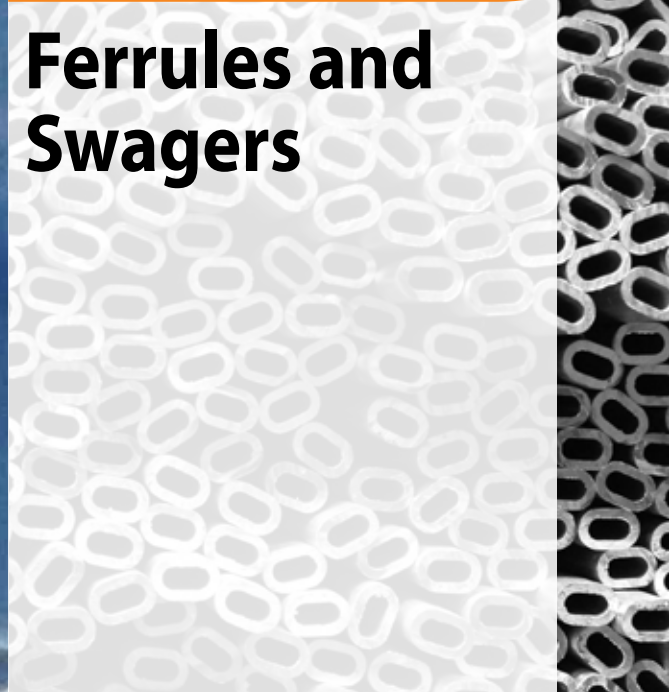


SECTION THREE

Ferrules and Swagers



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TALURIT®



TALURIT™ AB

The original mechanical splicing systems Bridco is the Australian and New Zealand distributor for Talurit AB, a prestigious and renowned Swedish company specialising in mechanical splicing systems since 1948.

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FERRULE SECURING INSTRUCTION - TALURIT[™] Rev. 2009-04-16

Please note these instructions are only applicable to products produced and supplied by Talurit AB, Sweden and Gerro GmbH, Germany!

Checking of the wire rope:

Begin by checking the diameter of the wire rope.
The measured diameter is applicable.

Check rope type, rope grade, type of rope lay and fill factor (f) or metallic cross-sectional area factor (C). Make sure the wire rope corresponds to requirements in the tables for each ferrule type.

Fill factor (f): The ratio between the sum of the nominal metallic cross-sectional areas of all the wires in the rope (A) and the circumscribed area (A_u) of the rope based on its nominal diameter (D).

$$f = \frac{A}{A_u} \quad C = f \cdot \frac{\pi}{4}$$

Ensure that the cut ends of pre-formed wire rope do not unlay. If a served rope end is to be pressed within the ferrule the serving shall consist only of a strand or wire. The serving material shall be of aluminium or annealed steel and shall have a tensile strength no greater than 400 N/mm². The diameter of the serving shall be no greater than 5% of the nominal rope diameter. Any serving within the ferrule before pressing shall be no longer than 0,5 x nominal rope diameter and the overall length of serving shall extend no further than 1 x rope diameter from the rope end.

Annealed ends must not be pressed inside the ferrule and annealed ends should not be longer than 0,5 x the wire rope diameter. Please also see our separate instructions for annealing machines type AV. Please note that our ferrules should only be used on new wire ropes.

Types of ferrules and their use:

T-ferrules (T), T-Konit[™] (TK), T-Konit[™] with inspection hole (TKH), Ultragrip[™] Metal (UM), Konit[™] (K), Steel (ST), Slimsteel[™] (SLST), Steel (STD) and Round (R) are intended for use on steel wire ropes made from carbon steel. The Copper ferrule (TCU), Round copper ferrule (RCU), stainless steel ferrule (INOX) and stainless steel terminals are intended for use with stainless steel wire ropes.

Note! Only ferrules type T, TKH and UM correspond to the European standard EN 13411-3.

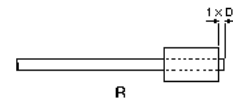
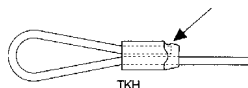
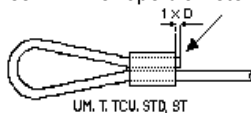
Select correct ferrule size:

The correct size of ferrule is selected from the applicable table for each type of ferrules. Note applicable rope types in each table. All our aluminium ferrules comply with this quality specification and to other material specifications stated in the ruling standards. All our ferrules are seamlessly extruded over mandrel.

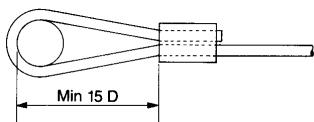
Ferrule selection is based on the following criteria: the rope grade, the diameter of the wire rope, the fill factor or metallic cross-sectional area factor, the wire rope core i.e. fibre core (FC) or steel core (IWRC= independent wire rope core).

Assembly of the wire rope in the ferrule:

Enter the wire rope into the ferrule. When the loop is formed the end of the wire rope is returned into the ferrule according to type as indicated in the figures D= wire rope diameter.



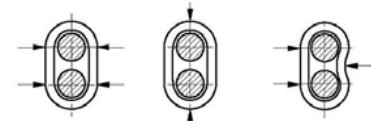
Before pressing conical ferrules with inspection hole, make sure that the short end of the wire rope is entered all the way to the back edge of the inspection hole!



If a thimble is not used, the distance from the unpressed ferrule to the bearing point of the soft eye must be at least 15 x the wire rope diameter (D), as per the figure. In some cases the sling eye should be even larger. Using a pin or a hook calculate 3 x pin diameter or the hook width to verify 15 x D or more.

The width of the eye without load shall be approximately half its length.

If the end of the wire rope is fixed in the ferrule before pressing then this should be done with care and preferably with controlled pressure, e.g. with our pre-pressing machines. Avoid faulty or unnecessary deformation of the ferrule. Do not clench or hammer in the middle of the long side of the ferrule. See figure.



CORRECT

WRONG

Press dies:

Check that the ferrule type and code number corresponds with the details stamped on the die. However our dies are not stamped with R and TCU-types; for these ferrule types use the type markings for T ferrules. Before pressing the dies should be carefully cleaned and the bore of the dies should be lightly lubricated. This will aid material flow and lengthen die life.

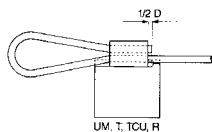
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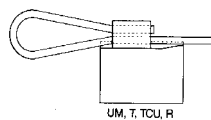
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Positioning of the ferrule in the dies before pressing:

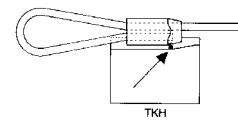
The following figures show how the ferrule should be positioned before pressing when using press dies with rounding or taper. In straight cylindrical dies the ferrule is placed in the middle of the cylindrical bore.



(Die with one-sided rounding)
Place the ferrule about half a wire rope diameter away from the die rounding.



(Conical die)
Place the ferrule centered in the straight cylindrical section of the die.

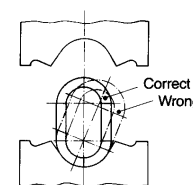


(Conical die)
Place the ferrule with the short wire rope end downwards and make sure the tap is in the inspection hole.

Pressing:

Make sure the dies are set up correctly and aligned. Lubricate the bore of the press dies. Press the ferrule, holding the wire rope with your two hands, one at each side of the dies. Attention! The closing dies imply a risk of crushing! The major axis of the oval ferrule cross-section must align with the direction of pressing. Use the regulating valve on the press to find the correct pressure in addition with an oil drop test*. On completion of the pressing operation the dies shall meet and pressing must stop! Do not overload the dies. The ferrule shall be pressed in one direction, without being turned. Fins or flash material shall be removed by a grinding method without damaging or reducing the round diameter of the ferrule. Any flash material shall not be pressed back into the ferrule.

* Oil drop test: place an oil drop on the supporting edge of the lower die. Use the regulating valve to close the dies. When the oil drop is pressed out of the closing dies the accurate pressure is achieved!



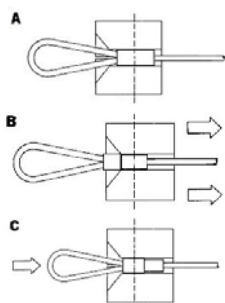
Multi bite pressing:

There are two types of dies for multi-bite pressing, a full length and a short type. **IMPORTANT!** Lubricate the bore of the press dies in every step!

