

BELL SYSTEM PRACTICES
Outside Plant Construction
and Maintenance

SECTION G85.126.2
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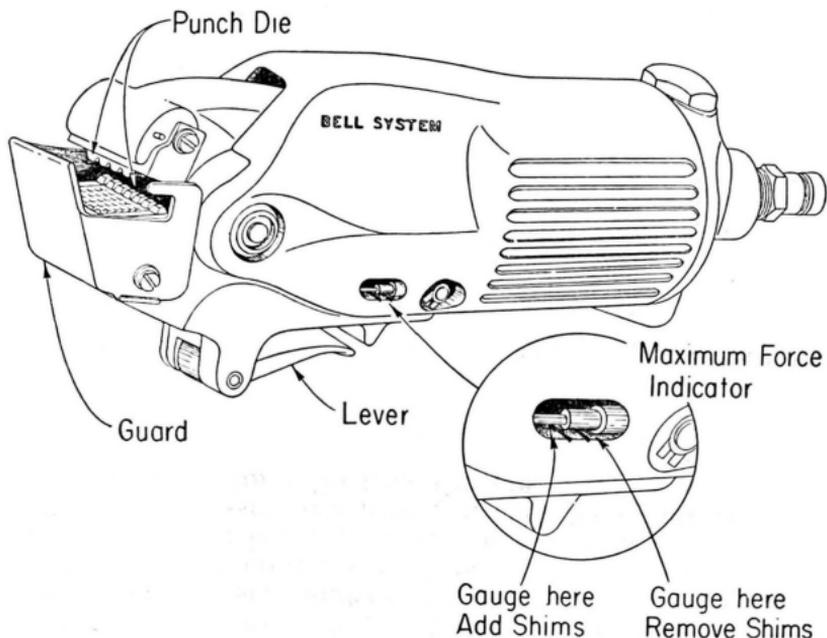
B PNEUMATIC PRESSER

1. GENERAL

1.01 This section covers the B Pneumatic Presser used in splicing aluminum cable conductors by the punched sleeve method. This tool is similar to the superseded B900149 Pneumatic Presser described in Section G85.126.1 except for the two-part punch die and guard. The punch die in the B presser can be replaced with a two-part press die (available as an optional part) for pressing C Splice Sleeves on twisted joints in aluminum conductor cables.

2. DESCRIPTION

2.01 The B Pneumatic Presser is illustrated in the following sketch. It is about 10 inches long 3-1/2 inches high and 2-1/4 inches wide. The presser is equipped with a two-part punch die, a guard, 30 feet of 3/16-inch hose and a container of shims. The tool, without hose, weighs about 3-1/2 pounds. The left-hand side of the presser contains a device for indicating the force applied to the joint being punched or pressed. The hose is for connecting the presser to a nitrogen cylinder or air compressor and the shims are for adjusting the die.



2.02 Nitrogen gas obtained from a 220-cubic foot nitrogen gas cylinder or the B Nitrogen Cylinder at a line pressure of 90 pounds per square inch (psi) is used to operate the presser. A C Gas Regulator is employed to control the line pressure. About 3-1/2 cubic feet of gas are needed to punch 100 sleeves. The tool is operated by pressing the lever.

2.03 **Adjusting Presser for Punching Sleeves:** Connect the presser to a gas cylinder. Secure the hose to the strand, platform or cable to prevent the presser from accidentally falling. Set the regulator pressure (outlet side) to 90 psi. Check the delivery pressure occasionally.

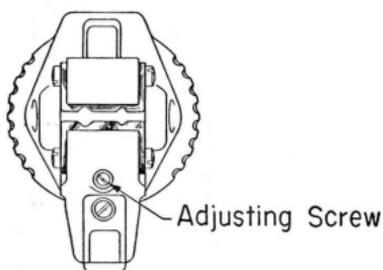
2.04 To test the presser for correct force on the die, prepare a joint of the type to be made and before punching the sleeve, push the gauge toward the back of the presser and then punch the sleeve. The gauge should stop between the lines of the force indicator for maximum force. If the gauge is to the left of the left-hand line, it will be necessary to place shims under the lower die; if the gauge is to the right of the right-hand line, it will be necessary to remove shims under the lower die. To place or remove shims, turn the regulator adjusting screw counterclockwise until it turns freely and then disconnect the hose from the presser. Remove the guard and lower die and place or remove shims as required. Then

replace the die and guard and again make a test splice to ensure that the presser is functioning properly. The presser should be checked occasionally for proper operation and especially when a change is made in the size of wires or sleeves being punched.

