

BRONZE 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. PLATED CONTACT SURFACES SHOULD NOT BE WIRE BRUSHED.
- Step 2: Contact sealants are not normally required in copper connections. The use of sealants is recommended in severe corrosive environments and for direct burial applications such as ground grids.
- Step 3: Install the power connector onto the conductor or other terminal with bolts finger tight only.
- Step 4: Alternately, in a diagonal pattern, tighten bolts evenly to the SEFCOR recommended torque values.

RECOMMENDED HARDWARE TORQUE VALUES

Dia.	Silicon Bronze			Stainless Steel			Galvanized Steel		
	In-lb	ft-lb	N-m	in-lb	ft-lb	N-m	in-lb	ft-lb	N-m
3/8"	240	20	27.1	180	15	20.3	180	15	20.3
1/2"	480	40	54.2	300	25	33.9	300	25	33.9
5/8"	660	55	74.6	480	40	54.2	480	40	54.2
3/4"	840	70	94.9	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. Silicon bronze Hardware is not lubricated. 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.