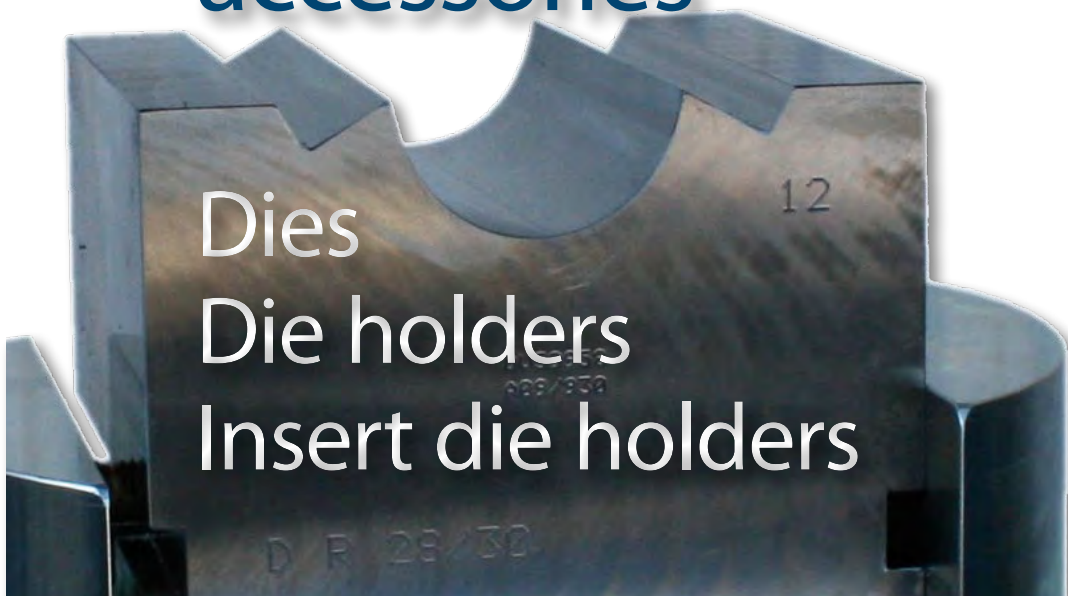


The original mechanical splicing systems.



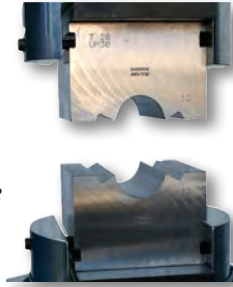
Swager
accessories



Dies
Die holders
Insert die holders

TALURITTM

Ferrules, sleeves and sockets require individual press dies depending on material and dimension. We develop and manufacture standard and special dies to cater for all possible swaging demands. Dies are fabricated in different block sizes to fit our various swagers. The smallest swager use block size A and the largest swager use L.



Dies in die holders

The dies are mounted in the die holder of the swager.

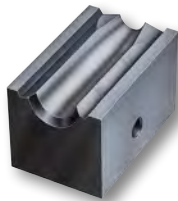
Smaller block sizes than standard can be fitted to the swager by using insert die holders. These compensate the gap between the smaller dies' size and the original one.

Dies

Our dies are manufactured from high quality steel for optimum strength and service life. In addition to our comprehensive standard range we are also able to supply special dies to customer specification.

Conical press dies (Universal type).

These Universal type dies are used to press conical ferrules type TK and K. In addition they will also cater for the straight cylindrical T, TCU, UM and R type ferrules.



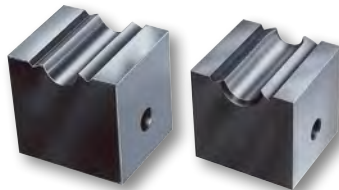
Conical press dies with special spigot

to swage TKH ferrule or TALUKON. Can be removed and replaced with a blanking-off bush for standard type ferrules. These dies are mainly for aluminium and copper ferrules.



Cylindrical press dies

with "rounding" or straight form for cylindrical ferrules type T, UM, TCU and R.



Several stage dies

are used when the press capacity is not enough to close the standard dies in one stage. These straight through stage dies are for type T, UM and TCU cylindrical ferrules.



Combined dies

available in large die block sizes for use in medium to large presses. Type A, B1, C and C1 block size

Nos. 1+1,5 2+2,5 3+3,5

Type C block size

Nos. 1+1,5 2+2,5 3+3,5 4+4,5 5+6

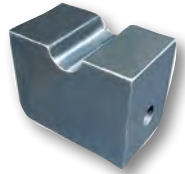


Dies for STC sleeves

in carbon steel for Flemish eye terminations.

