

ALUMINUM BOLTED CONNECTORS INSTALLATION INSTRUCTIONS

- Step 1: Clean all contact surfaces of the connector and conductor thoroughly with a stiff stainless steel wire brush or sandscreen capable of removing the oxidation film. Remove all contaminants and oxides. A typically bright aluminum surface should result. PLATED CONTACT SURFACES SHOULD NOT BE WIRE BRUSHED.
- Step 2: All contact areas should be coated immediately with a liberal amount of contact sealant (Alcoa #2 EJC or equal). A maximum of two minutes is allowed between completion of the cleaning process and application of the contact sealant.
- Step 3: Install the power connector onto the conductor or other terminal with bolts finger tight only. A significant amount of sealant should appear around the connection. If this is not the case, remove the connector and add additional sealant.
- Step 4: Alternately, in a diagonal pattern, tighten bolts evenly to the SEFCOR recommended torque values.
- Step 5: For Non-EHV power connectors, excess sealant may be left as is or lightly smoothed along the contact line.
- Step 6: For EHV power connectors, all excess sealant must be completely removed.
- Note: For aluminum power connectors with a copper liner to copper connection, Steps 1 through 6 should be followed for maximum protection. However, the use of contact sealant is not absolutely necessary.

RECOMMENDED HARDWARE TORQUE VALUES

Dia.	Stainless Steel			Aluminum			Galvanized Steel		
	in-lb	ft-lb	N-m	in-lb	ft-lb	N-m	in-lb	ft-lb	N-m
3/8"	180	15	20.3	180	15	20.3	180	15	20.3
1/2"	300	25	33.9	300	25	33.9	300	25	33.9
5/8"	480	40	54.2	480	40	54.2	480	40	54.2
3/4"	720	60	81.3	720	60	81.3	720	60	81.3

The torque values assume the following: Hardware consists of a hex head bolt, hex nut and spring lock washer. Aluminum nuts are wax lubricated and used with non-lubricated bolts. Galvanized steel hardware is not lubricated. Stainless steel nuts are wax lubricated and used with non-lubricated bolts. No additional lubrication is used during installation.