This procedure is for the full-length type. The press dies are first fixed in the swager as usual (Fig. A) using the centre fixing position, and pressing takes place as per standard procedure utilizing full pressure. The pressing is completed when the dies fully touch. If the press dies do not touch fully they must be moved to the second fixing position and pressing of half the ferrule carried out with reduced pressure as per Fig. B. NOTE! The pressure must be decreased to almost half not to overload the dies.

This method also ensures the load remains over the centre of the piston. The remaining half ferrule length is pressed as per Fig. C.

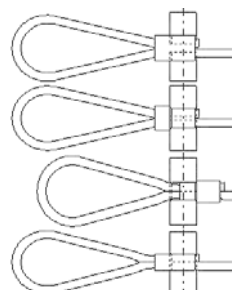
The procedure employing the short type dies involves moving the ferrule with the die remaining static in its fixed position see figure below. The pressure must be decreased to almost half the necessary pressure for full-length pressing.



Lubricate. Ferrule in middle of the die.

Lower the pressure. Move the die to its second fixing position. Lubricate. Press half the ferrule until the dies meet.

Lubricate. Press the remaining ferrule half.



Lubricate. Place the ferrule as shown in the picture. Reduce the pressure to half the value compared to full length.

Press the ferrule just about half the required distance.

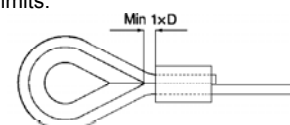
Lubricate. Now press the other side of the ferrule until the dies meet.

Lubricate. Press the first side of the ferrule once again, this time until the dies meet.

Checking and marking after pressing:

Check that the ferrule has been properly pressed and the wire rope is correct in alignment. Each ferrule shall be visually examined, free from flaws and defects. Any flash produced on the ferrules should be removed without damage to the ferrule or the rope. At each set-up the pressed ferrule shall be dimensionally checked to verify that it is within the diameter and when applicable length limits specified in the tables for ferrules. Each pressed ferrule after the set-up shall be checked for diameter to verify that it is within the diameter limits.

If a thimble is incorporated the point of the thimble should be at least $1 \times D$ (the diameter of the wire rope) away from the ferrule after pressing. See figure. When using a thimble without a point the distance shall be $1,5 \times D$. Thimbles shall be according to EN 13411-1.



Make sure the dead end of the wire rope protrudes from the ferrule after pressing. Our recommendation is approx. $0,5 \times D$ (the diameter of the wire rope), to exceed this can cause injury. In case of conical ferrule make sure the dead end is visible in the inspection hole. Marking of pressed ferrules should be carried out according to ruling standards. Use a steel stamp or our marking machines. The following maximum letter sizes and maximum depth of impression are valid:

For ferrule No.	Max. letter Size	Max. impression depth
8-24	3 mm	0,5 mm
24-110	5 mm	1,0 mm

Usage and scrapping:

Ferrule terminations of aluminium or copper shall not be exposed to temperatures outside the range -40°C to 100°C or to long-term submersion in seawater. Slings shall be taken out of use if their ferrules have been exposed to deformation or when the outer diameter has been reduced to less than 95% of the original diameter.

If you have wire ropes not covered by this instruction or have any technical questions, please contact our Technical Department for advice.

FERRULE SELECTION CHART BASED ON EN13411-3



T ferrule (T)
(aluminium)



T Konit with inspection hole
(TKH) (aluminium)

Matching wire rope to ferrule

Selection of the correct ferrule is to take account of:

- the measured rope diameter
- the rope type (and core)
- the nominal fill factor, f (or metallic cross-sectional area factor, C) of the rope. Very important for fibre core ropes.

Case 1

For **single layer** round strand ropes with **fibre core and cable-laid** ropes having a fill factor of at least 0,36 ($C \geq 0,283$) and max 0,45 ($C \leq 0,353$), a ferrule having a size / Code number equivalent to the measured rope diameter is to be selected from the table on page 53.

Case 2

For **single layer** round strand ropes with fibre core and cable laid ropes having a fill factor greater than 0,45 ($C > 0,353$) and for **single layer** round strand ropes with **metallic core and for rotation-resistant** round strand ropes having a fill factor up to 0,62 ($C \leq 0,487$), a ferrule having the next larger size / Code number than the measured rope diameter is to be selected from table on page 53.

Case 3

For **single layer** round strand ropes with **metallic core and for rotation-resistant** round strand ropes and parallel-closed round strand ropes having a **fill factor greater than 0,62 and up to 0,78** ($0,487 < C \leq 0,613$) the ferrule is to be selected from table on page 53.

Case 4

For **spiral strand** having a **fill factor of not greater than 0,78**, ferrules are to be selected having two size/code numbers larger than the actual rope diameter from table on page 1. Two ferrules spaced two rope diameters apart are to be used per termination. After pressing a space is to be maintained between ferrules. Please contact us for the table containing Case 4.

Application rope types and grade

Single layer, rotation resistant and parallel-closed stranded ropes conforming to EN 12385-4, stranded ropes conforming to EN 12385-5, spiral strand ropes conforming to EN 12385-10 and cable-laid ropes as specified in EN 13414-3. The maximum rope grade is to be 1960. The types of rope lay shall be Ordinary or Lang lay.

f = Fill Factor, is the ratio between the sum of the nominal metallic cross-sectional areas of all the wires in the rope and the circumscribed area of the rope based on its nominal diameter.

C = Nominal metallic cross-sectional area factor of the rope.

$$C = \frac{f \cdot \pi}{4}$$

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TALURIT™ SPLICING SYSTEM

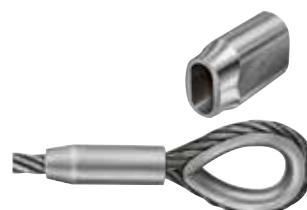
Tables of sizes for Aluminium T, TK and TKH ferrules

Ferrule No.	Wire rope Capacity Diameter (mm)						Die identification				Required pressure approx. kN
	Case 1 Fill factor 0,36≤f≤0,45 0,283≤C≤0,353		Case 2 Fill factor f≤0,62 C≤0,487		Case 3 Fill factor 0,62<f≤0,78 0,487<C≤0,613		Dies marked	Diameter after pressing		Length after pressing approx. mm	
T	Min	Max	Min	Max	Min	Max	T/TK/TKH	mm / Tol			
*GTA015	1,2	1,6	1,1	1,4			1,5	3,8	+0,2	8	10
GTA02	1,7	2,1	1,5	1,9			2	4	+0,2	9	20
GTA025	2,5	2,7	2,0	2,4			2,5	5		12	30
GTA03	2,8	3,2	2,5	2,7			3	6		14	45
GTA035	3,3	3,7	2,8	3,2			3,5	7		16	60
GTA04	3,8	4,3	3,3	3,7			4	8		18	80
GTA045	4,4	4,8	3,8	4,3			4,5	9		20	100
GTA05	4,9	5,4	4,4	4,8			5	10		23	125
GTA06	5,5	6,4	4,9	5,4			6	12	+0,3	27	180
GTA065	6,5	6,9	5,5	6,4			6,5	13		29	210
GTA07	7,0	7,4	6,5	6,9	6,0	6,4	7	14		32	250
GTA08	7,5	8,4	7,0	7,4	6,5	6,9	8	16		36	320
GTA09	8,5	9,5	7,5	8,4	7,0	7,9	9	18		40	410
GTA10	9,6	10,5	8,5	9,5	8,0	8,9	10	20	+0,4	45	500
GTA11	10,6	11,6	9,6	10,5	9,0	9,9	11	22		50	600
GTA12	11,7	12,6	10,6	11,6	10,0	10,9	12	24		54	720
GTA13	12,7	13,7	11,7	12,6	11,0	11,9	13	26		59	850
GTA14	13,8	14,7	12,7	13,7	12,0	12,9	14	28	+0,7	63	1 000
GTA16	14,8	16,8	13,7	14,7	13,0	13,9	16	32		72	1 300
GTA18	16,9	18,9	14,8	16,8	14,0	15,9	18	36	+0,9	81	1 600
GTA20	19,0	21,0	16,9	18,9	16,0	17,9	20	40		90	2 000
GTA22	21,1	23,1	19,0	21,0	18,0	19,9	22	44		99	2 400
GTA24	23,2	25,2	21,1	23,1	20,0	21,9	24	48	+1,1	108	2 900
GTA26	25,3	27,3	23,2	25,2	22,0	23,9	26	52		117	3 400
GTA28	27,4	29,4	25,3	27,3	24,0	25,9	28	56		126	3 900
GTA30	29,5	31,5	27,4	29,4	26,0	27,9	30	60	+1,4	135	4 500
GTA32	31,6	33,6	29,5	31,5	28,0	29,9	32	64		144	5 100
GTA34	33,7	35,7	31,6	33,6	30,0	31,9	34	68		153	5 800
GTA36	35,8	37,8	33,7	35,7	32,0	33,9	36	72	+1,6	162	6 500
GTA38	37,9	39,9	35,8	37,8	34,0	35,9	38	76		171	7 200
GTA40	40,0	42,0	37,9	39,9	36,0	37,9	40	80		180	8 000
*GTA42	42,1	44,1	38,4	40,3	37,0	38,9	42	84	+1,9	191	8 800
GTA44	42,1	46,2	40,0	42,0	38,0	39,9	44	88		198	9 700
*GTA46	46,3	48,3	42,1	44,1	39,0	40,9	46	92		209	10 600
GTA48	46,3	50,4	42,1	46,2	40,0	43,9	48	96		216	11 500
GTA52	50,5	54,6	46,3	47,9	44,0	47,9	52	104	+2,1	234	13 500
*GTA54	52,6	56,7	48,0	51,7	46,0	49,9	54	108		246	14 600
GTA56	54,7	58,8	54,6	51,9	48,0	51,9	56	112	+2,3	252	15 700
GTA60	58,9	63,0	54,7	58,8	52,0	54,6	60	120	+2,4	270	18 000

