

Assembly instructions - Alukaflex® from DanCables

Ver.: 04



Alukaflex® - Flexible aluminum conductor equivalent with Class 5 according to DIN/EN 60228

To ensure the best possible operation and reliability:

- Use crimping tools and appropriate crimp cable lugs, connectors, or pinbolts that are approved for Alukaflex®.
- The used crimp connectors must comply with DIN 46329 or DIN 46267 and be specified for use according to DIN/EN 60228. The sleeve must contain contact grease.
- We have tested and approved the C8 crimp system from Intercable (formerly Weitkowitz).
- We have tested and approved the crimping system with Klauke's EKM 60IDCFM (Dorn) crimping tool.
- Use a cable lug/connector that is one size bigger than the cable dimension. E.g.: The cable Alukaflex ECO 5G50 mm², a 70 mm² crimp cable lug must be used, crimping tool and dies must match 70 mm².
- The aluminum conductor must be brushed immediately before crimping, to remove the oxide layer.
- When installing CEE plugs or similar, the conductor must be greased with contact grease, and end-sleeves must be applied on the conductor.
- The used contact grease must contain ingredients that prevent the formation of a new oxide layer on the conductor.

DanCables offers daily rentals and sales of crimping tools and equivalent profile C8 crimp dies.

C8 crimping dies from Intercable

Item no. Purchase	Item no. Rental	Type no.	Used for Alukaflex® mm ²	Dies and cablelug size mm ²	Dies code	Used with tool
17001025	-	91502	10	16	K12	APW 30
17001030	-	91503	16	25	K12	APW 30
17001035	-	91504	25	35	K14	APW 30
17001040	17999991	91505	35	50	K16	APW 30
17001045	17999992	91506	50	70	K18	APW 30
17001050	17999993	91507	70	95	K22	APW 30
17001055	17999994	91508	95	120	K22	APW 30
17001060	17999995	91509	120	150	K25	APW 30
17001265	17999994	91511	95	120	K22	APW 18
17001077	17999995	91512	120	150	K25	APW 18
17001065	17999996	91513	150	185	K28	APW 18
17001070	17999997	91514	185	240	K32	APW 18
17001075	17999998	91515	240	300	K34	APW 18
17001076	-	91516	300	400	K38	APW 18
17001078	-	91517	400	500	K44	APW 18
17001079	-	91518	500	625	K52	APW 18

Battery powered crimping tools from Intercable (to be used with C8 crimping dies)

Item no. Purchase	Item no. Rental	Type no.	Dies used for Alukaflex®	Description
17001010	17001010	91163	C8	APW 30 hydraulic accu tool
17001255	17001255	97222	C8	APW 18 hydraulic accu tool

Battery powered crimping tools from Klauke with dornpress

Item no. Purchase	Item no. Rental	Type no.	Used for Alukaflex®	Description
-	17999988	-	16-185 mm ²	EKM 60IDCFM (Makita batt.) / EKM 60IDCFB (Bosch batt.)



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Crimping should be carried out by trained personnel. Regardless of whether a Dorn or C8 crimp is used, the instructions must be followed.

- The connector must contain contact grease in an quantum that fills the sleeve after crimping.
- The dies size (for C8 crimp) must follow the specified number on the connector.
- The conductor must be undamaged, and all strands must be inserted to the full depth.
- Follow the crimp marking points on the connector.
- Use appropriate heatshrink for the termination.

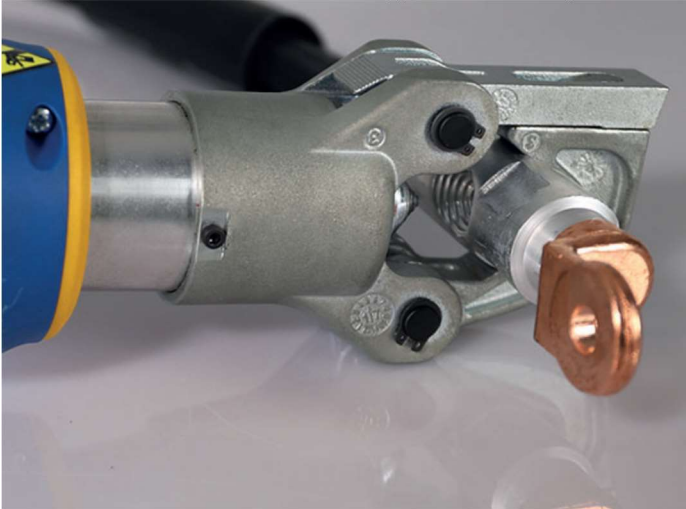
Stripping length = full depth of the sleeve



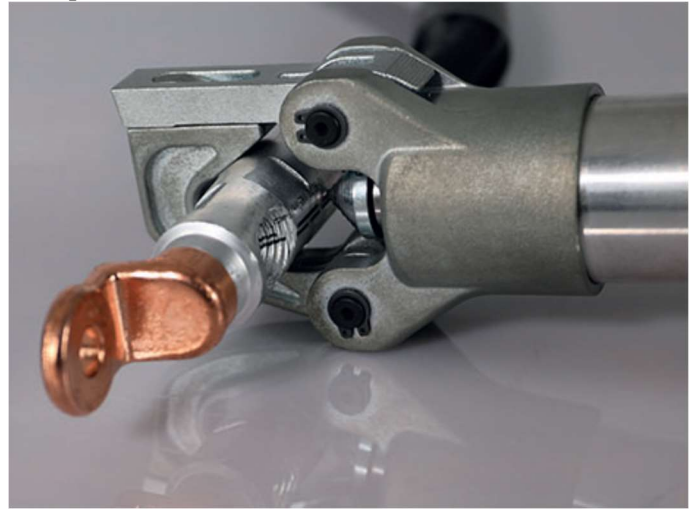
Crimp 1: On the front, furthest away from the cable.



Crimp 2: on the backside (180° opposite to crimp 1)



Crimp 3: On the front, closest to the cable.



Work done with Dorn pressing



Work done with C8 pressing



Finish with heat shrink covering the cable sheath and crimp work.

