

## **THE SILVERLINE TERMINAL END**

### **Procedure For Clamping Steel/ Polypropylene Core Wire**

(For wire sizes refer to chart)

1. Using insulating or duct tape, mark off the wire 95mm (A ref. data sheet) back from the wire end, which is the same length as the body and the hole into which the wire is inserted.
2. Cut out the centre core 20mm longer than the pin. Insert the pin and return lay of wire to original condition. (For polypropylene only)
3. Enter the wire into THE SILVERLINE TERMINAL END, up to the 95mm (A) mark previously taped onto the wire. A hammer may have to be used to tap the end up to the mark.
4. Fit SILVERLINE dies (ref. data sheet) into the clamping machine.
5. Position the Terminal End with the wire inserted into the clamping machine dies, so that the neck of the terminal end is 3mm from the end of the die.
6. Clamp the end once at recommended tonnage (ref. data sheet) and release. Reposition the Terminal End on the die until 5mm of the die is exposed. Clamp the end once more at the recommended tonnage. The body length of the end should have increased from 95mm to about 10,7 – 11,0mm after this operation
7. One of the most important aspects of the clamping is to ensure that the body length increases by 12 – 15%. Ensuring that the metal being clamped has nowhere else to go under compression, other than along the length of the terminal. After filling all the voids of the wire inside of the Terminal End. The compressed metal will extend the length of The SILVERLINE Terminal End to the required percentage.
8. A flash will appear down the side of the Terminal after clamping. This may be ground off with a hand grinder. (It was once the practice of the clamping operator to turn the terminal on its side in the die and clamp again so that he did not have to remove the flash with a grinder. In effect what he was doing was to forcibly implode the flash into the body of the Terminal and create a flaw along the body length of Terminal End, dramatically reducing its strength. Under no circumstances must this procedure be reproduced SILVERLINE TERMINAL END.)

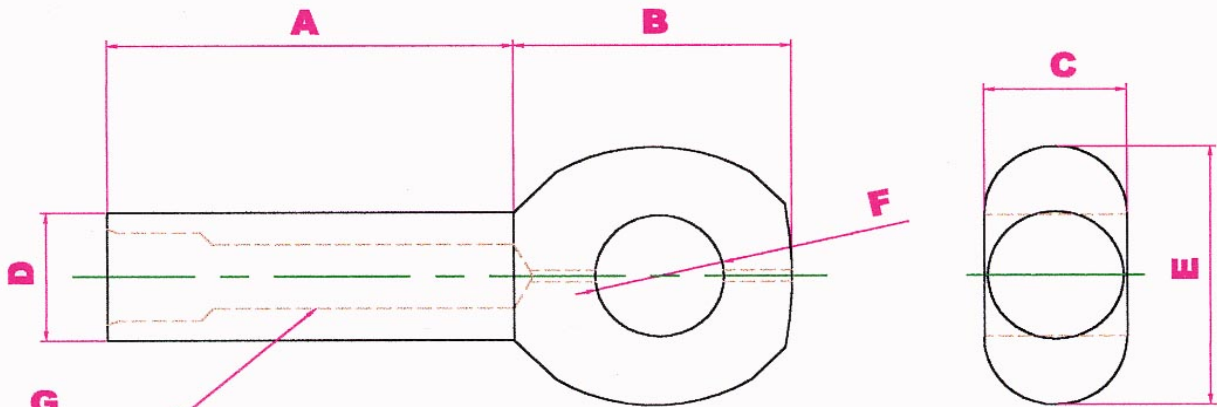
**Note:** Clamping tonnages are for reference only. The elongation is the most important factor. All clamping machines do not reproduce the same results using these tonnage settings. Please record your own settings to ensure consistent results every time.