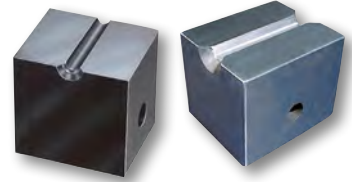


Dies (cylindrical) for steel ferrules
type ST, STD, STS and INOX.



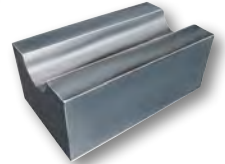
Dies for terminals

in carbon and stainless steel. Both in round as well as hexagonal form.



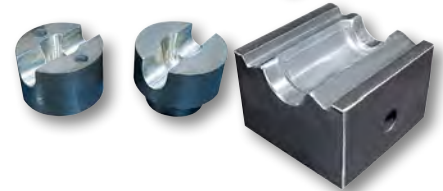
Dies for swage sockets and end stops

intended for carbon and steel sockets as well as special sleeves.



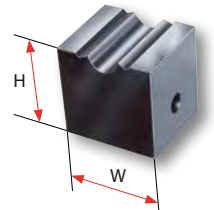
Special dies

Press dies for pressing customer specified special fittings.



Dies in other sizes

Available on request both in mm and inch sizes. Also specials like hexagonal shape of bore is available.



Dies Block size	Basic Dimensions		Intended for swager
	Height (mm)	Width (mm)	
A	38	42	18T, 22T*, 25T*
B*	48	50	50T*
B1	48	70	75T, 100T, 150T
B2	50,2	70	100T, 150T
C	78	80	250T* and 300T
C1	78	100	250T* and 300T
D	110	156	500T* and 600T
E	150	220	900T* and 1000T
E1	150	250	900T* and 1000T
F	200	250	1500T*
G	250	300	2000T*
G0	152,4 (6")	304,8 (12")	2000T
H	300	380	2500T*
H	300	380	3000T*
K	200	400	3700T
L	250	450	3700T
2"x3½"	2" (50,8)	3½ (88,9)	600T**
2½"x5"	2½" (63,5)	5" (127)	600T, 1000T**
4"x7"	4" (101,6)	7" (177,8)	600T, 1000T**
5"x7"	5" (127)	7" (177,8)	600T, 1000T**
6"x12"	6" (152,4)	12" (304,8)	equal to G0, 2000T**

* old type

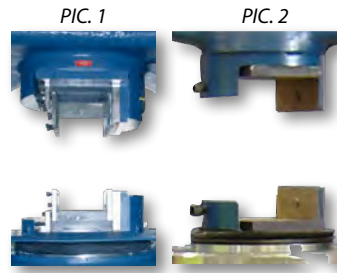
** and larger with insert die holder.

Die holders

All die holders are bolted onto the swagers. The placement, if they are square or angular, type of locking and if they are made for centric or eccentric load varies with the different swagers and swaging procedures.

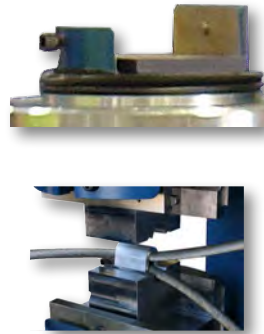
Square/Angular setting

Die holders are often mounted square to the swager. For 1-pillar swagers the die holders are turned 90 degrees compared to PIC 1. Angular setting, PIC 2, is the most common setting for medium sized swagers, since it allows ample working space.



Locking of dies

The locking mechanism differs with the various die holders. Small die holders have one bolt for each die. Larger swagers have one or two guiding pins as well as bolts.

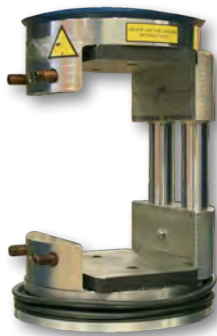


The 600-tons swager has guiders to slide the dies into position.

Centric or eccentric load

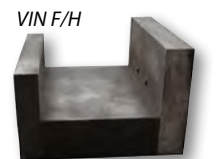
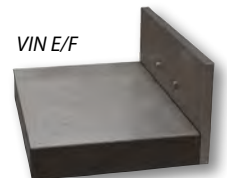
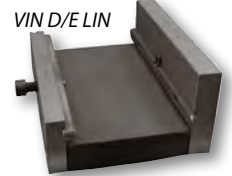
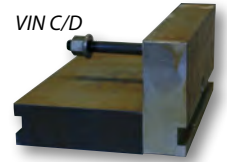
Dies in most applications are placed right above the piston in the centre, which gives even weight distribution.

For other applications such as Flemish eye swaging the load is sometimes applied eccentrically. To protect the swager from abnormal wear, a die holder with pillar guides is recommended.