Please note that these instructions are only applicable to products produced and supplied by Talurit AB, Sweden and Gerro GmbH, Germany!



T ferrule (T)
(aluminium)



T Konit (TK)
(aluminium)



T Konit H (TKH)
(aluminium)

*These sizes are not included in the EN 13411-3 standard.

Table based on EN 13411-3:2004 + A1:2008

TK & TKH ferrules available on request.

T ferrules sized 62-152 available on request.

Ferrules: T and TKH have been validated according to EN 13411-3 regarding Ferrule Secured Eye terminations and Ferrule Secured Endless slings.
TK-ferrules have been validated according to TALURIT™ splicing system.

Wire rope: Above table applies to bright or galvanized single layer steel wire ropes with round strands and rope grade 1 570 – 1 960. Wire ropes shall conform to EN 12385-4 and 5. The types of rope shall be Ordinary or Lang lay.
For higher tensile grade we have an approved system called T-LOC. For higher and lower filling factor, please contact our Technical Department.
Note! Please refer to the TALURIT™ Ferrule Securing Instructions for further information.

f = Fill factor, is the ratio between the sum of the nominal metallic cross-sectional areas of all the wires in the rope and the circumscribed area of the rope based on its nominal diameter.

C = Nominal metallic cross-sectional area factor of the rope.

$$C = \frac{f \cdot \pi}{4}$$

TALURIT™ SPLICING SYSTEM

Table of sizes for Copper TCU ferrules

	Wire Rope Capacity Diameter (mm)				Die Identification		
	Fill factor (f=0,40-0,50) Fibre Core		Fill factor (f=0,50-0,60) Steel Core		Dies marked	Diameter after pressing	Required pressure approx.
TCU	Min	Max	Min	Max	T	(mm) / Tol.	(kN)
GTC015	1,1	1,5	1,0	1,4	1,5	3,8 +0,2	20
GTC02	1,6	2,0	1,5	1,9	2	4 +0,2	30
GTC025	2,1	2,6	2,0	2,4	2,5	5	45
GTC03	2,7	3,1	2,5	2,8	3	6	60
GTC035	3,2	3,6	2,9	3,3	3,5	7	80
GTC04	3,7	4,1	3,4	3,8	4	8	100
GTC045	4,2	4,6	3,9	4,2	4,5	9	125
GTC05	4,7	5,1	4,3	4,7	5	10	180
GTC06	5,2	6,1	4,8	5,6	6	12 +0,4	210
GTC065	6,2	6,6	5,7	6,1	6,5	13	250
GTC07	6,7	7,1	6,2	6,6	7	14	320
GTC08	7,2	8,2	6,7	7,5	8	16	410
GTC09	8,3	9,0	7,6	8,2	9	18	500
GTC10	9,1	10,1	8,3	9,2	10	20 +0,5	600
GTC11	10,2	11,2	9,3	10,2	11	22	720
GTC12	11,3	12,3	10,3	11,2	12	24	850
GTC13	12,4	13,4	11,3	12,2	13	26	1 000
GTC14	13,5	14,5	12,3	13,2	14	28 +0,7	1 300
GTC16	14,6	16,1	13,3	14,7	16	32	1 600
GTC18	16,2	18,2	14,8	16,6	18	36 +0,9	2 000
GTC20	18,3	20,2	16,7	18,4	20	40	2 400
GTC22	20,3	22,4	18,5	20,4	22	44	2 900
*GTC24	22,5	24,6	20,5	22,5	24	48 +1,1	3 400
*GTC28	27,0	28,6	24,7	26,1	28	56	4 500
*GTC30	28,7	30,8	26,2	28,1	30	60 +1.4	5 100

*Not stocked. Available on request.

Note! Ferrules made of copper (RCU, TCU and TCUK) have many application areas. One of them being the use together with wire ropes made of stainless steel. This is specially advantageous to avoid galvanic corrosion problems.

TCU and TCUK: The TCU and TCUK ferrules have been validated according to TALURIT™ splicing system, which is within the frames of EN 13411-3. Copper as material is not accepted in this standard. We do not guarantee strength of slings for lifting activities made of Copper turnback ferrules. A termination performed according to our instructions will normally withstand a tensile strength of 90% of minimum breaking load (MBL) of the wire rope. Verifying tests must be done in order to find out the strength. Please read our TALURIT™ Splicing Instructions carefully to secure a safe and correct swaging operation.

Wire rope: Above table applies to wire ropes made of stainless steel, bright or galvanized single layer steel wire ropes with round strands and rope grade 1 570 – 1 960. Wire ropes shall conform to EN 12385-4 and 5. The types of rope shall be Ordinary or Lang lay. For higher tensile grade and higher Fill factor, please contact our Technical Department. Note! Stainless steel as a material is not included in the EN standard for wire ropes.

Please refer to TALURIT™ Ferrule Securing Instruction for further information.

Please note that these instructions are only applicable to products produced and supplied by Talurit AB, Sweden and Gerro GmbH, Germany!



Copper ferrule (TCU)
(copper)

f = Fill factor, is the ratio between the sum of the nominal metallic cross-sectional areas of all the wires in the rope and the circumscribed area of the rope based on its nominal diameter.

C = Nominal metallic cross-sectional area factor of the rope.

$$C = \frac{f \cdot \pi}{4}$$



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TALURIT™ SPLICING SYSTEM

Table of sizes for Stainless Steel INOX ferrules

Wire Rope Capacity Diameter (mm)					Die Identification			
	Fill factor (f=0,42-0,52) Fibre Core		Fill factor (f=0,53-0,58) Steel Core		Dies marked	Diameter after pressing		Required pressure approx.
Code	Min	Max	Min	Max	INOX	(mm) / Tol.		(kN)
GTS015	1,2	1,6	1,1	1,4	1,5	3,9	+0,15	100
GTS02	1,7	2,2	1,5	2,0	2	4,5	0	160
GTS025	2,3	2,7	2,1	2,6	2,5	5		200
GTS03	2,8	3,2	2,7	3,0	3	6		250
GTS035	3,3	3,7	3,1	3,5	3,5	7,8		300
GTS04	3,8	4,2	3,6	4,0	4	8		350
GTS045	4,3	4,7	4,1	4,5	4,5	9,8		400
GTS05	4,8	5,4	4,6	5,0	5	10,8	+0,3	500
GTS06	5,5	6,4	5,1	6,1	6	12	0	600
GTS07	6,5	7,4	6,2	7,1	7	14		700
GTS08	7,5	8,4	7,2	8,1	8	16		850
GTS09	8,5	9,5	8,2	9,1	9	18		1 000
GTS10	9,6	10,5	9,2	10,1	10	20	+0,4	1 100
*GTS11	10,6	11,5	10,2	11,1	11	21,3	0	1 350
GTS12	11,6	12,6	11,2	12,2	12	24		1 500
GTS13	12,7	13,6	12,3	13,2	13	26		1 750
*GTS14	13,7	14,6	13,3	14,2	14	28	+0,5	2 000
GTS16	14,7	16,7	14,3	16,2	16	32	0	2 500
GTS18	16,8	19,0	16,3	18,2	18	36	+0,6	3 100
*GTS20	19,1	21,0	18,3	20,2	20	40	0	3 400
GTS22	21,1	23,1	20,3	22,2	22	44		3 900
*GTS24	23,2	25,2	22,3	24,2	24	48	+0,8	4 500
*GTS26	25,3	27,3	24,3	26,4	26	52	0	5 000
*GTS28	27,4	29,4	26,5	28,4	28	56		5 600
*GTS30	29,5	31,5	28,5	30,3	30	60		6 000

*Not stocked. Available on request.