2.05 After splicing, close the cylinder valve and disconnect the hose from the regulator. Unscrew the regulator adjusting screw sufficiently to relieve the pressure on the diaphragm.

2.06 A two-part press die is available as an optional part for use with the B presser in splicing aluminum cable conductors by the pressed sleeve method.

2.07 **Press Die for B Presser:** Remove the guard and punch die and replace them with a press die. Before connecting the presser to a cylinder, turn the adjusting screw, shown in the sketch, closing the jaws until a small C Splice Sleeve can be conveniently placed in the small opening of the die (or a large sleeve in the large opening). This will limit the travel of the jaws and prevent placing a finger between the die.



2.08 **Adjusting Presser for Pressing Sleeves:** To ensure that the tool is in proper adjustment, prepare a joint of the type to be made and, before pressing the sleeve, move the gauge toward the back of the presser and then press the sleeve. The gauge should be in the position shown in the sketch in Paragraph 2.01. If the gauge is to the left of the left-hand line, it will be necessary to place shims under the lower die; if the gauge is to the right of the right-hand line, it will be necessary to remove shims from under the lower die. To place or remove shims, turn the regulator adjusting screw counterclockwise until it turns freely and then disconnect the hose from the tool. Open the jaws as far as practicable by turning the adjusting screw. Remove the lower die and place or remove shims as required. Then replace the die, adjust the spacing between the die and again make a test splice to ensure that the presser is functioning properly.

2.09 **Optional Part:**

Die, Press, for B Pneumatic Presser

(Consists of a two-part die, 5 shims, 4 screws and 4 washers)

2.10 The **replacement parts** for the presser are listed below.

Guard, for B Pneumatic Presser

Hose, for B Pneumatic Presser

(Consists of 30 feet of 3/16-inch hose with connectors)

Die, Punch, for B Pneumatic Presser

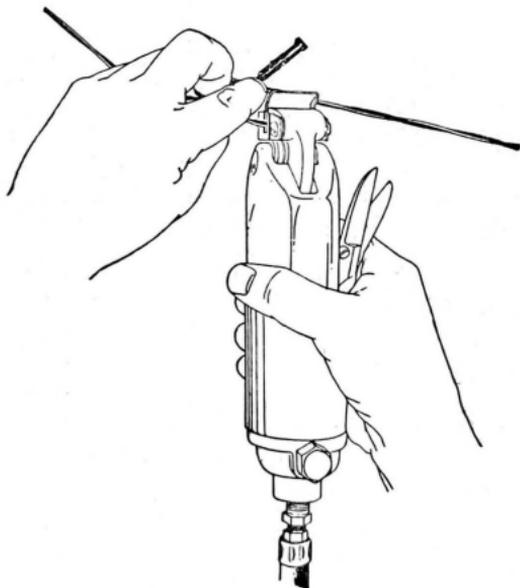
(Consists of a two-part die, 5 shims, 4 screws and 4 washers)

Shims, Set of, for B Pneumatic Presser

(Consists of 5 shims, 4 screws and 4 washers in a container)

3. OPERATION

3.01 **Punching Sleeves:** The method of punching a sleeve is shown in the following sketch. With the joint properly positioned in the die, press the lever to close the jaws; then release the pressure on the lever to open the jaws. The sleeve should be punched only once. The work can be facilitated by preparing several joints and then punching the sleeves on the joints that have been prepared.



3.02 **Pressing Sleeves:** The method of pressing sleeves with the tool is illustrated below. With the joint in the proper opening and the dies centered over the sleeve, press the lever to close the jaws; then release the pressure on the lever to open the jaws. Only one press on a sleeve is required. The work can be facilitated by twisting several joints, placing a C Splice Sleeve over each twist and then pressing the sleeves.

