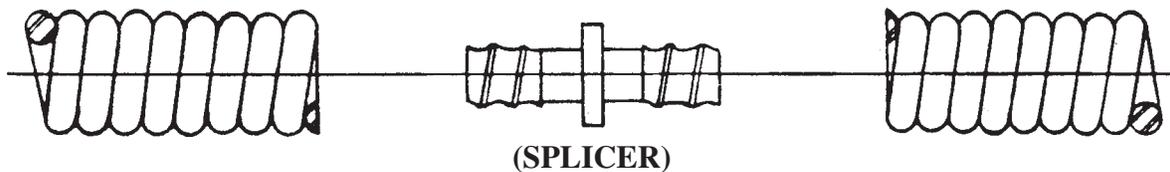


Instructions for Installing Cable Splicer or Couplings in Spartan Tool Cables

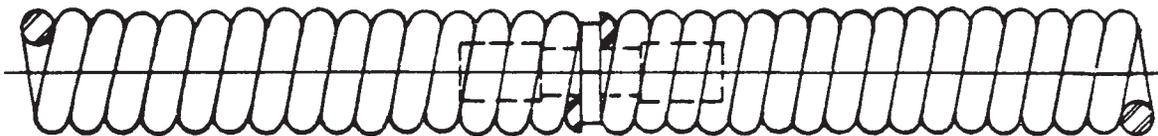
Instructions for installing cable splicer or couplings in Spartan Tool cables.

CAUTION: Make sure appropriate welding gear is used to avoid injuries. Follow all OSHA safety rules when welding.

1. How to Splice Cable:



- Step One: Square ends of cable to be spliced by placing each end of cable against a grinding wheel until ends are completely flat.
- Step Two: Place cable in vise. Remove any jagged edge of metal on inside of cable with a punch. Open ends slightly with a punch so opening is large enough to allow splicer to be inserted. If the cable has an innercore which protrudes, pull a small length of innercore (1") out of cable and cut it off to allow room for splicer. Push innercore back into cable.
- Step Three: Make sure splicer is free of rust or grease before inserting into cable. Use wire brush for cleaning if needed.
- Step Four: With cable in vise, turn splicer with a wrench into cable drawing shoulder of splicer up to one end of cable. Repeat process with other end of cable.



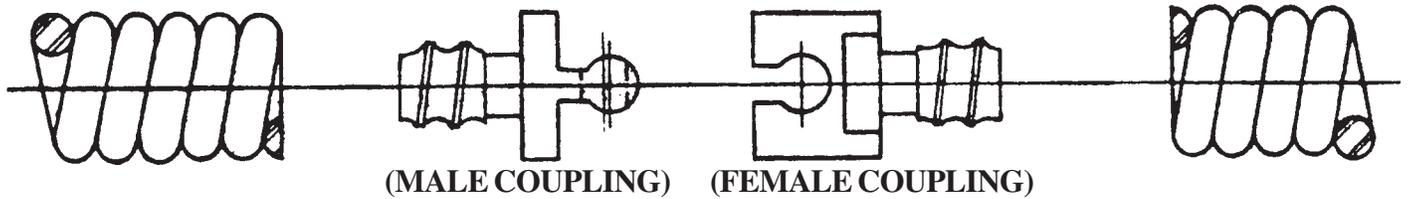
- Step Five: By arc welding, tack cable to shoulder of splicer. Use low heat setting (80-90 amps) and low hydrogen welding rods. DO NOT attempt a full weld with an acetylene torch. Extreme heat necessary for such a weld will soften the last 2-3 coils of wire nearest the shoulder of the coupling increasing the possibility of breakage.



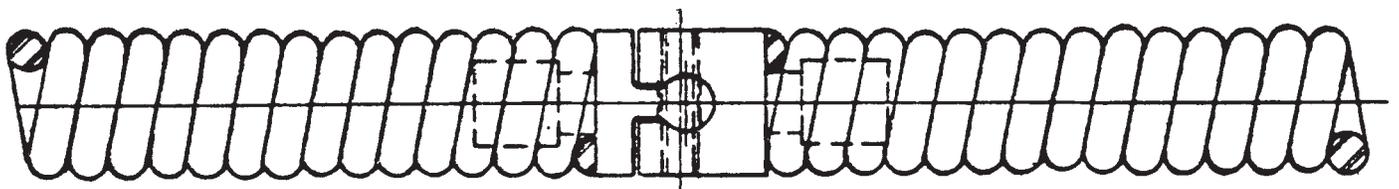
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2. How to Install Coupling:



- Step One: Square end of cable into which the coupling is to be installed, by placing cable end against a grinding wheel until end is completely flat.
- Step Two: Place cable in vise. Remove any jagged edge of metal on inside of cable with a punch. Open end of cable slightly with a punch so opening is large enough to allow coupling to be inserted. If cable has an innercore which protrudes, pull a small length of innercore (1") out of cable and cut it off to allow room for coupling. Push innercore back into cable.
- Step Three: Make sure coupling is free of rust or grease before inserting into cable. Use wire brush for cleaning if needed.
- Step Four: With cable in vise, turning coupling with a wrench into cable, drawing shoulder of coupling up tone end of cable.



- Step Five: By arc welding, tack cable to shoulder of coupling. Use low heat setting (80-90 amps) and low hydrogen welding rods. DO NOT attempt a full weld with an acetylene torch. Extreme heat necessary for such a weld will soften the last 2-3 coils of wire nearest the shoulder of the coupling increasing the possibility of breakage.

Note: If heat setting is too high, you will get the cable coil to hot which removes the temper of the wire which will cause the wire to crystalize and break.



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