Ferrules have been validated according to TALURIT™ splicing system.

Note! We do not guarantee strength of slings for lifting activities made of INOX-ferrules. A termination performed according to our instructions will normally withstand a tensile strength of 90% of the minimum-breaking load (MBL) of the wire rope. Verifying tests must be done in order to find out the strength.

Wire rope: Above table applies to stainless steel single layer wire ropes with round strands and rope grade 1570.

For higher tensile grade and higher Fill factor, please contact our Technical Department.

Please refer to TALURIT™ "Ferrule Securing Instructions" for further information.

Please note that these instructions are only applicable to products produced and supplied by Talurit AB, Sweden and Gerro GmbH, Germany!



f = Fill factor, is the ratio between the sum of the nominal metallic cross-sectional areas of all the wires in the rope and the circumscribed area of the rope based on its nominal diameter.

C = Nominal metallic cross-sectional area factor of the rope.

$$C = \frac{f \cdot \pi}{4}$$

TALURIT™ SPLICING SYSTEM

Table of sizes for Round Aluminium R ferrules

Die Identification						
Code	Fill factor (f=0,50-0,60) Steel Core		Dies marked		Diameter after pressing	
	Min	Max	T	(mm) / Tol.	Required pressure approx. (kN)	
GTR03A	2,0	2,8	3	6	+0,1	60
GTR04A	2,9	3,8	4	8	0	100
GTR05A	3,9	4,7	5	10		180
GTR06A	4,8	6,1	6	12	+0,3	210
GTR08A	6,7	7,5	8	16	0	410
GTR10A	8,3	9,2	10	20	+0,4	600
GTR12A	10,3	11,2	12	24	0	850
GTR13A	11,3	12,2	13	26		1 000
GTR14A	12,3	13,2	14	28	+0,5	1 300
GTR16A	13,3	14,7	16	32	0	1 600
GTR18A	14,8	16,6	18	36	+0,6	2 000
GTR20A	16,7	18,4	20	40	0	2 400
GTR24A	20,5	22,5	24	48	+0,8	3 400
GTR28A	24,7	26,1	28	56	0	4 500

Please note that these instructions are only applicable to products produced and supplied by Talurit AB, Sweden and Gerro GmbH, Germany!



Round ferrule (R)
(aluminium)

TALURIT™ SPLICING SYSTEM

Table of sizes for Round Copper RCU ferrules

Die Identification						
Code	Fill factor (f=0,50-0,60) Steel Core		Dies marked		Diameter after pressing	
	Min	Max	T	(mm) / Tol.	Required pressure approx. (kN)	
GTRCU02	0,8	1,9	2	4	+0,1	30
GTRCU03	2,0	2,8	3	6	0	60
GTRCU04	2,9	3,8	4	8		100
GTRCU05	3,9	4,7	5	10		180
GTRCU06	4,8	6,1	6	12	+0,3	210
GTRCU07	6,2	6,6	7	14	0	320
GTRCU08	6,7	7,5	8	16		410

Please note that these instructions are only applicable to products produced and supplied by Talurit AB, Sweden and Gerro GmbH, Germany!



Round ferrule (RCU)
(copper)

Note! Ends stops (R and RCU) are not allowed to use for lifting applications. The expected strength regarding this end-termination is approximately 50% of the MBL of the wire rope (informative only). Accordingly, verifying tests must be performed to secure the strength of the application.

Wire rope: Above table applies to wire ropes made of stainless steel, bright or galvanized single layer steel wire ropes with round strands and rope grade 1 570 – 1 960. Wire ropes shall conform to EN 12385-4 and 5. The types of rope shall be Ordinary or Lang lay. For higher tensile grade and higher Fill factor, please contact our Technical Department.

Please refer to TALURIT™ Ferrule Securing Instruction for further information.

f = Fill factor, is the ratio between the sum of the nominal metallic cross-sectional areas of all the wires in the rope and the circumscribed area of the rope based on its nominal diameter.

C = Nominal metallic cross-sectional area factor of the rope.

$$C = \frac{f \cdot \pi}{4}$$

TALURIT®

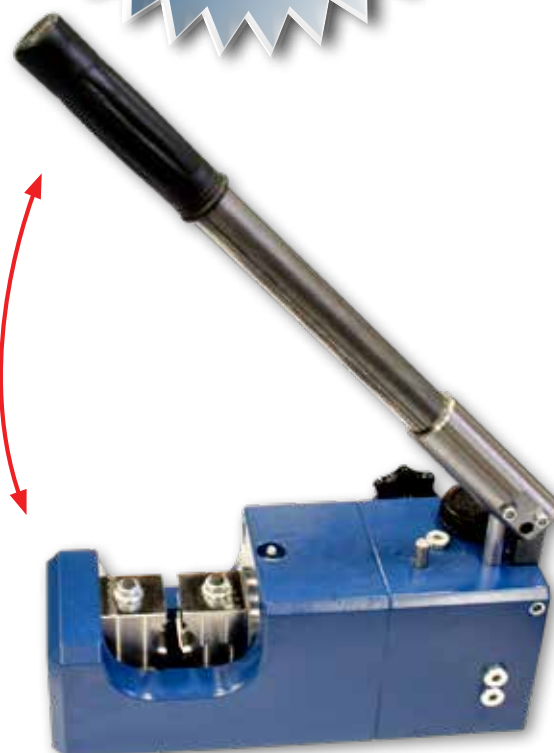
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20 TON 1-PILLAR SWAGER TALURIT™

TALURIT™ – here with a small Swager with high capacity



Economically priced
Robust design
Total reliability
Easy to place
Easy to carry
Easy to use



TALURIT™ SWAGERS

The 20-ton Swager has a single pillar open throat design and the built in pump is very efficient. Less than 20 strokes close the dies!

Due to lightweight and easy operation it is suitable to use in the field.

The pump handle is also used as a carrying handle in its locked position.

In a single stage swage T-ferrules up to No. 6,5 can be swaged. Multi stage swaging makes it possible to swage T-ferrules up to No. 9.

Note! All our dies are manufactured from hardened and tempered die steel for long life and durability.

Operating the pump: Close the relief valve on the pump and start pumping the handle to close the dies. Open the relief valve to open the dies.

swager

TECHNICAL DATA

Part Number: GPP20T

Max. swaging force (kN)	200	Type of die	A
Max fluid pressure (bar) approx.	630	Max. die length (mm)	39
Length of stroke (mm)	13	Dimensions L x W x H (mm)	400 x 150 x 160
Capacity - Single stage (T) - Multi stage (T/UM)	6,5 9/10	Weight (kg)	18,7

T SWAGER - TYPE 1P

TALURIT™ SYSTEM

GENERAL DESCRIPTION

The 40 ton Swager has a single pillar open design and can be used either vertically, horizontally and upside down. Options such as a stabilizing plate or a tilted adjustable stand are available. The 40 ton Swager offers total flexibility and is easy to use in the field due to its light weight and easy operation.

OPERATIONAL INFORMATION

The new 40 ton swager is both efficient and safe! It has the capacity to press T-ferrules up to size No. 9 in single stage swaging, and T-ferrules up to size No. 13 in multi stage swaging. The swager can be used with A and A1 TALURIT™ dies. All dies are manufactured from hardened and tempered die steel for a long service life, durability and excellent swaging results.

The swager can be fitted with two different models of electrical hydraulic units. The basic electrical hydraulic unit (HAGG 2,2/700-V2) comes with both up/down function and "hold position" to facilitate rope/eye adjustment and to make tool set-up quicker. To minimize cycle time when pressing, the HAGG 2,2/700-V2 is also equipped with a stroke limiter that allows control of the retraction stroke length of the piston when operating the swager.

