

BELL SYSTEM PRACTICES
Outside Plant Construction
and Maintenance

SECTION G85.126.1
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AT&T Co Standard

B900149 PNEUMATIC PRESSER

1. GENERAL

1.01 This section replaces Issue 1. It describes the B900149 Pneumatic Presser and the method of using it in splicing aluminum cable conductors. This presser has been superseded by the B Pneumatic Presser described in Section G85.126.2.

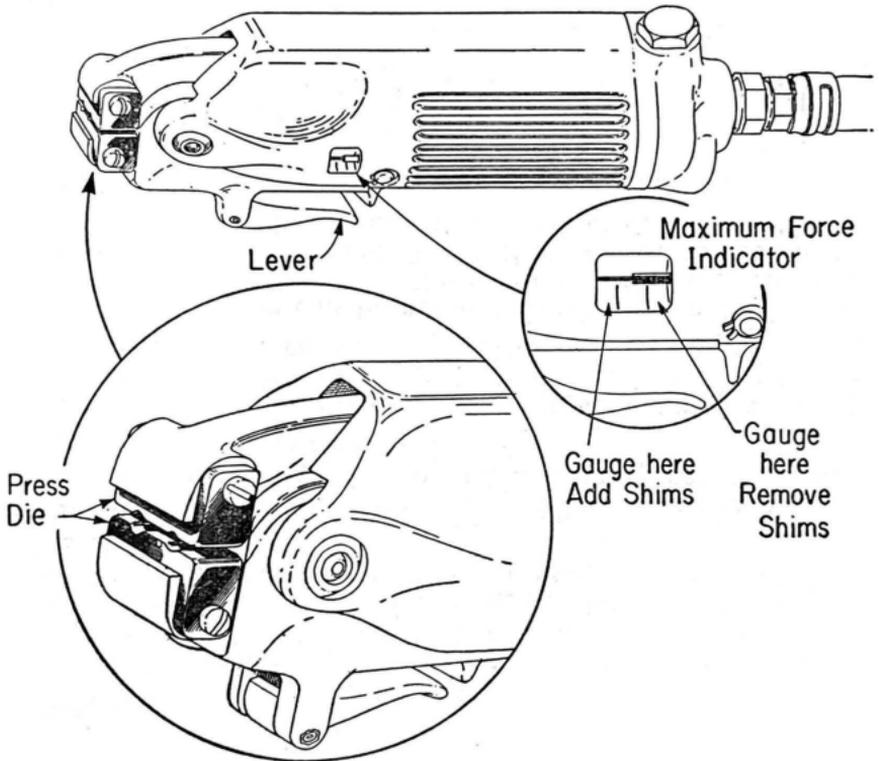
1.02 The section has been reissued to cover the use of the B900149 presser in splicing aluminum cable conductors by the punched sleeve method.

1.03 The B900149 presser was supplied with a two-part press die for pressing C Splice Sleeves over twisted joints in aluminum cable.

1.04 This presser can be made equivalent to a B Pneumatic Presser by replacing the two-part press die with a two-part punch die and a guard. A B900149 presser so modified can be used to splice aluminum cable conductors by the punched sleeve method.

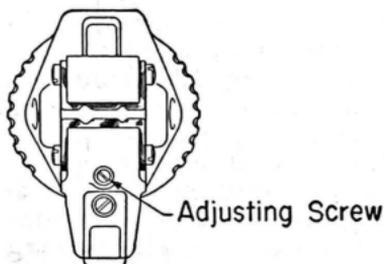
2. DESCRIPTION

2.01 The B900149 Pneumatic Presser is illustrated in the following sketch. It is about 9 inches long, about 3 inches in diameter and weighs about 3-1/2 pounds. When supplied it was equipped with a two-part press die, a container of shims, and 30 feet of 3/16-inch hose equipped with connectors. The shims are for adjusting the die and the hose for connecting the presser to a nitrogen cylinder or air compressor. The left-hand side of the presser contains a device for indicating the force applied to the joint.