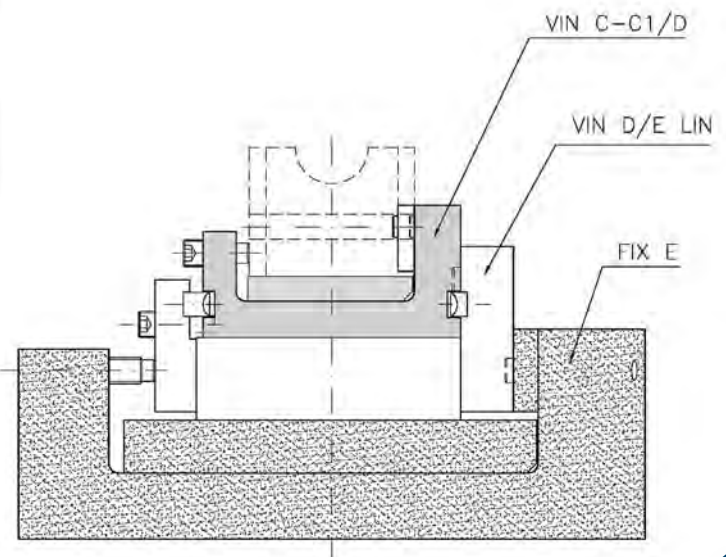
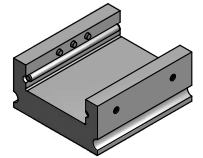


Dies	Fit in
Block size	Insert die holder
A	VIN A/UB-10T
B1	VIN B1/C1
B2	VIN B1/C1
C	VIN C-D EXC VIN C-C1/D
C1	
D	VIN D/E LIN
E	VIN E/F VIN E/G
E-E1	VIN E-E1/G0
F	VIN F/G VIN F/H
G	VIN G/H VIN G/L
G0	VIN G0/K
H	VIN H/L
K	VIN K/L
B1	VIN B1/2½"x5"
2"x 3½"	VIN 2"x 3½"/D
2"x 3½"	VIN 2x3½/4x7 DUAL
2½"x5"	VIN 2½"x5"/D
2½"x5"	VIN 2½"x5"/4"x7"
2½"x5"	VIN 2½x5/4x7 DUAL
4"x7"	VIN 4"x7"/E
5"x7"	VIN 5"x7"/E
6"x12"	VIN 6"x12"/K
4"x7"	VIN CONVERT TO 5x7
5"x7"	VIN CONVERT TO 4x7

Examples of insert die holders



VIN 2½"x5"/4"x7"



Insert die holders

By inserting an extra die holder smaller dies can be used. The table on the next page shows how to use insert die holders to be able to use smaller dies.

SWAGER	Max ferrule size (T / single stage)	Dies - standard	Smaller dies together with insert die holders	
			Smaller dies	Insert die holders
UB-10T	3,5	A		VIN A/UB-10T
18-ton	6	A		
40-ton	9	A, A1		
75-ton	11	B1		
150-ton	16	B1, B2		
300-ton	24	C, C1		
			B1	VIN B1/C1
600-ton	34	D		
			C	VIN C/D EXC
			C-C1	VIN C-C1/D
			C1	VIN C1/D
		4"x7"/5"x7"		
			2½"x5"	VIN 2½"x5"/4"x7", VIN 2½x5/4x7 DUAL
			2"x3½"	VIN 2x3½/4x7 DUAL
			B1	VIN 2½"x5"/4"x7" + VIN B1/2½"x5"
			B1	VIN 2½x5/4x7 DUAL + VIN B1/2½"x5"
1000-ton	44	E, E1		
			D	VIN D/E LIN
			C	VIN D/E LIN + VIN C/D EXC
			C-C1	VIN D/E LIN + VIN C1/D
			5"x7"	VIN 5"x7"/E
			4"x7"	VIN 4"x7"/E
			2½"x5"	VIN 4"x7"/E + VIN 2½"x5"/4"x7", VIN 2½x5/4x7 DUAL
			2"x3½"	VIN 4"x7"/E + VIN 2x3½/4x7 DUAL
2000-ton	60	G0		
			E, E1	VIN E-E1/G0
			D	VIN E-E1/G0 + VIN D/E LIN
			5"x7"	VIN E-E1/G0 + VIN 5"x7"/E
			4"x7"	VIN E-E1/G0 + VIN 4"x7"/E
3700-ton	86	L		
			K	VIN K/L
			H	VIN H/L
			G	VIN H/L + VIN G/H
			E	1) VIN H/L + VIN G/H + VIN E/G 2) VIN K/L + VIN G0/K + E-E1/G0
			6"x12"	VIN 6"x12"/K + VIN K/L



Always swage according to
Ferrule Securing Instruction!

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