The new 40 ton swager can also be fitted with a manual hydraulic unit, P59L-40, for operating the swager. All hydraulic hoses come with quick couplings for easy handling and quick setup of the swager.



swager TECHNICAL DATA			
Part Number: GPP40T	Value		Unit
Max. Swaging force	400		kN
Max. oil pressure	700		bar
Length of stroke	22		mm
Dimensions (L x W x H)	146 x 146 x 340		mm
Weight	37		kg
TYPE OF DIES:	A (38x42)	A1 (38x50)	-
- Capacity single stage	8 (T-ferrule)	9 (T-ferrule)	-
- Capacity multi stage	10 (T-ferrule)	13 (T-ferrule)	-
OPTIONS:			
Handle	Art No: 40T HANDLE		-
Stabilizing plate	Art No: 40T STAB PLATE		-
Adjustable stand	Art No: 40T ADJ STAND		-
MA 800 - Pressure Gauge	Art No: MA 800		-

hydraulic units TECHNICAL DATA			
HAGG 2,2/700	Value		Unit
Power supply and Nominal current at:	415V (50 Hz)	9,5	A
Power		2,2	kW
Cycle time (Single stage, full stroke)		9,8	s
Reservoir volume		2,5	l
Inlet/Outlet threads on couplings		1/4" BSPP	inch
Noise level		78	dB (A)
Dimensions (L x W x H)		630 x 290 x 310	mm
Weight		41,0	kg
Foot pedal		Included	-
Hold position		Included	-
Stroke limiter		Included	-
Hand Pump: P59L-40			
Max Fluid Pressure		700	bar
Weight		4,1	kg
Dimension (L x W x H)		535 x 121 x 178	mm
Hose with quick coupling		800	mm

TALURIT®

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For our environment:



- automatic power shut down
- efficient swage cycle time
- water-based paint

The compact and powerful swager!

- Economically priced
- Robust design
- Total reliability
- User friendly
- Automatic power shut down
- Variable speed (GREEN OPTION)

130T SWAGER - TYPE 1S TALURIT™ SYSTEM

GENERAL DESCRIPTION

The 130-ton Swager has a single pillar open throat design. It can be mounted either in upright position or upside down in a flat or tilted position (the different mounting positions is shown on the next page). This swager is easy to use and the open design allows comfortable access to the swaging area. An efficient 4 kW hydraulic unit (HAGG 130T) completes the swager system.

In single stage this 130T swager has a capacity to swage T and UM ferrules up to size 16. Size 20 is maximum for these ferrules using multi stage swaging.

The swaging operation is controlled by an electric twin pedal, i.e. a foot control and is permitting the operator using both hands to handle the rope assembly.

FERRULES/FITTINGS	CAPACITY
T (aluminum)	can be swaged up to size 16 in single stage (up to size 20 multi stage).
UM (aluminum)	can be swaged up to size 16 in single stage (up to size 22 multi stage).
STT Sockets/Terminals (carbon steel)	1/4"
TAL-X Flemish Eye Sleeves (carbon steel)	5/8"

Note! Values above are approximate guidelines



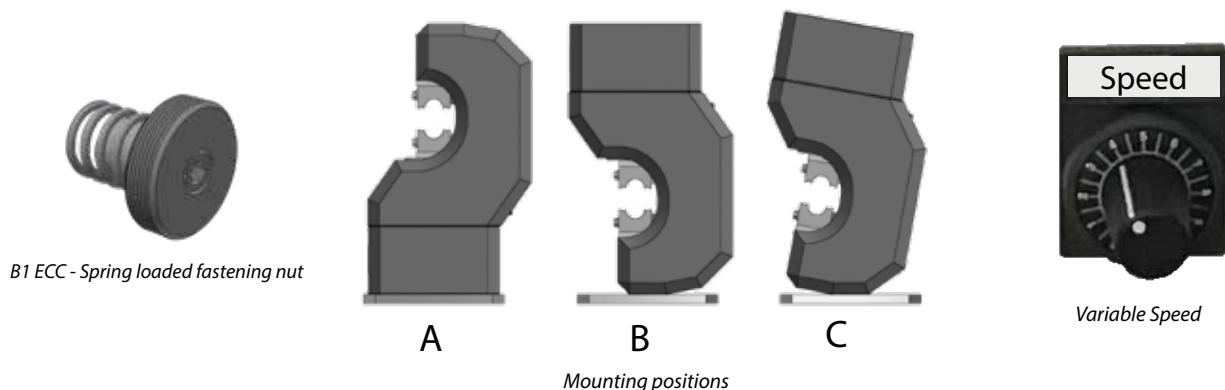
In addition to the standard up/down function, the foot control can activate a "hold position" to facilitate rope or sling eye adjustment making tool set-up quicker.

The retraction length of the stroke can be adjusted by the stroke limiter. The hydraulic unit shuts down after an adjustable idle time, and can be started again by just pressing the control pedal. This energy saving feature is also in addition reducing the already low noise level.

Pressure gauge

With the pressure gauge, MA 130T, it is possible to pre-set the required pressure and get the die set to open automatically once this pre-set pressure is reached. Saving production cycle time and reducing operator movements and wear of the dies.

EQUIPMENT	STANDARD	OPTIONS
Die holder	FIX B1	-
Dies	B1 and B2	-
Power	4 kW	-
Electrical pressure gauge	MA 130T	-
Fastening nut for eccentric load (for example TAL-X and swaged terminals)	-	B1 ECC
Different mounting positions for press head (with reference to next page)	A	B or C
Variable Speed (more info on next page)	-	VS



OPTIONAL EQUIPMENT

Die holder

The base die holder for the 130T swager is FIX B1/B2. Add the spring loaded fastening nut B1 ECC to convert the die holder into a system suitable for swaging flemish eye sleeves and terminals. B1 ECC will make the dies float.

Dies

Die sizes B1 (48x70 mm) and B2 (50,2x70 mm) are standard.

Note! All our dies are manufactured from high quality, hardened, and tempered steel for long life time and durability.

Variable speed

This is the more environmental friendly choice. When adding the variable speed (VS) option the speed of the piston can be customized. By turning up the speed adjustment to maximum the piston will move with 9,6mm/s up to a force of 30 ton. It will then slow down until maximum force is reached and the piston is moving with 1,8mm/s. The speed adjustment can be set at any speed between 1,8-9,6mm/s.

CAPACITY					
STANDARD	Max swaging force		1300 kN		
	Max. fluid pressure		Approx. 313 bar		
	Working pressure		0-313		
	Length of stroke		45 mm		
	Die block sizes		B1 and B2		
	Inlet/outlet threads on couplings		3/8"		
	Amount of oil		30 l (oil is not delivered with the swager)		
	Noise level		less than 70 (dB (A))		
	Dimensions L x W x H		350x720x1425 mm		
	Height of table		845 mm		
	Working height (centre line where dies are closed)		1197 mm		
	Weight		460 kg (without oil)		
	Rated current at	240/400V 50Hz		14/8,5A	
		230V 60Hz		20A	
1S	Piston velocity	pressing speed	50Hz - 4mm/s	60Hz - 5mm/s	
		return speed	50Hz - 5,7mm/s	60Hz - 6,8mm/s	
	Power	50Hz	4,0kW		
		60Hz	5,5kW		
VS	Piston velocity	speed depending on pressure	9,6mm/s up to a pressure of 30T		
			1,8mm/s at maximum pressure		
	Power		4,0kW		

TALURIT®

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For our environment:



- automatic power shut down
- efficient swage cycle time
- water-based paint

- **Powerful**
- **Versatile**
- **Reliable**
- **User friendly**
- **Automatic shut down**
- **Short process cycle time**
- **Environmentally friendly**
- **Compatible with several types of dies**

250T SWAGER - TYPE 1S TALURIT™ SYSTEM

GENERAL DESCRIPTION

The 250-ton swager has a single pillar open throat design. It offers total flexibility. This swager is easy to use and the open design allows easy access to the dies. The swager is fitted with a hydraulic unit.

The swager body is manufactured from one single block construction that ensures strength, long service life and a minimum of maintenance. All swagers are thoroughly test run.

The 250T swager has a capacity to swage T, TS and UM ferrules up to approximate no. 22 in single stage. Multi stage swaging makes it possible to swage T and UM ferrules up to No. 30.

The swaging operation is controlled by an electric foot pedal permitting the operator to use both hands to handle the rope assembly when swaging.



In addition to the standard up/down function, the foot pedal has a "hold" position toggle to facilitate rope/eye adjustment and to make tool set-up quicker.