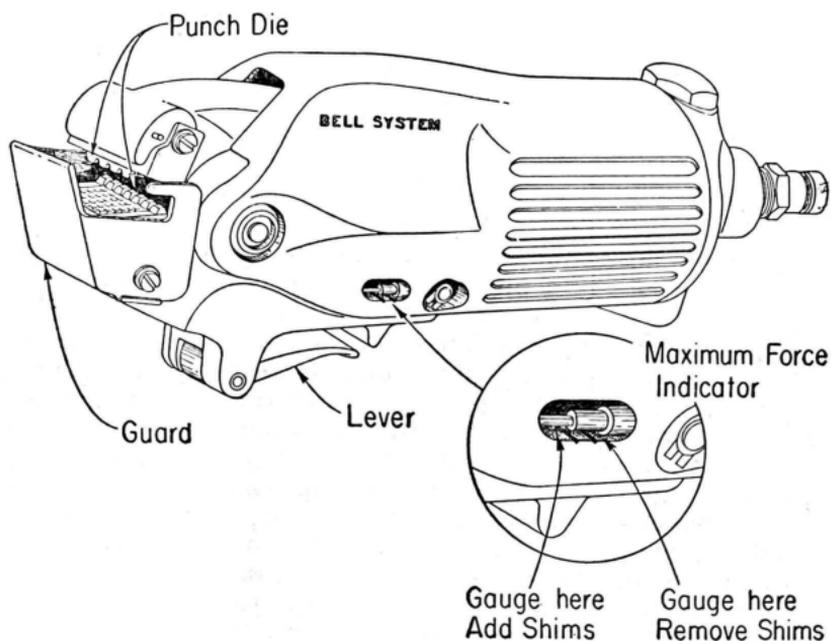
2.02 Nitrogen gas obtained from a 220-cubic foot nitrogen gas cylinder or the B Nitrogen Cylinder at a line pressure of 90 pounds per square inch (psi) is used to operate the tool. The C Gas Regulator should be employed to control the line pressure. About 3-1/2 cubic feet of gas are needed to press 100 sleeves. The die has two slots, one for pressing small sleeves and the other large sleeves. The tool is operated by pressing the lever.

2.03 Before connecting the presser to the nitrogen cylinder turn the adjusting screw, shown in the sketch, separating the jaws so that a small C sleeve can be conveniently placed in the small opening in 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. Connect the presser to a gas cylinder. Secure the hose to the strand, platform or cable to prevent the presser accidentally falling. Set the regulator pressure (outlet side) to 90 psi. Check the delivery pressure occasionally.



2.04 **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 as far as practicable and then press the sleeve. The gauge should be in about 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.

2.05 **Punch Die for B900149 Presser:** The B900149 presser can be made equivalent to the B Pneumatic Presser by replacing the two-part press die with the two-part punch die and guard that are available as replacement parts for the B presser. These parts may be ordered as indicated in Paragraph 2.10. A presser equipped with punch die and guard is illustrated on Page 4.



2.06 Remove the two-part die and replace it with the two-part punch die and guard, as shown above.

2.07 **Adjusting Presser for Punching Sleeves:** 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 half of the die; if the gauge is to the right of the right-hand line, it will be necessary to remove shims (or a shim). To place or remove shims, turn the regulator adjusting screw counter-clockwise until it turns freely and then disconnect the hose from the presser. Remove the guard and lower half of the 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 and especially when a change is made in the size of wires or sleeves being punched.

2.08 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.

2.09 The Press Die available as an optional part for the B Pneumatic Presser should be ordered when the press die of the B900149 presser needs replacing. This part is listed below.

Die, Press, for B Pneumatic Presser (consists of a two-part die, 5 shims, 4 screws and 4 washers).

2.10 The guard and punch die for making a B900149 presser equivalent to a B Pneumatic Presser are available as replacement parts for the B presser and are listed below. The hose and shims that are available as replacement parts for the B Pneumatic Presser should be ordered when these parts are needed for replacement purposes. These parts are also included in the following listing:

Die, Punch, for B Pneumatic Presser (consists of a two-part die, 5 shims, 4 screws and 4 washers).

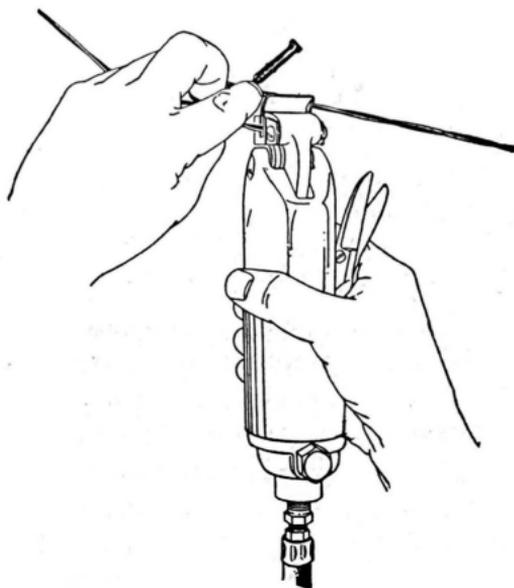
Guard, for B Pneumatic Presser.

Hose, for B Pneumatic Presser (consists of 30 feet of 3/16-inch hose with connectors).

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 joint, placing a C Splice Sleeve over each twist and then pressing the sleeves.

