Hi-MOD Made in UK

Hayn Marine

51 Inwood Road, Rocky Hill, CT 06067 USA

Stainless Steel Compression Terminals

For use with Stainless Steel Wire 1x19, 7 Strand, Compact Strand, Dyform©

Please follow the instructions enclosed exactly as described. Petersen Stainless Rigging Limited accepts no liability for improper use or assembly of these products.

Tel: 860-257-0680 Fax: 860-257-0683 **www.hi-mod.com**

Version 16.01

For video demonstration of installation please visit: www.hi-mod.com

Installation Notes:

1.0 Loctite 277 curing time is 24 hours to achieve full holding strength. Additionally, application on Stainless Steel **requires** a primer in order to properly cure the Loctite. Also note, lower temperatures adversely affect cure times. See Loctite section located on www.hayn.com for technical information.

2.0 DO NOT over-tighten, threads may seize. Typically, "hand tight" plus and additional 1/2 turn is adequate engagement.

3.0 Engineered for exclusive use with Stainless Steel wire ropes.

4.0 For routine maintenance, remove the end fitting, tap back the Body, wash, and inspect. Fittings are fully re-usable unless the Cone is distorted.

5.0 Application of sealants is **not** recommended for use with Hi-MOD fittings.

INSTALLATION INSTRUCTIONS

1. Wrap a piece of electrician's tape around the wire and saw to length. A clamp or a vice and a file are useful, but not necessary.

2. Slide the Body over the wire as shown prior to untwisting the wire rope.

3. Untwist the outer strands by picking out and rotating in the opposite direction of wire lay.

4. Slide the thin end of the Cone over the center core. If tight on wire core, you can spread the Cone open with a screwdriver blade.

5. Slide Crown Ring over the wire center core with concave side first, facing the already installed Cone.

6. Using the built in depth indicator on the end fitting, push over the Crown Ring until the wire center core bottoms out. This ensures the correct depth of Crown Ring engagement.

7. Twist the outer strands back into position over the Cone. Firmly twist the Crown Ring in the direction of the wire lay while positioning the outer strands in the slots.

8. When all of the outer strands are positioned, the Cone and Crown Ring will remain in place with no assistance. Gently twist the Body back over the wire, rotating in the same direction as the lay of the wire.

NOTE: Wires up to 7/32" (5mm) require 2 strands per slot (fig.1).
Wires 1/4" (6mm) and above have 1 strand per slot (fig.2).

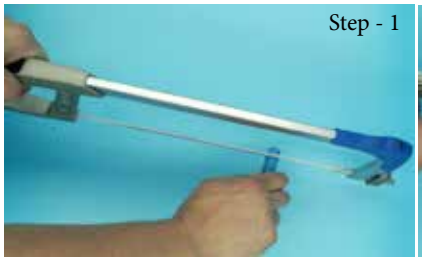

fig. 1


fig. 2

9. Test fit end fitting without Loctite and only to "hand tight" to ensure free engagement.

10. Remove the end fitting and ensure that the outer strands remain engaged on the Crown Ring.

11. Apply Loctite Primer on thread surfaces and wait 1 minute to dry.
Apply Loctite 277 to thread surface to secure the fittings thread engagement.
Screw end fitting on "hand tight" plus an additional 1/2 turn.
Wipe away any residual Loctite from fitting surface.