By setting the required pressure on the pressure gauge MA 250T-1S, the piston returns automatically once the pressure is reached. This saves time and unnecessary movements for the operator. When left un-used the resource saving automatic shut down will turn off the machine, but is easy to start again by pressing down the foot pedal.

An oil cooler is built into the swager to cool down the hydraulic oil.

Note! All our dies are manufactured from hardened and tempered die steel for long life and durability.

FERRULES/FITTINGS	CAPACITY
T (aluminum)	can be swaged up to size 22 in single stage (up to size 30 multi stage).
UM (aluminum)	can be swaged up to size 22 in single stage (up to size 30 multi stage).
STT Sockets/Terminals (carbon steel)	can be swaged up to size 5/8".
TAL-X Flemish Eye Sleeves (carbon steel)	can be swaged up to size 1".

Note! Values above are approximate guidelines

EQUIPMENT	STANDARD	OPTIONS
Die holder	• FIX C1 250T	• FIX 2,5"x5"
Insert die holders	• VIN C/C1	• VIN B1/C1 • VIN 2"x3,5"/2,5"x5"
Power	Power Pack 4 kW	-
Electrical pressure gauge	MA 250T -1S	-
Oil Cooler	Oil Cooler 250T	-
Noise Level	approx. 70 dB(A)	Silencer 250T (approx. 68 dB(A))



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OPTIONAL EQUIPMENT

Dies and insert die holders

Die size C, C1 are standard. With the die holder FIX 2,5"x5" dies size 2,5"x5" can be used. Dies C1 is for swaging with several stage. With optional insert die holders smaller dies can be used:

- VIN B1/C1 for dies size B1
- VIN 2"x3,5"/2,5"x5 for dies size 2"x3,5"

Die holders

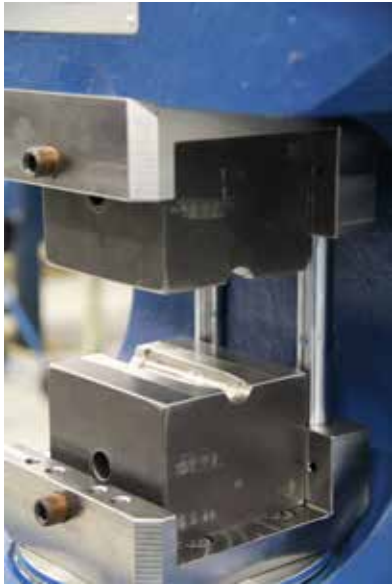
- FIX C1 250T Standard die holder with pillar guide. Dies are locked with bolts.
- FIX 2,5"x5" Optional die holder with pillar guide. Dies are locked with bolts.

Noise level (SILENCER 250T)

Optional SILENCER 250T with extra insulation can reduce the noise level to less than 68 dB(A).

TECHNICAL DATA

Art No. P 0250T 1S	
Max swaging force (kN)	2500
Max. fluid pressure (bar)	Approx. 313
Power (kW)	4
Rated current at 240/400 V (A)	17/8,5
Length of stroke (mm)	55
Piston velocity	
- high pressure (mm/s)	2,07 (2,48 at 60 Hz)
- low pressure (mm/s)	10,09 (12,1 at 60 Hz)
Amount of oil (l)	30 (oil is not delivered with the machine)
Dimensions L x W x H (mm)	1050x 670 x 1450
Standard working height (mm)	1065
Weight without oil (kg)	approx. 1050



FIX C1 250T



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TALURIT™ SWAGERS

In addition to the swagers listed in this catalogue, Talurit AB offers a range of larger swagers all the way up to 4200ton, making it possible to swage aluminium ferrules for nominal wire rope up to 160mm diameter.

The machines are designed to achieve safe and efficient mechanical splicing of steel wire ropes with many types of end fittings. The company uses the very latest techniques in engineering to ensure our manufacturing processes are to the highest quality standard while maintaining cost effectiveness as well as highest possible safety level. Key components are fully traceable with material certificates and quality inspections. All our swagers are manufactured in our work shop in Gothenburg, Sweden.



1000t swager



4200t swager with RBS 130

TALURIT™ CUTTING MACHINES

Talurit Group has developed a broad range of wire rope cutting and annealing machines over the years. The cutting machines include basic hand cutters, manually operated hydraulic shears, annealing and tapering machines, and many different fully automatic cutting machines.

The annealing machines also include manual and fully automatic machines. The automatic cutting machines with shears are very efficient and proven to have short pay back time. The machines are manufactured with safety and environmental concerns in mind.

Cutting machines are mainly intended for cutting preformed wire rope. We have a wide range of manual and automatic machines to choose from. The ideal machine can be chosen depending on the volumes of cutting required and the wire rope diameter range.

Our annealing machines do not use shears, the wire rope is twisted off by annealing. Current is applied to heat the wire when the rope is clamped. When the rope is red hot, it is twisted and pulled. After twisting, the rope is slightly rounded and the wires will not unwind. By increasing the distance between the clamping chucks the wire end becomes more pointed, e.g. ideal for excavating machines etc.



LK45 15 on stand



AV30 Annealing machine



Annealed end



Square cut end

DIE SETS FOR ALUMINIUM AND COPPER FERRULES

TYPES OF DIES



K,
Conical Press Dies



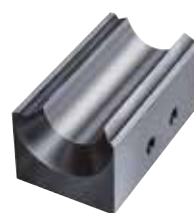
KH,
Conical Press Dies
with inspection hole



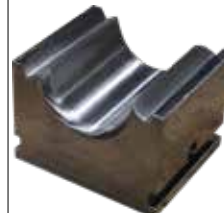
R,
Cylindrical Press Dies
(straight)



A,
Cylindrical
Press Dies
(one sided rounding)



FR,
Cylindrical Several
Stage Press Dies



FRK,
Cylindrical short
Several Stage Press
Dies

MARKING AND IDENTIFICATION OF DIE SETS

The set of dies to the right is identified as B1 R 12/13, explaining block size, type of bore and ferrule to be used.

- Block size
B1 in the picture to the right, is standard for a 150T swager. The standard block sizes for different swagers are shown in the table of page 2.
- Type of die
R in the picture, means that the bore is straight.
Different types of dies are shown on top of the page.
- Size of ferrule to be swaged.
12/13 in the picture, means that both
T 12 and UM 13 can be swaged.

Conical Press Dies

Marked K and KH (also T, TK / UM, K for ferrules)

Used for pressing of conical ferrules type TK and K and also straight cylindrical ferrules as T, TS, TCU, UM and R.

Marked K and KH (also TKH for ferrules)

Used for pressing of TKH ferrules with inspection holes. With blind taps they can also be used as the above mentioned conical dies for other ferrules. Patented solution and required in most standards for conical pressed ferrules.

Cylindrical Press Dies, straight or one sided rounding

Marked A (also T / UM for ferrules)

Usually provided with completely straight form but may also be delivered in one-sided rounding on request.

Combined Cylindrical Press Dies

Marked R (also T for ferrules)

Supplied in the following combinations:

BLOCK SIZE	Nos.				
B and B1	1+1,5	2+2,5	3+3,5		
C	1+1,5	2+2,5	3+3,5	4+4,5	5+6

Cylindrical Several Stage Press Dies

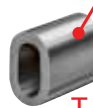
Marked FR and FRK (also T / UM for ferrules)

For pressing in several stages of cylindrical ferrules.

Supplied in straight form and in two types, long and short.



The other markings are explained on page 2



T



UM



WHICH WIRE ROPE TERMINATION

There are many different combinations and uses for Bridco stainless steel fittings and wire rope terminations.

The information shown in the centre spread of the catalogue is intended as a guide to help select the combination or system most suited for your application.

For further dimensions including dimensions and maximum loads on these and many other Bridco stainless steel products, refer to appropriate page in our catalogue or consult your Bridco stockist.

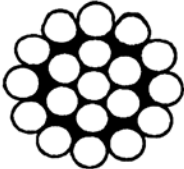
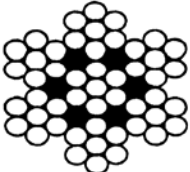

SWAGE EYES

It is recommended for the eye to be formed around the thimble.

Swage ferrules (crimps) on stainless steel wire should always be copper or stainless steel (inox).

Aluminium ferrules are not suitable and should only be used on galvanised wire.

