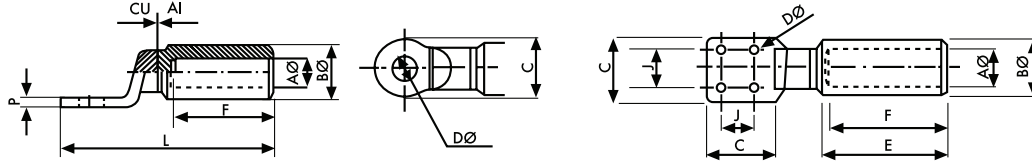




Stone-Stamcor
bringing power to your product

Bi-Metallic Lugs and Ferrules




TABLE 1B - BIMETALLIC CRIMPING LUGS
DIMENSIONS


SECTION mm²	REFERENCE	DIMENSIONS mm								
		AØ	BØ	C	DØ	E	F	J	L	P
16	Y4A16A105C	6.0	16.0	20.0	6.5; 8.5; 10.5; 12.5	47.5	43.0	-	80.0	4.5
25	Y4A25A105C	7.0							86.0	5.0
35	Y4A35A128C	8.3								
50	Y4A50A128C	9.9	20.0	25.0	8.5; 10.5; 12.5; 16.5	64.0	59.0			
70	Y4A70A128C	11.7								
95	Y4A95A128C	13.7								
120	Y4A120A128C	15.3	25.0	30.0		64.0	59.0		114.0	6.0
150	Y4A150A128C	17.2								
185	Y4A185A128C	19.0								
240	Y4A240A128C	21.8	32.0	36.0	10.5; 12.5; 16.5	300 F=62 400 F=93	300 F=73 400 F=100		158.0	7.0
300	Y4A300A165C	24.9	35.0							
400	Y4A400A165C	26.0	40.0							
500	Y4A500A490C	29.1	47.0	ON REQUEST	4 X 9.0	101.0	94.0	30 X 30	200.0	10.0
630	Y4A630A490C	32.5								
800	Y4A800A4110C	37.5	60.0	ON REQUEST	4 X 11.0	136.0	125.0	40 X 40	270.0	
1000	Y4A1000A4110C	42.0								
1200	Y4A1200A4110C	45.5				65.0	146.5			

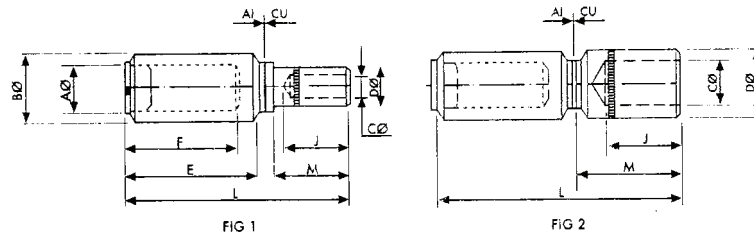
TABLE 2B - COMPRESSION DIES FOR BIMETALLIC LUGS

Section	Reference	Hydraulic		Pre Rounding	Deep Indent	Hexagon
mm ²		Compression Tooling				
16	Y4A16A105C	EP-510C / PCS-12042 / ECT-12042	TP630H	-	U35AOE	U140BGE4T(95)
25	Y4A25A105C			U50PRGE3T	U95A1E	U173BGE4T(150)
35	Y4A35A128C					
50	Y4A50A128C					
70	Y4A70A128C			U70PRGE3T	U150A2E	U215BGE5T(240)
95	Y4A95A128C			U95PRGE3T		
120	Y4A120A128C			U120PRGE3T		
150	Y4A150A128C			U150PRGE3T	U240A4E	U280BGE4T(400)
185	Y4A185A128C			U185PRGE3T		
240	Y4A240A128C			U240PRGE3T		
300	Y4A300A165C		U300PRGE3T	U300A34N	-	
400	Y4A400A165C	PCS-25 / ECT-25020		-	-	
500	Y4A500A490C	on request				
630	Y4A630A490C					

