

01300-A. SUBMITTAL TRANSMITTAL FORM

SUBMITTAL TRANSMITTAL

Submittal Description: Receipt for Sweeping Dies Submittal No: 4
 Spec Section: 05150

	Routing	Sent	Received
OWNER: City of Lake Oswego	Contractor/CM	7/9/09	
PROJECT: Lake Oswego Interceptor Sewer	CM/Engineer	7/9/09	1/9/09
CONTRACTOR:	Engineer/CM		
	CM/Contractor		

We are sending you: Attached Product data for information only Submittals for review and comment
 Under separate cover via _____

Remarks: _____

Item	Copies	Date	Section No.	Description	Review action*	Reviewer initials	Review comments attached
1	3	1/9/09	05150	Receipt for newsweeping dies	NET	NEB	

*Note: NET = No exceptions taken; MCN = Make corrections noted; A&R = Amend and resubmit; R = Rejected
 Attach additional sheets if necessary.

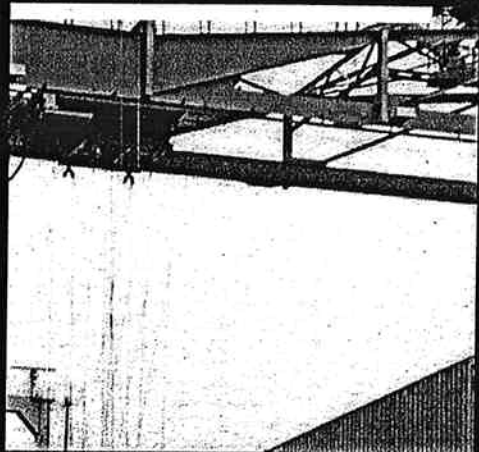
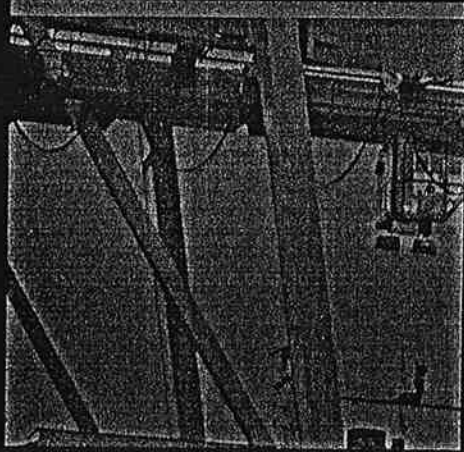
Contractor: Certify either A or B

- A. We have verified that the material or equipment contained in this submittal meets all the requirements, including coordination with all related work, specified (no exceptions).
- B. We have verified that the material or equipment contained in this submittal meets all the requirements specified except for the attached deviations.

No.	Deviation

Certified by: [Signature]
 Contractor's Signature

¹ See paragraph 01300-4.0 A, Transmittal Procedure.



 **ESCO®**

How to Swage ESCO® Cast Stainless Steel Open and Closed Sockets/5/16" through 1-1/8"

Fast Installation, Long Service Life

ESCO Cast Stainless Steel Swage Sockets are made with ESCO 40 stainless steel swaging alloy to provide ideal swaging characteristics. These sockets have tapered shanks to provide a firm but gradual grip on the rope for maximum rope life and efficiency.

These sockets are designed to be used on 6 x 19 classifications, right regular lay, E.I.P., I.W.R.C. wire rope manufactured to U.S. specifications. If other constructions of wire rope are to be used, sample assemblies should first be swaged and properly tested.

Note: The swaging instructions on these pages are for ESCO cast smooth bore sockets. Contact your ESCO representative for swaging information about earlier ESCO "screwy" cast sockets.

Check Dies for Wear

Before swaging, check your dies for wear with ESCO die gauges to be certain they are in good condition.

Lubricate Dies

Use E.P. No. 1 or No. 2 Extreme Pressure Grease to lubricate dies or sockets before swaging.

Die Selection

To be sure of attaining best performance, it is recommended that you use only ESCO dies for swaging ESCO sockets. Use the chart below to select the correct dies.