THE MOST COMMON STYLES OF WIRE ROPE

	1 X 19	STIFF COMMONLY USED FOR STANDARD RIGGING, MAST STAYS, ETC. HAS A SMOOTH FINISH AND LOOKS GOOD WITH SWAGE TERMINALS.
	7 X 7	SEMI FLEXIBLE EASY TO HAND CRIMP AND CAPABLE OF LIMITED ANGLES. COMMONLY USED ON BALUSTRADING AND SAFETY RAILS.
	7 X 19	VERY FLEXIBLE EASIEST TO HAND CRIMP. USED FOR RUNNING RIGGING OR WHERE SHARP TURNS ARE REQUIRED.

AISI 316 offers the highest resistance to corrosion and is often regarded as the premium grade. It is recommended to use AISI 316 if materials are exposed to a heavy salt environment.



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PLATED COPPER HAND SWAGE SLEEVES

CODE	FOR WIRE SIZE MM	FOR WIRE SIZE IMP	BORE *1	LENGTH BEFORE SWAGING	BITES PER SLEEVE (MIN) *2
THS-115P	1.6	1/16"	5	9.7	2
THS-120P	2	5/64"	6	10.7	2
THS-130P	2.5 & 3	3/32" & 1/8"	5	11.5	2 – 3
THS-140P	4	5/32"	11	15.9	2 – 3
THS-150P	5	3/16"	15	22.2	2 – 3
THS-160P	6	1/4"	16	22.2	3
THS-180P	8	5/16"	17	28.4	3
THS-110P	10	3/8"	19	38.1	3

• 1 BORE = Approx. dia of cavity in the pressing tool or die used for pressing.

* 2 = When using Bridco hand tool

Note: Hand swage ferrules are not designed to any recognised standard and should never be used for any critical or lifting applications. The Talurit TCU range is designed for this application.



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ALUMINIUM HAND SWAGE SLEEVES

CODE	FOR WIRE SIZE MM	FOR WIRE SIZE IMP	BORE *1	LENGTH BEFORE SWAGING	BITES PER SLEEVE (MIN) *2
THS-115A	1.5	1/16"	5	9.7	2
THS-120A	2	5/64"	6	10.7	2
THS-130A	2.5 & 3	3/32 & 1/8"	8	11.5	2 – 3
THS-140A	4	5/32"	11	15.9	2 – 3
THS-150A	5	3/16"	15	22.2	2 – 3
THS-160A	6	1/4"	16	22.2	3

• 1 BORE = Dia of cavity in the pressing tool or die used for pressing.

* 2 = When using Bridco hand tool

Note: Hand swage ferrules are not designed to any recognised standard and should never be used for any critical or lifting applications. The Talurit T range is designed for this application.



HAND SWAGING SLEEVES

COPPER SLEEVES FOR FIBRE ROPE

CODE	USE TOOL	FOR ROPE	BORE	LTH BEFORE SWAGING	BITES PER SLEEVE
CP-140R	CP-763	4mm	6.9	6	1
CP-160R	CP-775	6mm	9.1	8	1
CP-180R	CP-775	8mm	10.9	8	1
CP-110R	CP-778	10mm	12.8	10	2

NOTE: For best results 2 sleeves should be used for each eye swage when using fibre rope.





BRIDCO HAND SWAGES

The CP range of copper and aluminium sleeves (ferrules) are specifically designed for use with hand crimping tools. The results, when used with the correct tools, properly adjusted, are extremely strong with an even structure of metal surrounding the wire. Copper sleeves are recommended for use on stainless steel wire ropes. For galvanised wire ropes, aluminium sleeves can be used.

Please note that although hand crimping can give excellent results it should not be used on wire used for lifting purposes. Use approved methods only.

STOPPERS

CODE	SUIT WIRE	BEFORE SWAGE DIA	AFTER SWAGE DIA	STARTS SLIPPING (KG)
CP-115S	1.5MM	5.1	3.5	195
CP-130S	3.2MM	6.35	5	340
CP-140S	4.0MM	10.5	6.8	545
CP-150S	5.0MM	10.9	7.5	725

Use normal hand swage tool for crimping stoppers, use the hole one size below the wire size ie: 3mm wire rope use 2mm hole on the tool.

PRESSING PROCEDURE

1. Feed the wire through the ferrule to leave at least one wire diameter in length protruding from ferrule.
2. Beginning at the tail end of the ferrule press along the length of the ferrule using the full width of the plier jaw.
3. Rotate the ferrule 90 degrees and repeat, pressing surplus metal back into the ferrule.
4. Rotate back 90 degrees and repeat the process.





HAND SWAGE TOOLS

CODE	TO PRESS SLEEVES
HS-123HC	1.5mm (1/16"), 2.0mm, 2.5mm (3/32"), 3.0mm (1/8")
HS-345HC	3mm (1/8"), 4mm, 5mm (3/16")
HS-6810HC	6mm (1/4"), 8mm, 10mm (3/8")



HEX SWAGE PLIERS

CODE	HEX SWAGE PLIERS	OVERALL LENGTH	WEIGHT KG
CP-793H	3mm HEX SWAGE PLIERS	900mm	6
CP-794H	4mm HEX SWAGE PLIERS	900mm	6



WIRE ROPE CUTTERS

CODE	BRAND	MAX WIRE SIZE	OVERALL LENGTH	WEIGHT KG
CP-FELC07	FELCO	7mm	190mm	0.27
CP-FELC09	FELCO	9mm	325mm	0.75
CP-FELC12	FELCO	12mm	500mm	1.50
CP-FELC16	FELCO	16mm	590mm	2.30



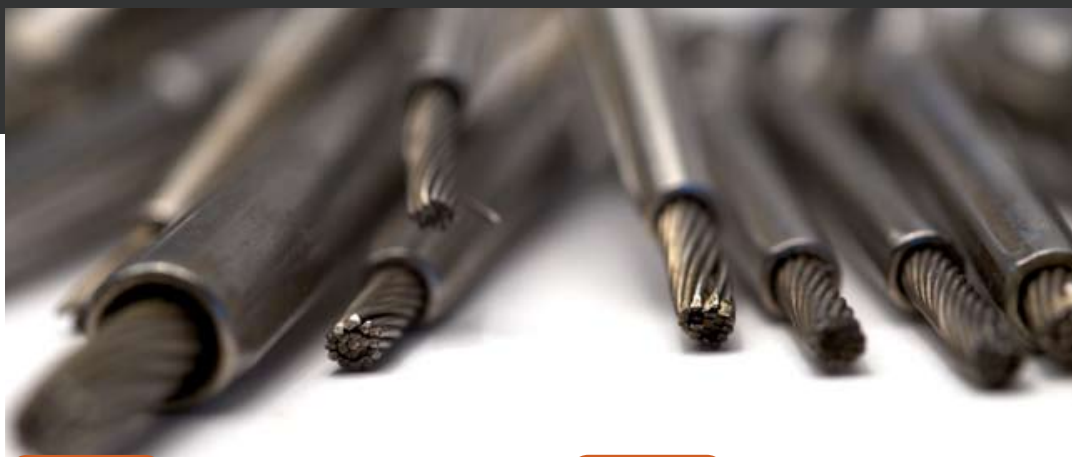
BRIDCO ECONOMY ROPE CUTTERS

CODE	MAX WIRE	OVERALL	WEIGHT KG
CP-WRC04	4mm	200mm	0.31



Dimensions

WORLD STANDARD OF SWAGING



mm

WIRESIZE BEFORE SWAGING	DIAMETER BEFORE SWAGING	DIAMETER AFTER SWAGING
1.6	4.06/3.94	3.50/3.40
2.5	5.53/5.41	4.82/4.7
3	6.35/6.22	5.56/5.44
4	7.54/7.42	6.35/6.23
5	9.12/9.00	7.95/7.83
5.5	10.84/10.72	9.50/9.35
6	12.54/12.42	11.12/10.95
7	14.30/14.18	12.70/12.50
8	16.13/16.01	14.30/14.07
9-10	17.85/17.73	15.90/15.70
11	19.83/19.63	17.47/17.27
12	21.44/21.32	19.05/18.82
12E	20.08/20.00	17.80/17.60
14	25.00/24.88	22.23/22.00
16	28.17/28.05	25.40/25.15
19	34.52/34.40	31.75/31.44
22	40.46/40.21	36.50/36.20
25	46.02/45.77	41.28/40.97
28	50.0	44/44.5
32	58.0	51.0/51.5
36	65.0	57.0/57.8
38~40	72.0	63.2/64.0

inch

WIRESIZE BEFORE SWAGING	DIAMETER BEFORE SWAGING	DIAMETER AFTER SWAGING
1/16	.160/.155	.138/.133
3/32	.218/.213	.190/.185
1/8	.250/.245	.219/.214
5/32	.297/.292	.250/.245
3/16	.359/.354	.313/.308
7/32	.427/.422	.375/.368
1/4	.494/.489	.438/.431
9/32	.563/.558	.500/.492
5/16	.635/.630	.563/.554
3/8	.703/.698	.625/.618
7/16	.781/.773	.688/.680
1/2	.844/.839	.750/.741
9/16	.984/.979	.875/.866
5/8	1.109/1.104	1.000/.990
3/4	1.359/1.354	1.250/1.238
7/8	1.593/1.583	1.437/1.425
1	1.812/1.802	1.625/1.613
1 1/8	1.968	1.732/1.751
1 1/4	2.284	2.007/2.028
1 3/8	2.559	2.244/2.275
1 1/2	2.835	2.488/2.519
1 3/4	2.952	2.598/2.640

Note

The swager is designed to reduce the terminal shank to required diameter in one pass. However dimension variations of terminals, cables or material hardness could make it necessary to pass the terminal twice.

