

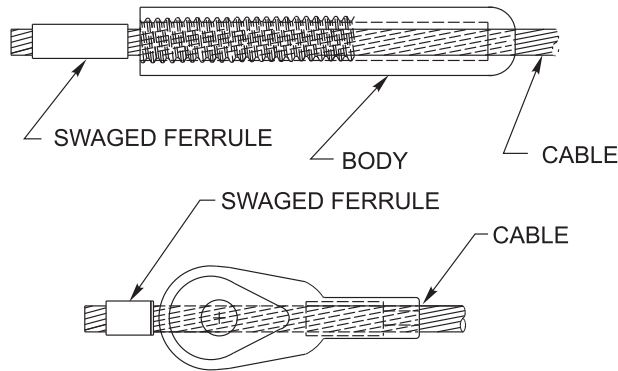
- F. Repeat above steps for each **Cable** to be installed between **Posts**.
- G. Tension the **Cables** (to approximately 400 lbs.) by holding the **Cable** (using **Jawed Pliers**) closely above the **Stud** in the bottom **Rail**. Turn the **Receiver** clockwise with an Allen Wrench from underneath the bottom **Rail**. First, tension the cable nearest the center point between **Posts** and/or cable **Braces**. Then, tension the rest of the **Cables** in sequence, by alternating from one side of the center cable to the other, as you move outward toward the **Posts** and/or **Cable Braces**. (For tensioning sequence illustration, see *Tensioning Cables* in preceding *Installing Cables* Section of this guide.)

SWAGING INSTRUCTIONS

Before you begin swaging

NOTE: If you are using coated cable, be sure to strip the coating from the end of the cable before swaging.

If you are using the **Adjust-A-Jaw™** or **Adjust-A-Body™** Type **Tensioner** or **Ultra-Tec® Fixed Jaw** fitting, make sure the **Cable** has been inserted through the **Body** of the fitting prior to swaging the **Ferrule** onto the **Cable**. See illustrations below.



If you are using the **Invisiware® Receiver** or **Welded Receiver (Threaded Receiver inside Post)**, the **Stud** will be swaged onto the end of the **Cable** and will install directly into the fitting.

If you are using the **Invisiware® Radius Ferrule** or **Clip-on Stop**, the fitting will be swaged onto the end of the **Cable** and no further operation will be required.

NOTE: Swage the fitting on one end of the Cable only, before stringing Cables through Posts and Braces. Where only one end of the Cable has an adjusting fitting (Invisiware® Receiver or Adjust-A-Jaw™ or Adjust-A-Body™ Type Tensioner), we recommend that you swage the unadjusting end first and the adjusting end last –after the Cables have been strung.

Swaging

- A. If you are using any fittings other than **Radius Ferrules** or **Clip-on Stops**, position the **Ferrule** or (threaded) **Stud** onto the Cable as shown in Figure D below.

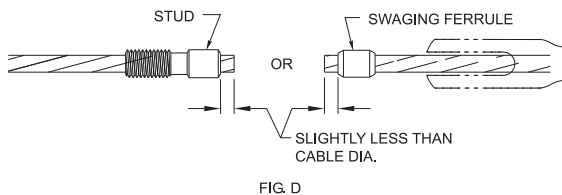
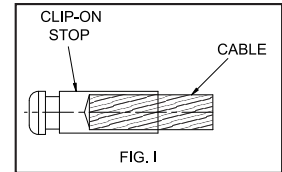
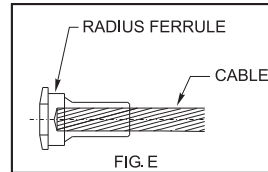


FIG. D

If you are using **Radius Ferrules** or **Clip-on Stops**, slide the **Cable** into the open end of the fitting until it stops (see Figures E and I).



- B. Place **Ferrule** or **Stud** into **Open Swager Dies**

If you are using the **Ultra-Tec® Model 610 Portable Swager** for 1/8" and 3/16" diameter Cable (for **CRS4 & CRS6 Studs** and **CRF4 & CRF6 Ferrules**), see Figure F.

TAKE CARE TO AVOID PUTTING THREADS IN SWAGING DIES

SLOTTED SIDE OF HAND HELD PORTABLE SWAGER

(FOR CRS4 & CRS6 STUDS ONLY)

SLOTTED SIDE OF HAND HELD PORTABLE SWAGER

(FOR CRS4 & CRS6 FERRULES ONLY)
USING MODEL 610 SWAGER

FIG. F

If you are using the **Ultra-Tec® Model 650 Portable Swager** for all sizes of **Cable**, see Figure G. Make sure the die size you use in the **Swager** is the one marked for the diameter of the **Cable** onto which the fitting is being swaged.

TAKE CARE TO AVOID PUTTING THREADS IN SWAGING DIES

FOR STUDS

FOR RADIUS FERRULES

FOR FERRULES

USING MODEL 650 PORTABLE SWAGER

FIG. G