

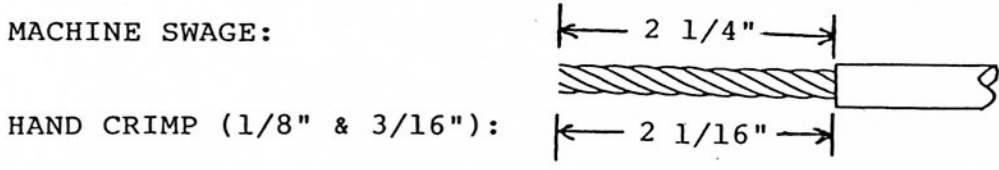
INSTRUCTIONS FOR TERMINATING THE JOHNSON "SMOOTH LINE TURNBUCKLE"

ALL REQUIRED COMPONENTS FOR THE CATALOG NO. CHOSEN ARE INCLUDED IN THIS PACKAGE (Except red Loctite).

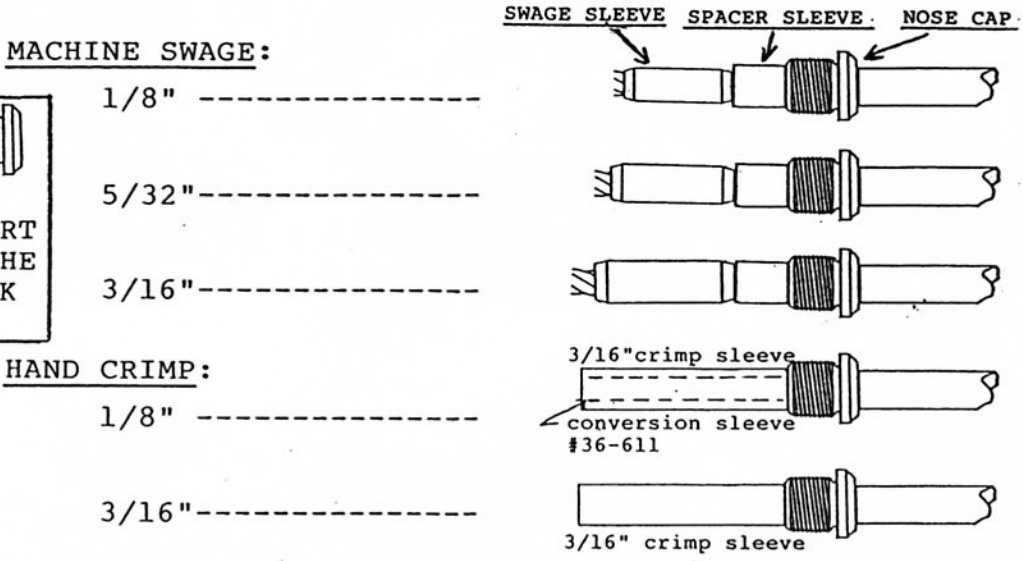
IMPORTANT - PLEASE NOTE THAT MACHINE SWAGE VERSIONS CAN BE SWAGED USING ROTARY OR KEARNEY TYPE SWAGERS ONLY!

FOR ASSEMBLY WITH COATED CABLE (If cable is not coated, you may skip to step 3).

- 1) STRIP COATING FROM CABLE - CUT BACK DIMENSION FOR 1/8", 5/32" & 3/16" CABLE IS AS FOLLOWS:(Our 53 series stripper is recommended).



- 2) ASSEMBLE THE ENCLOSED COMPONENTS ON THE CABLE AS SHOWN BELOW:



IMPORTANT START SWAGING FROM THE INSIDE AND WORK OUTWARD.

IMPORTANT - 3/16" OF CABLE MUST PROJECT BEYOND END OF SWAGE SLEEVE BEFORE SWAGING. THIS WILL ACCOMODATE FOR GROWTH IN LENGTH OF THE SWAGED TERMINAL.

- 3) FOR UNCOATED CABLE ASSEMBLE AS DESCRIBED IN STEP 2 WITHOUT SPACER.
- 4) MACHINE SWAGE TERMINALS MUST BE SWAGED FOR THE ENTIRE LENGTH.
HAND CRIMP TERMINALS TO BE ASSEMBLED USING INSTRUCTION SHEET H-C4 WITH THE EXCEPTION OF CUT BACK DIMENSION.
- 5) AFTER SWAGING (or crimping), ASSEMBLE INTO BODY TUBE USING RED LOCTITE ON THREADS OF NOSE CAP. THE LOCKING SET SCREW IS INSTALLED WITH BLUE LOCTITE AT THE FACTORY.

<u>REPLACEMENT PARTS:</u>		<u>NOSE CAP</u>	<u>SPACER SLEEVE</u>	<u>SWAGE SLEEVE</u>
MACHINE SWAGE	- 1/8"	60-610	60-621	60-613
"	5/32"	60-610-1	60-622	60-620
"	3/16"	60-611	60-623	60-612
HAND CRIMP	- 1/8"	60-610	-----	36-611+ 60-619
"	- 3/16"	60-611	-----	60-619