Note: When swaging solid rods, a special swaging compound must be used. After swaging wipe off the roller dies and swaging machine, and apply a corrosion preventative.



WWW.WIRETEKNIK.SE



OUR SMALLEST MACHINE.

A100



Hand pump P19L is standard equipment.



*Without Handpump, 13 kg (29 lbs)
with Handpump P19L.*

Dimensions:
L=440 mm (17 1/2")
W=300 mm (11 3/4")
H=135 mm (5 1/4")
Weight: 11 kg (24 lbs)

The Bantam Machine.

A perfect machine for swaging on-site. Low weight and small outer dimensions makes it extremely portable.

Swaging Range: 1,6-5 mm wire. (1/16"-3/16")

Typical applications:

- Architectural, like balustrades and railing.
- Scenographic use at theaters for hanging and supporting set pieces.
- Onboard joining of towing lines for NATO's aviation practice targets.
- Shop fitters use it to make spectacular product displays for their customers.
- Standing rigging for sailing dinghies and lifelines on yachts.
- Structural rigging for hang-gliders and ultra-light airplanes.



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OUR MOST SOLD MACHINE.

A200



WIRETEKNIK

Powerful Portability.

A perfect machine for swaging on-site. Low weight and small outer dimensions makes it extremely portable.

Swaging Range: 1,6-8 mm wire. (1/16"-5/16")

Typical applications:

- Standing rigging and lifelines for sailboats.
The Swedish Navy uses it for making railing.
- Architectural, like balustrades and railing.
- Scenographic use at theaters for hanging and supporting set pieces.
- Extensively used for on-site swaging of wire fall protection systems on roofs and buildings.
- Structural rigging for hang gliders and ultra-light airplanes.
- Anchoring of weather balloons.
- Oceanographers uses it for swaging winch wire ropes for their surveying instruments.
- Lifting strops for fuel rods at nuclear power plants.
- Structural rigging for sail-roofs and sail-shades.



An example of A200 fitted with Hydraulic pump unit PHU1.

Dimensions:

L=500 mm (19 3/4")

W=300 mm (11 3/4")

H=140 mm (5 1/2")

Weight: 19,5 kg (42 lbs)



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BIG JOB. SMALL MACHINE.

A 270



WIRETEKNIK



Big Job. Small Machine.

A perfect machine for swaging on-site. Low weight and small outer dimensions makes it extremely portable. Rigging screws can be swaged assembled.

Swaging Range: 2,5-12 mm wire. (3/32" - 1/2")

Typical applications:

- Standing rigging and lifelines for sailboats.
- Architectural, like balustrades and railing.
- Often used to build support structures for membrane roofs and tents.
- Structural rigging for sail-roofs and sail-shades.



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A350

THE PRODUCTION LINE MACHINE.



WIRETEKNIK



An example of A350 fitted with Hydraulic pump unit PHU1.



Dimensions:
L= 1117 mm (44")
W=370 mm (14 3/4")
H=210 mm (8 1/4")
Weight: 66 kg (146 lbs)

Production Line Machine.

A perfect machine for line production, the low weight and small outer dimensions still makes it extremely portable.

Rigging screws can be swaged assembled.

Swaging Range: 2,5-16 mm wire. (3/32"-5/8")

Typical applications:

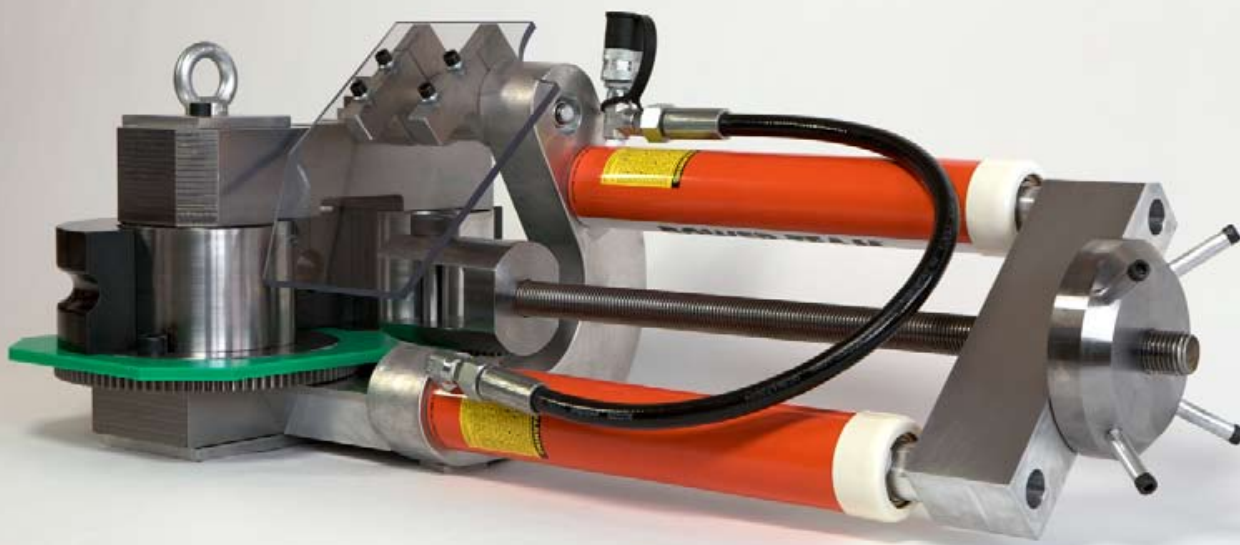
- Standing rigging and lifelines for sailboats.
- Architectural, like balustrades and railing.
- Good for medium size glass facade projects.
- Often used to build support structures for membrane roofs and tents.
- Structural rigging for sail-roofs and sail-shades.



www.wiretechnik.se



THE ULTRA COMPACT MACHINE.

A 400


*Also available optimised for road safety barriers.

WIRETEKNIK



Dimensions:
L=990 mm (39")
W=530 mm (20 7/8")
H=370 mm (14 1/2")
Weight: 142 kg (313 lbs)

The Ultra Compact Machine.

The Ultra Compact Machine for up to 28 mm Wire Rope.

A perfect machine for swaging on-site. Low weight and small outer dimensions makes it extremely portable. Rigging screws can be swaged assembled.

Swaging Range: 8-28 mm wire. (5/16"-1 1/8")

Typical applications:

- Standing rigging and lifelines for larger sailboats and yachts.
- Used for on-site production of road safety barrier systems.
- Architectural, like balustrades, railing and hanging bridges.
- Good for big size glass facade projects.
- Often used to build support structures for membrane roofs and tents.
- Structural rigging for sail-roofs and sail-shades.



www.wireteknik.se



A500

"THE BRONTO" OUR LARGEST MACHINE.



Dimensions:

L=1380 mm (54 1/4")

W=780 mm (30 3/4")

H=490 mm (19 1/4")

Weight: 392 kg (864 lbs)

Extremely Powerful.

A500 is a perfect machine for swaging on-site. Low weight and small outer dimensions makes it extremely

Swaging Range: 16-40 mm wire. (5/8"-1 1/2")

Typical applications:

- Architectural, like balustrades, railing and hanging brid ges.
- Often used to build support structures for membrane roofs and tents.
- Good for big size glass facade projects.
- Structural rigging for sail-roofs and sail-shades.
- Standing rigging and lifelines for larger sailboats and yachts.



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