IMPORTANT:

ESCO Cast Stainless Steel Sockets			
Socket (Rope) Size	Die Description*	Die Part Number	
		Mk 75/87 Swagers	Mk 100 & Larger Swagers
5/16"	3/8" Open	4016520	4003338
3/8"	3/8" Open	4016520	4003338
7/16"	1/2" Open	4016518	4003340
1/2"	1/2" Open	4016518	4003340
9/16"	5/8" Open	4016522	4003342
5/8"	5/8" Open	4016522	4003342
<i>NOTE: 5/8" is maximum size for the Mark 75/87 swager</i>			
3/4"	3/4" Open Channel		4003343
<i>NOTE: 3/4" is maximum size for the Mark 100 swager</i>			
7/8"	3/4" Open Channel		4003343
1"	7/8" Open Channel		4003344
1-1/8"	1" Open Channel		4003345
<i>NOTE: 1-1/8" is maximum for the Mark 150 swager</i>			

*Refer to page 8 for diameters of open channel dies.

Socket (Rope) Size	Minimum Amount of Rope to Insert in Socket
5/16"	2-1/4"
3/8"	2-1/4"
7/16"	3"
1/2"	3"
9/16"	3-3/4"
5/8"	3-3/4"
3/4"	4-1/8"
7/8"	5-1/8"
1"	6"
1-1/8"	8-9/16"

SWAGING DIES

QUALITY SWAGING AT A COMPETITIVE PRICE

ESCO® Swaging Dies are precision manufactured using premium quality tool steel.

Their lightweight, durable design makes them easy to handle and profitable to use.

When used properly with ESCO swage fittings, they will deliver long, trouble-free service.

ADAPTERS FOR COMPETITIVE SWAGERS

ESCO can make adapters that will allow you to use standard ESCO Dies and the ESCO swaging system in competitive swagers.

Call for a quote on your specific requirements.

THREE BASIC DIE BLOCK SIZES

- 2" x 3-1/2" end dimension. Working Load Limit (WLL) 200 tons jaw pressure. Use on ESCO Mark 75 and Mark 87 swagers.
Weight 11-16 pounds per set.
- 2-1/2" x 5" end dimension. WLL 500 tons jaw pressure. Use on ESCO Mark 100 and Mark 150 Swagers. Can be used on Mark 200 and Mark 250 swagers with an adapter. Do not exceed 500 ton WLL!
Weight 25-40 pounds per set.
- 4" x 7" end dimension. WLL 1200 tons jaw pressure. Use on ESCO Mark 200 and Mark 250 Swagers.
Weight 90-134 pounds per set.

SWAGING DIE TYPES

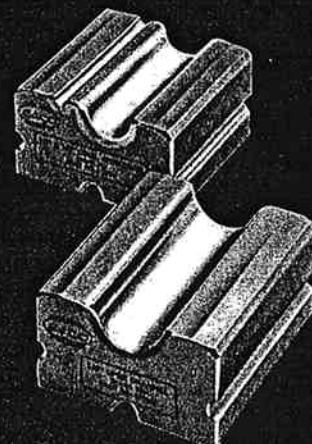
ESCO dies are available in five basic types:

Open Channel Dies

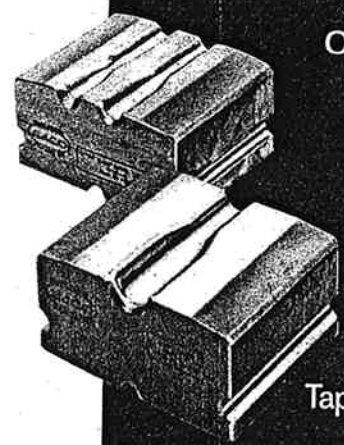
Swages all ESCO stainless steel, duplex, and single sleeves. Also swages some sizes of sockets, ferrules, and carbon steel sleeves.

Tapering Dies

Swage ESCO carbon steel sleeves. Preliminary swaging is required in open channel dies on 1" and larger sleeves.



Open Channel Dies



Tapering Dies