

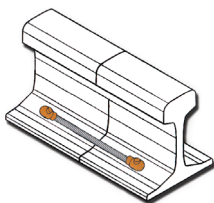
THIS DOCUMENT IS AN INSTRUCTIONAL GUIDE ON THE USE OF EXOWELD® HAMMER DIES.

These dies are used when an exothermic joint requires the cable to be flat on one side, to be welded to a flat surface (like a rail). The hammer die is rounded on the bottom and flat on the top, which is used to hammer the cable into the needed shape.

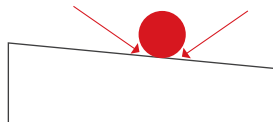
The below guides are examples of the components used and the preparation procedure that will need to take place prior to executing the exothermic welding with the mould and weld metal powder, for welding cables to a flat surface.

WHEN TO USE A HAMMER DIE

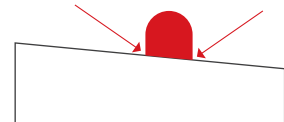
A hammer die is needed when an exothermic connection is required between a cable and a flat surface. This is the case, for example, with a cable to rail foot connection, as explained by the illustration below.



The exothermic weld example:
Cable to Rail foot (Exoweld® code MRF)



The round cable does not lie flat against the rail foot, which allows leakage in bonding and affects molecular fusion.



After the cable has been reshaped in the hammer die, it lies flat against the rail foot, fitting nicely into the mould cavity.

REQUIRED COMPONENTS

These are the required components needed to use a hammer die correctly. The required connection will determine the size of the components.



Bare Stranded Copper Conductor



Copper Sleeve to match conductor size



Hammer Die ordered to match conductor and sleeve size

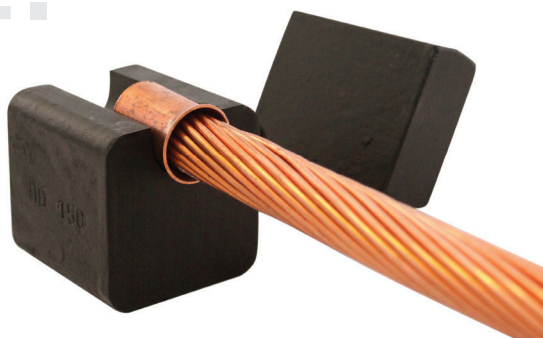
PROCESS GUIDELINES

1.



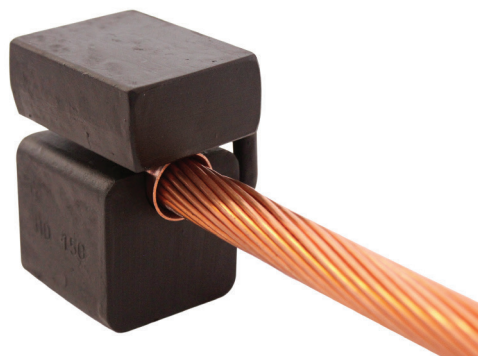
Place the copper sleeve over the end of the copper conductor you would like to make the connection with.

2.



Place the copper sleeve into the hammer die cradle, ensuring it fits properly.

3.



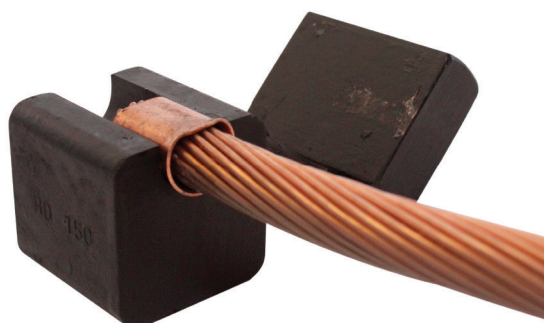
Close the top of the hammer die and check that the copper sleeve comes into contact with the bottom of the lid.

4.



Hammer down the lid firmly, so that the copper sleeve moulds into the shape of the die. This may need to be done several times.

5.



The result will be a conductor and sleeve that are joined, with one side being flat, and the other side remaining round. Use the flat side to exothermically weld the cable to the flat surface.