.0mm			15.0	48
630	37.0			1 Crimp x 25.0mm				

(\* ) In case of using dies with different length of crimp face than specified above, the total effective crimp length (crimp length x no. of crimp) should be equivalent to maintain a secured mechanical and electrical connection.

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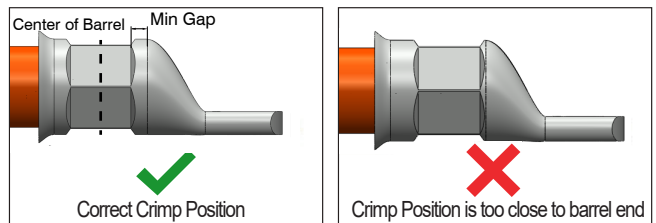
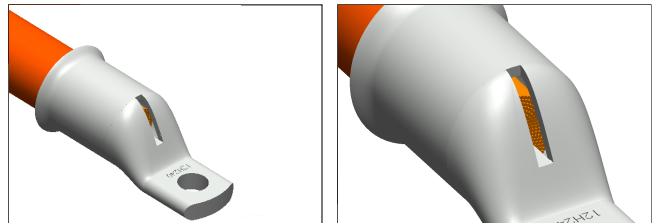
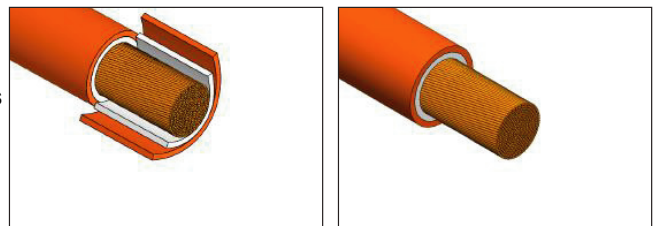
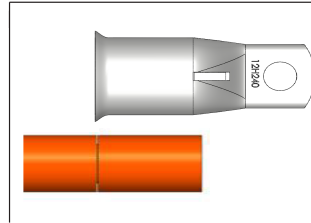
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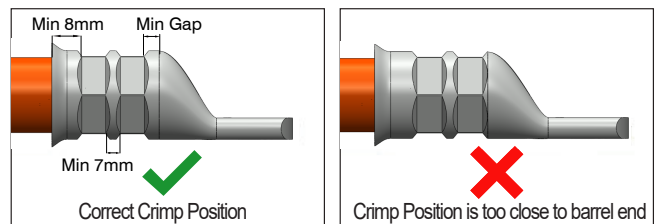
# B12

## CU-FLEX® Circuit Breaker Lug Installation Guide

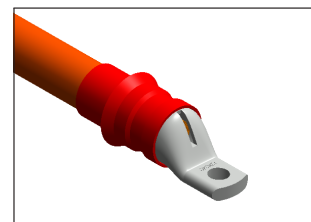
1. Select a suitable size of **CU-FLEX® Circuit Breaker Lug** by verifying that the conductor size marking on the lug and cable match. Mark stripping length on cable as specified on the B12 Selection Table.
2. Carefully cut and strip outer layers of the cable (sheathing, insulation, fleece tape). Be very careful not to nick or cut any strands of the conductor. Adjust the stripping tool so that it cuts close to the conductor but leaves a small amount of insulation to tear away by hand. This will help protect the fine wires during the stripping process.
3. Carefully insert the conductor into the lug making sure all strands are contained within the barrel. Do not twist the conductor. Use the slotted window to check if conductor is fully inserted into the barrel.
4. Select a suitable crimping tool with the correct crimp force and note the required No. of crimps as specified on the B12 Selection Table (12-13 Tonne, 25 Tonne or 60 Tonne). Choose the appropriate Copper die by referring to the correct A/F (across flats) die size on the B12 Selection Table.
5. For hydraulic hex crimpers, place the lug on the non-moving die and allow the other die to move up to crimp. **If more than 1 crimp is required (refer B12 Selection Table for more details), begin crimping from the front end (palm end) of the barrel to the open end.** Position the lug to the correct crimp location on the barrel as specified on the B12 Selection Table. Do not crimp closer than the minimum gap specified in the B12 Selection Table from the front end of the barrel.
6. Begin the crimping process and continue until the full cycle is complete. Make sure the dies are fully closed for sufficient crimping force. Release the ram and repeat the process if more than 1 crimp is required. Leave a 7mm gap between each crimp. Do not crimp closer than 8mm from the open end of the barrel.
7. Check crimping result. Use a file if necessary to remove burrs to have a smooth crimp surface. Apply suitable **CU-FLEX® G01 Heatshrink** to complete the crimping. The heatshrink should cover the entire Copper Barrel and approximately 50mm of the cable jacket



Single Crimped Method



Multiple Crimped Method



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