Step - 1


Step - 2


Step - 3


Step - 4


Step - 4


Steps - 5 & 6


Step - 7


Steps - 8 & 10


Step - 9


Step - 11

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Hi-MOD COMPRESSION FITTINGS CONE CONFIGURATION CHART

Wire Ø	Wire Type	Body Code	Cone P/N	Cone Color	Cone Length	Ident. Rings	Crown Ring P/N
1/8" or 3mm	1x19	03	CTC18		0.551"	0	CTCR18
5/32" or 4mm	1x19	04	CTC532		0.787"	0	CTCR532
3/16" or 5mm	1x19	05	CTC316		0.933"	0	CTCR316
7/32"	1x19	05	CTC732		0.874"	0	CTCR732
6mm	1x19	06	CTCM6		1.106"	0	CTCR14
1/4"	1x19	06	CTC14		1.106"	0	CTCR14
9/32" or 7mm	1x19	07	CTC932		1.283"	0	CTCR932
5/16" or 8mm	1x19	08	CTC516		1.571"	0	CTCR516
3/8"	1x19	10	CTC38		1.886"	0	CTCR38
10mm	1x19	10	CTCM10		1.874"	0	CTCR38
12mm	1x19	12	CTCM12		2.209"	0	CTCR12
7/16"	1x19	10	CTC716		1.874"	0	CTCR38
1/2"	1x19	12	CTC12		2.209"	0	CTCR12
9/16" or 14mm	1x19	14	CTC916		2.550"	0	CTCR916
5/8" or 16mm	1x19	16	CTC58		3.150"	0	CTCR58
3/4" or 19mm	1x19	19	CTC34		3.413"	0	CTCR34
7/8" or 22mm	1x19	22	CTC78		3.913"	0	CTCR78
1" or 26mm	1x19	26	CTC1		4.606"	0	CTCR1
CS - KOS Compact Strand / D - Bridon Dyform							
3mm	1x7	03	CTC18		0.551"	0	CTCR18
4mm	1x7	04	CTC532		0.787"	0	CTCR532
5mm	1x19	05	CTC316		0.933"	0	CTCRM5-D
6mm	1x19	06	CTCM6		1.106"	0	CTCRM6-D
7mm	1x19	07	CTC932		1.283"	0	CTCRM7-D
8mm	1x19	08	CTC516		1.571"	0	CTCRM8-D
10mm	1x19	10	CTCM10		1.874"	0	CTCRM10-D
12mm*	1x19	12	CTCM12		2.209"	0	CTCRM12-D
12mm	1x19	12	CTCM12-CS		2.209"	0	CTCRM12-D
14mm	D - 1x25	14	CTCM14-D		2.543"	2	CTCRM14-D
14mm	CS - 1x36	14	CTCM14-CS	No Color	2.235"	2	CTCRM14-CS
16mm	D - 1x25	16	CTCM16-D		3.138"	2	CTCRM16-D
16mm	CS - 1x36	16	CTCM16-CS	No Color	3.090"	2	CTCRM16-CS
19mm	D - 1x31	19	CTCM19-D		3.413"	2	CTCRM19-D
19mm	CS - 1x31	19	CTCM19-CS		3.355"	2	CTCRM19-CS
19mm	CS - 1x36	19	CTCM19-CS1x36	No Color	2.630"	0	CTCRM19-CS1x36
7 Strand - Includes 1x7, 7x7, 7x19							
1/8" or 3mm	7 Strand	03	CTC18-7		0.512"	1	CTCR18
5/32" or 4mm	7 Strand	04	CTC532-7		0.709"	1	CTCR532
3/16" or 5mm	7 Strand	05	CTC316-7		0.886"	1	CTCR316
7/32"	7 Strand	05	CTC732-7		0.886"	1	CTCR732
6mm	7 Strand	06	CTCM6-7		1.063"	1	CTCR14-7
1/4"	7 Strand	06	CTC14-7		1.063"	1	CTCR14-7
9/32" or 7mm	7 Strand	07	CTC932-7		1.181"	1	CTCR932-7
5/16" or 8mm	7 Strand	08	CTC516-7		1.461"	1	CTCR516-7
3/8"	7 Strand	10	CTC38-7		1.764"	1	CTCR38-7
10mm	7 Strand	10	CTCM10-7		1.764"	1	CTCR38-7
7/16"	7 Strand	10	CTC716-7		1.768"	1	CTCR38-7
1/2" or 12mm	7 Strand	12	CTC12-7		2.181"	1	CTCR12-7
9/16" or 14mm	7 Strand	14	CTC916-7		2.504"	1	CTCR916-7

*NOTE: There are instances where 12mm Compact Strand does not allow for adequate thread engagement. In this case, the cone is to be substituted with part # CTC12.

Three main reasons why we recommend that you do not use sealant.

1) Regardless of how much sealant and pressure you apply to the terminal, we do not believe that you will completely fill the cavity, thus leaving a small air pocket which will get water in it (usually somewhere near the centre of the cable where it is difficult to get at).

2) Stainless steel is protected by a very thin chrome-oxide layer. If the oxide layer becomes damaged, it needs more oxygen to replenish that layer. Any water that makes its way in past the sealant will become stale (oxygen depleted) over time. It is safer to allow fresh water into the terminal on a regular basis which will not only clean and wash away any built up salt residues but will also maintain the oxide layer of the stainless steel.

3) The main mechanical components of the compression fittings are manufactured from stainless steel grade 316L. This material has high anti-corrosive properties and is ideal for use in a constant sea water environment. The design of the terminal and its components has been developed in such a way that it is acceptable to use this material. Other designs of this type of terminal may not benefit from these design features.
The design of the Hi-MOD swageless compression terminal is such that you can dismantle the terminal at any time, allowing you to inspect and clean the internal components. If you use a sealant, it would make this operation very difficult and you may not be able to see all of the inner components properly.

A note regarding the Loctite to use.

The manufacturer recommends Loctite 277, but we suggest using Loctite 243 as Loctite 277 requires a primer for use on Stainless Steel whereas 243 does not. Loctite 243 does have a quicker fixture time at 5 minutes as compared to the 60 minutes for the Loctite 277, but since you are applying the Loctite in the next to the last step, 5 minutes should be plenty of working time. The breaking strengths are similar between the two products and the lower prevailing torque strength of the Loctite 243 allows for easier disassembly for inspection and routine maintenance.