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BELL SYSTEM PRACTICES
Outside Plant Construction and Maintenance

SECTION G85.125.1
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SLEEVE PRESSER
NICOPRESS TOOLS FOR SPLICING LINE WIRE

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1. GENERAL

1.01 This section covers the adjustment, lubrication, and inspection of Nicopress Tools used for making pressed sleeve joints in certain sizes of line wire and in river crossing strand and river crossing wire. It is being reissued to include reference to the 31-QC Nicopress Tool.

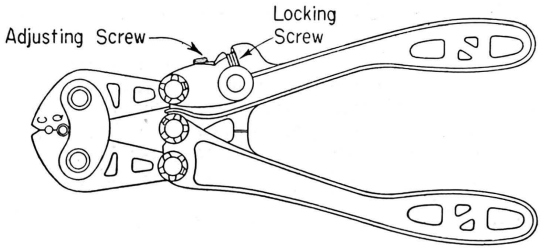
1.02 The type of tool to be used is specified in the table of Pressed Sleeve Joints in Section G31.121.1.

1.03 The gauge supplied with the sleeve presser should be retained for use in checking the adjustment of the tool.

2. DESCRIPTION

2.01 Three sleeve pressers of the Nicopress type are available for splicing line wire. They are as follows:

(a) The 31-QC Nicopress Tool, shown in the following illustration. Its over-all length is 11-3/4 inches and it weighs 2 pounds. The jaws are fitted with two grooves. One handle of this tool is equipped with a screw adjustment. A gauge and an Allen wrench for the adjusting screws are supplied with each tool.



31-QC NICOPRESS TOOL

(b) The 51-JE Nicopress Tool resembles the 31-QC tool, except that its over-all length is 18 inches and it weighs 4 pounds. It is fitted with two grooves, and one handle is fitted with a screw adjustment. A gauge and an Allen wrench are supplied with each tool.

(c) The 3-L Nicopress Tool is similar in appearance to the 31- and 51-type tools, except that it is somewhat longer and heavier, being 35 inches long and weighing 12 pounds. Both handles are fitted with screw adjustments. The jaws are fitted with one groove. A gauge is supplied with each tool, but no wrench is furnished, as the adjusting screws are square-head set screws which may be turned with an adjustable wrench.

3. ADJUSTMENT

3.01 Unless a sleeve presser is known to be in adjustment, it should not be used until gauging tests indicate that it is properly adjusted. Press a sleeve on a piece of new line wire (use the C groove in the 31-QC tool, and the E groove in the 51-JE tool) and gauge the press. The sleeve presser is properly adjusted when the pressed section of the sleeve will enter the "GO" gauge with very little play, but without forcing. If the pressed sleeve does not gauge properly the tool must be adjusted before it is used.

3.02 Before adjusting a sleeve presser, move the handles apart sufficiently to open the jaws.

3.03 To adjust the 31-QC and 51-JE tools, loosen the locking screw one or two turns. If the press on the sample sleeve gauged too large, turn the adjusting screw in (clockwise) a fraction of a turn. Tighten the locking screw, make another press on the test sleeve and gauge the press. If the press on the

sample gauged too small, the locking screw should be loosened and the adjusting screw should be backed out (turned counter-clockwise) slightly. Tighten the locking screw, make a press on the test sleeve and gauge the press. Continue adjusting as outlined above until the press will just pass into the gauge slot. Tighten the locking screw firmly so that the tool will hold its adjustment.

3.04 In adjusting the 3-L tool both adjusting screws should be turned in or out the same amount.

4. LUBRICATION

4.01 Oil the various bearing points in the sleeve presser occasionally with a light grade of engine oil.

4.02 Wipe the sleeve presser occasionally with an oily rag to prevent rusting.

5. INSPECTION

5.01 Sleeve pressers should be inspected carefully for visible defects and to see that all parts are in serviceable condition.

5.02 Sleeve pressers which have developed major defects or which can not be corrected by adjustment as described in Part 3, shall be returned in accordance with local instructions.