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	WRITTEN BY: Peter Stanwicks
DESCRIPTION: Dyform Swaging Recommendations	PAGE 1 of 1
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1 Introduction

Navtec has done extensive testing on Dyform wire swages resulting in improved swaging techniques. Dyform wire is stronger than the same size conventional 1x19 wire and can put greater loads on the swages. The following swaging procedure is recommended to produce the best possible adhesion to withstand the greater strength of Dyform wire.

2 Tools And Consumables Required

1. Roll type swaging machine. WireTeknik swaging tool is recommended
2. Scotch Brite
3. Acetone
4. High Strength Sleeve Retainer, Permatex Item No. 64040
5. Diamond Dust, GE Micron Products Type SJK-5, Size 140/170, Carat 100

3 Assembly

1. Inspect end fittings inside diameter and Dyform outside diameter for correct fit between the two.
2. Using Scotch Brite, clean the Dyform wire for the length of the swage.
3. Rinse off the Dyform with acetone and dry with clean cloth
4. Put High Strength Sleeve Retainer on Dyform for the length of the swage
5. Sprinkle Diamond Dust on the Dyform for the length of the swage
6. Insert the Dyform into the fitting and rotate 360° to spread the Sleeve Retainer and Diamond Dust around inside the swage
7. Swage the fitting per the machine manufacturer's instructions.

Note: Navtec recommends roll-type swaging over rotary for Dyform. As an option, rotary swagers can be used for 8mm and smaller Dyform wire. Please contact Navtec for further information.