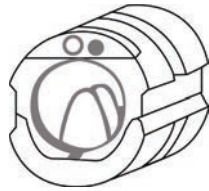


TABLE 3B - BIMETALLIC COMPRESSION FERRULES

DIMENSIONS



SECTION mm²		REFERENCE	FIG.	DIMENSIONS													
AL	CU			AØ	BØ	CØ	DØ	E	F	J	M	L					
25	16	Y4RP25SA16C	2	7.0	16.0	5.6	12.2	47.5	43.0	29.5	34.5	87.0					
	25	Y4RP25SA25C				7.0											
35	16	Y4RP35SA16C		8.3		5.6							7.0				
	25	Y4RP35SA25C				8.0											
	35	Y4RP35SA35C															
50	16	Y4RP50SA16C	1	9.9	5.6												
	25	Y4RP50SA25C			7.0												
	35	Y4RP50SA35C			8.0												
	50	Y4RP50SA50C			9.5												
70	16	Y4RP70SA16C	1	11.7	5.6												
	25	Y4RP70SA25C			7.0												
	35	Y4RP70SA35C			8.0												
	50	Y4RP70SA50C			9.5												
	70	Y4RP70SA70C	2		11.0	21.0			33.5	38.5	91.0						
95	35	Y4RP95SA35C	1	13.7	8.0	12.2											
	50	Y4RP95SA50C			9.5												
	70	Y4RP95SA70C	2		11.0	21.0											
	95	Y4RP95SA95C			13.0												
120	35	Y4RP120SA35C	1	15.3	8.0	12.2	64.0	59.0	29.5	33.0	104.0						
	50	Y4RP120SA50C			9.5												
	70	Y4RP120SA70C	2		11.0	21.0											
	95	Y4RP120SA95C			13.0												
	120	Y4RP120SA120C			14.2												
150	50	Y4RP150SA50C	1	17.2	9.5	12.2					29.5	33.0	104.0				
	70	Y4RP150SA70C	2		11.0	21.0											
	95	Y4RP150SA95C			13.0												
	120	Y4RP150SA120C			14.2												
	150	Y4RP150SA150C			16.0												
185	70	Y4RP185SA70C	1	19.0	11.0	21.0			64.0	59.0	33.5	37.0	108.0				
	95	Y4RP185SA95C			13.0												
	120	Y4RP185SA120C			14.2												
	150	Y4RP185SA150C			16.0												
	185	Y4RP185SA185C	2		18.0	26.2					43.5	49.0	120.0				
240	95	Y4RP240SA95C	1	21.8	13.0	21.0					33.5	37.0	108.0				
	120	Y4RP240SA120C			14.2												
	150	Y4RP240SA150C			16.0												
	185	Y4RP240SA185C			18.0		26.2										
	240	Y4RP240SA240C	2		20.0						43.5	49.0	120.0				


TABLE 4B - COMPRESSION DIES FOR FERRULES
DIMENSIONS


DEEP INDENT



HEXAGON

SECTION mm²		REFERENCE	ALUMINIUM		COPPER HEXAGON
AL	CU		DEEP INDENT	HEXAGON	
25	16	Y4RP25SA16C	U35AOE	U140BGE4T (95)	BU/1060 (50mm Die)
	25	Y4RP25SA25C			
35	16	Y4RP35SA16C			
	25	Y4RP35SA25C			
	35	Y4RP35SA35C			
50	16	Y4RP50SA16C	U95A1E	U173BGE4T (150)	
	25	Y4RP50SA25C			
	35	Y4RP50SA35C			
	50	Y4RP50SA50C			
70	16	Y4RP70SA16C			
	25	Y4RP70SA25C			
	35	Y4RP70SA35C			
	50	Y4RP70SA50C			
	70	Y4RP70SA70C			
95	35	Y4RP95SA35C			
	50	Y4RP95SA50C			
	70	Y4RP95SA70C			
	95	Y4RP95SA95C			
120	35	Y4RP120SA35C	U150A2E	U215BGE5T (240)	BU/0980 (150mm Die)
	50	Y4RP120SA50C			BU/1060 (50mm Die)
	70	Y4RP120SA70C			BU/0980 (150mm Die)
	95	Y4RP120SA95C			BU/1060 (50mm Die)
	120	Y4RP120SA120C			BU/0980 (150mm Die)
150	50	Y4RP150SA50C			
	70	Y4RP150SA70C			
	95	Y4RP150SA95C			
	120	Y4RP150SA120C			
	150	Y4RP150SA150C			
185	70	Y4RP185SA70C	U240A4E	U280BGE4T (400)	BU/0980 (150mm Die)
	95	Y4RP185SA95C			BU/1010 (240mm Die)
	120	Y4RP185SA120C			BU/0980 (150mm Die)
	150	Y4RP185SA150C			BU/1010 (240mm Die)
	185	Y4RP185SA185C			BU/0980 (150mm Die)
240	95	Y4RP240SA95C			
	120	Y4RP240SA120C			
	150	Y4RP240SA150C			
	185	Y4RP240SA185C			
	240	Y4RP240SA240C			



RECOMMENDED GUIDE TO CRIMPING ALUMINIUM AND BI-METAL CONNECTORS

Recommended Application

Use aluminium connectors on aluminium conductors and use bi-metal connectors where an aluminium conductor is terminated onto copper, terminal or busbar. Always match the connector barrel size to the conductor size and use only the recommended Tooling for that connector range.



Tools and Materials

- Hydraulic crimping tool with the correct die set
- Cable cutter and stripping tool
- Selected connector and matching conductor
- Wire brush and oxide-inhibiting compound for aluminium conductors
- Gloves and eye protection



Recommended Procedure

1. Cut the conductor cleanly and square, with no damaged or flared strands.
2. Strip insulation to match the barrel length only; do not nick or reduce the conductor strands.
3. Wire-brush the stripped strands to bright metal and immediately apply oxide-inhibiting compound to limit re-oxidation. (Recommended practice)
4. Insert the conductor fully into the barrel until it bottoms out.
5. Fit the correct dies and position the connector squarely in the crimping tool.
6. Complete the crimps in the recommended sequence: from the palm toward the cable on lugs, and from the centre toward the ends on ferrules or splices.
7. Inspect the finished crimp for full insertion, correct number of compressions and a firm, even profile.

Key Recommendations

- Use the specified tool and die combination for each connector size.
- Keep the work area clean and support the connector during crimping.
- Verify that the conductor is inserted fully before crimping.
- Do not use undersized or oversized connector dies.
- Do not crimp over insulation or on contaminated, oxidised strands.
- Do not mix conductor and connector materials unless a bi-metal transition is specified.

Tooling note: Refer to the catalogue for tools and correct dies for each connector reference and conductor size.