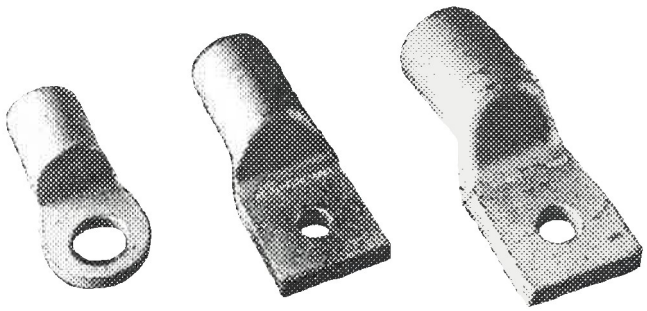
Hotpress

COPPER COMPRESSION FITTINGS

Heavy Duty Copper Cable Lugs and Connectors



Range 1.5mm² - 1000mm²

The Hotpress series of copper cable lugs and connectors are designed to meet the most demanding performance standards e.g. BS4579 Part 1. Forged by hot pressing from a solid copper billet and machined accurately to size, each item in the range consists entirely of solid copper to BS1433:1970. This form of manufacture eliminates stesses at critical points, e.g. the palm/barrel interface, where the larger cross section of conductive material also contributes to a lower through resistance. Unlike a tubular lug, the palm is solid copper, with a lower resistance and with no inside surfaces to cause current transfer problems. The palm thickness and width are not limited by the barrel, as in the case of a lug manufactured from tube. The range is electro-tinned to BS 1872 to reduce corrosion and to improve the electrical interface.

Overall, the Hotpress lug has a higher short circuit rating, operates at a lower onload temperature, resulting in a greater stability, reliability, and service life. Suitable for circular stranded and flexible copper conductors in the range of 1 .5mm² to 1000mm². The following tables show the standard range of hotpress lugs, but due to the versatility of manufacturing from a solid copper blank other variations are easily manufactured and can be quoted for on request.

Product Selection

These products are accurately manufactured for reliability in service and careful attention must be given to selecting the correct fitting for your particular application. The following tables have been designed to assist selection, and the following sequence should be employed.

1. Accurately identify the size of conductor to be terminated or jointed.
2. Refer to the ‘Conductor’ column of the tables and select the required size.
3. Reading across from the conductor size -

    If the conductor is to be terminated select the required bolt hole size and note the Erma Cat N°.
    If the conductor is to be jointed then note the Erma Cat N°.

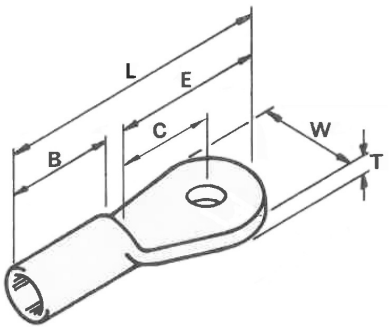
Unit 4A, London Medway Commercial Park, James Swallow Way, Hoo, Rochester, ME3 9GX
Tel: +44 (0)1322 444500
info@sicame.co.uk www.sicame.co.uk

