

BELL SYSTEM PRACTICES
Outside Plant Construction
and Maintenance

SECTION G86.520.1
Issue 1, March, 1948
AT&TCo Standard

TOOLS
SLEEVE ROLLING TOOL

Contents	Page
1. General	1
2. Description	1
3. Care and Maintenance	2
4. Testing Sleeve Rolling Tool	3

1. GENERAL

1.01 This section outlines the care and maintenance of the Sleeve Rolling Tool. This information was previously given in Section G31.121, Issue 4. Information relating to the operation of this tool is contained in Section G31.121.2.

1.02 This section includes information concerning changes that are recommended in the lubrication of the sleeve rolling tool.

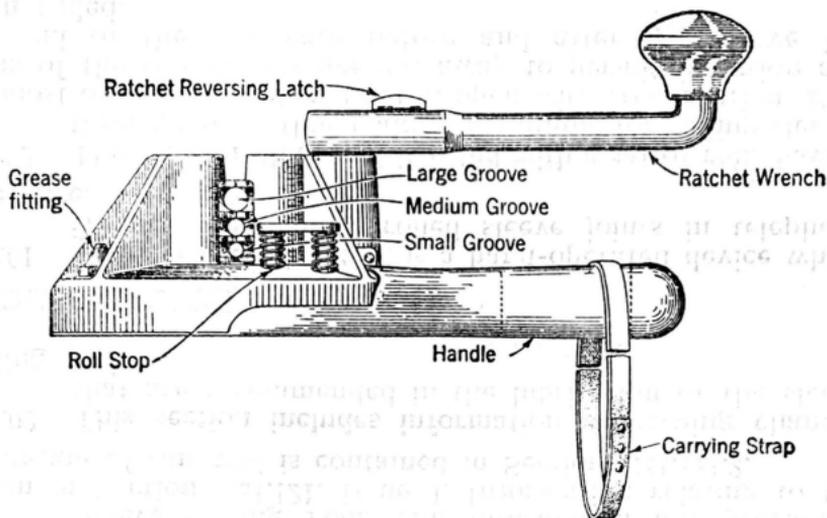
2. DESCRIPTION

2.01 The sleeve rolling tool is a hand-operated device which is used for making rolled sleeve joints in telephone line wire.

2.02 The sleeve rolling tool is fitted with a set of rolls having three grooves, thus making it suitable for rolling sleeves on most of the conductors used in open wire construction. Portions of the roll flanges are cut away to permit insertion and removal of the line wire before and after the sleeve has been rolled.

2.03 Sleeve rolling tools manufactured after 1938 are equipped with roll stops to assist in locating the rolls in the position where the flats are opened. The roll stop consists of a flat thumb plate fitted to two pins which slide into the housing of the tool. By depressing the thumb plate and slowly turning the ratchet wrench, one of these pins will engage a hole in the large

gear inside the case when the roll flats have reached the open position, and will thereby lock the rolls in that position. Coil springs return the roll stop to the disengaged position when pressure on the thumb plate is released. The sleeve rolling tool is shown in the following illustration.



3. CARE AND MAINTENANCE

3.01 Exercise care to place the tool in the truck in such a position that it will not be damaged in transit. Do not throw it into the truck or on the ground.

3.02 When required for use aloft, the tool should be raised and lowered in a canvas bucket or hooked securely to the body belt.

3.03 The leather strap attached to the handle should always be placed over the wrist to prevent the tool from falling when carrying or using it.

3.04 Wipe the sleeve rolling tool with an oily rag occasionally in dry weather, and after each time it is used in damp or rainy weather.

3.05 The grease fitting on the sleeve rolling tool will accommodate a Zerk grease gun. Tools in the field should be lubricated at six-month intervals using wheel bearing grease. This grease may be obtained at automobile service stations. **Do not use graphite grease.** To ensure that the grease reaches all the bearings of the tool, turn the handle from time to time during the greasing operation until grease is forced through the

bearings at the outer end of the roll shafts. When in use, the tool should be lubricated weekly by applying S.A.E. 20 or 30 oil to the bearings at the outer end of the roll shafts, while the tool is held horizontally with these bearings uppermost. Operate the tool while the oil is being applied so that the oil will be worked into the bearings.

3.06 Do not attempt to take the sleeve rolling tool apart, as removing the rolls from the housing will usually destroy the grease seal. No attempt should be made to replace broken or worn-out ratchet wrenches in the field. Should a tool become unusable, it should be returned to the storeroom.

4. TESTING SLEEVE ROLLING TOOL

4.01 Each sleeve rolling tool should be checked periodically (about once every six months or oftener depending upon the amount of use) to determine whether it has become worn so much that it no longer makes satisfactory joints. To check the tool it should be used for rolling a sleeve on new wire of the size for which the sleeve is intended. Measure the diameter of the finished sleeve in the proper "GO" slot of the sleeve-wire gauge shown in the section on Rolled Sleeve Joints.

(a) If the sleeve will enter the slot designated for the size and kind (copper or steel) of sleeve being checked, the sleeve rolling tool is satisfactory.

(b) If the sleeve will not enter the slot it may be assumed that the tool has become worn to the point where it will not roll sleeve joints having satisfactory holding power, and the tool should in this case be returned to the storeroom.