**ALSO FROM SILVERLINE ARE: CONNECTORS, SWIVEL-CONNECTORS AND DUPLEX-CONNECTORS. THIMBLES FOR WIRES AND DYNEEMA. SWIVELS. GOOD PRODUCTS AT FAIR PRICE.**



# SILVERLINE

## Combination Wire End Sizes



## SILVERLINE Terminal Ends for Combination wire

Part Number	Rope size in mm	Conn-ector size	A Body & Bore Length	B Head Length	C Head Thickness	D Body Diameter	E Head Hight	F Eye Dia.	G Bore Diameter	Silverline Swage Die Size	Talurit Swage Die Size	Pressing Pressure Applied	Pin size	D After pressing
SLC14C13	14	16	92	56	20	34	55	26	15	17	14	200T	6	28
SLC16C13	16	16	92	56	20	34	55	26	17	17	14	200T	6	28
SLC18C13	18	16	92	56	20	34	55	26	19	17	14	200T	6	28
SLC20C13	20	16	92	56	20	34	55	26	21	17	14	200T	6	28
SLC22C13	22	20	95	64	20	40	55	35	23	19	18	270T	6	36
SLC24C13	24	20	95	64	20	40	55	35	25	19	18	270T	6	36
SLC24C16	24	20	95	64	20	40	57	35	25	19	18	270T	6	36
SLC26C16	26	20	95	64	20	40	57	35	27	19	18	270T	8	36
SLC28C16	28	20	95	64	20	40	57	35	29	19	18	270T	8	36
SLC48C32	48	32	150	100	42	70	108	57	50	32	0	600T	12	
SLC52C32	52	32	150	100	42	70	108	57	54	32	0	600T	12	

The die size in blue are the Silverline dies and the yellow are Talurit dies.

All measurements in millimeters Included in the bag with the terminal end is a steel pin that should be inserted through the hole at the front of the terminal end, before clamping.

Elongation of the terminal body after clamping should be 12 to 15%.

FRASERBURGH ENGINEERING CO.

19 Reclaimed Ground  
Fraserburgh, Scotland

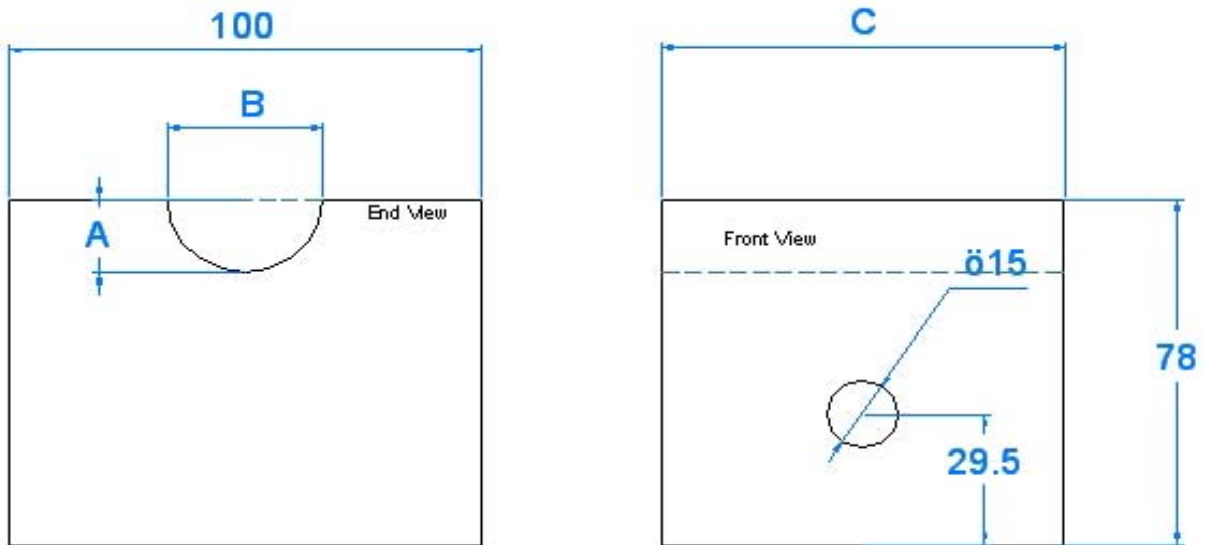
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# Silverline Products.



## SILVERLINE SWAGING DIES

Wire size	Silverline Swage Die Size	A	B	C
14 - 16mm	17	14,7mm	32mm	76mm
18 - 22mm	19	16,5mm	37mm	85mm
24 - 26mm	21	17,5mm	38mm	94mm
28 - 32mm	25	19,8mm	45mm	120mm
34 - 36mm	29	23mm	48mm	120mm
	32	30,5mm	61mm	120mm

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