Hotpress

COPPER COMPRESSION FITTINGS

Hotpress Copper Cable Lugs

Range 1.5mm² - 6mm²

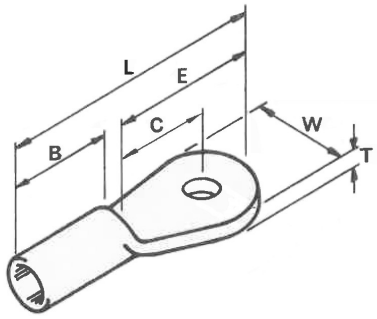


CONDUCTOR			ERMA CAT No.	DIMENSIONAL INFORMATION (mm)								DIE SELECTION
C.S.A (mm²)	No. & DIAMETER OF STRANDS (mm)			BOLT SIZE	W	L	B	E	C	T	Kg per 100	CRIMP CODE
	CIRCULAR STRANDED	FLEXIBLE										
1.5	1/1.38 7/0.50	32/0.20 19/0.30 30/0.25	41000	Pilot	16	33	7	24	15	1.3	0.3	HB
			41004	M4	8	19	7	11	7	1.1	0.1	
			41005	M5	10	21	7	13	8	1.1	0.2	
			41006	M6	16	33	7	24	16	1.0	0.3	
			41008	M8	16	33	7	24	16	1.0	0.3	
2.5	1/1.78 7/0.67	50/0.25	41010	Pilot	16	33	7	24	15	1.3	0.3	
			41014	M4	8	19	7	11	7	1.1	0.1	
			41015	M5	10	21	7	13	8	1.1	0.2	
			41016	M6	16	33	7	24	16	1.0	0.3	
			41018	M8	16	33	7	24	16	1.0	0.3	
4	1/2.25 7/0.85	56/0.30	41020	Pilot	16	27	7	19	11	1.1	0.2	HD
			41024	M4	8	19	7	11	7	1.1	0.1	
			41025	M5	10	21	7	13	8	1.1	0.2	
			41026	M6	15	25	7	17	7	1.1	0.2	
			41028	M8	16	27	7	19	11	1.1	0.2	
			41029	M10	16	27	7	19	11	1.1	0.2	
6	1/2.76 7/1.04		41030	Pilot	16	27	7	19	11	1.1	0.2	HD
			41034	M4	8	19	7	11	7	1.1	0.1	
			41035	M5	10	21	7	13	8	1.1	0.2	
			41036	M6	15	25	7	17	7	1.1	0.2	
			41038	M8	16	27	7	19	11	1.1	0.2	
			41039	M10	16	27	7	19	11	1.1	0.2	
		84/0.30 b	41040	Pilot	16	27	7	19	11	1.1	0.2	
			41044	M4	8	19	7	11	7	1.1	0.1	
			41045	M5	10	21	7	13	8	1.1	0.2	
			41046	M6	15	25	7	17	7	1.1	0.2	
			41048	M8	16	27	7	19	11	1.1	0.2	
			41049	M10	16	27	7	19	11	1.1	0.2	

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Hotpress Copper Cable Lugs

Range 10mm² - 16mm²

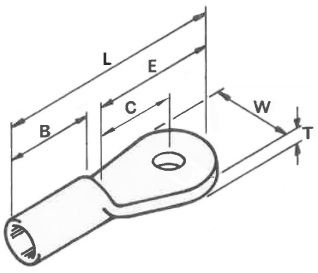


CONDUCTOR			ERMA CAT No.	DIMENSIONAL INFORMATION (mm)								DIE SELECTION
C.S.A (mm²)	No. & DIAMETER OF STRANDS (mm)			BOLT SIZE	W	L	B	E	C	T	Kg per 100	CRIMP CODE
	CIRCULAR STRANDED	FLEXIBLE										
10	1/3.57		41050	Pilot	19	33	9	19	12	1.4	0.5	HF
			41054	M4	15	27	9	17	7	1.4	0.4	
			41055	M5	15	27	9	17	7	1.4	0.4	
			41056	M6	15	27	9	17	7	1.4	0.4	
			41058	M8	16	29	9	19	11	1.4	0.4	
			41059	M10	19	33	9	24	12	1.4	0.5	
	7/1.35	80/0.40 b	41060	Pilot	19	33	9	19	12	1.4	0.5	
			41064	M4	15	27	9	17	7	1.4	0.4	
			41065	M5	15	27	9	17	7	1.4	0.4	
			41066	M6	15	27	9	17	7	1.4	0.4	
			41068	M8	16	29	9	19	11	1.4	0.4	
			41069	M10	19	33	9	24	12	1.4	0.5	
16	1/4.50		41070	Pilot	19	35	11	24	12	1.5	0.7	HG
			41075	M5	15	30	11	18	11	1.5	0.6	
			41076	M6	15	30	11	18	11	1.5	0.6	
			41078	M8	16	32	11	20	12	1.5	0.6	
			41079	M10	19	35	11	24	12	1.5	0.7	
	7/1.70		41080	Pilot	19	35	11	24	12	1.5	0.7	
			41085	M5	15	30	11	18	11	1.5	0.6	
			41086	M6	15	30	11	18	11	1.5	0.6	
			41088	M8	16	32	11	20	12	1.5	0.6	
			41089	M10	19	35	11	24	12	1.5	0.7	
		126/0.40 b 126/0.40 m 513/0.20 m 573/0.20 m	41090	Pilot	19	35	11	24	12	1.5	0.7	
			41095	M5	15	30	11	18	11	1.5	0.6	
			41096	M6	15	30	11	18	11	1.5	0.6	
			41098	M8	16	32	11	20	12	1.5	0.6	
			41099	M10	19	35	11	24	12	1.5	0.7	

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Hotpress

COPPER COMPRESSION FITTINGS



Hotpress Copper Cable Lugs **Range** 25mm² - 70mm²

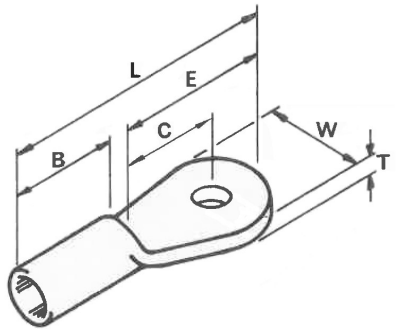
CONDUCTOR			ERMA CAT No.	DIMENSIONAL INFORMATION (mm)								DIE SELECTION
C.S.A (mm²)	No. & DIAMETER OF STRANDS (mm)			BOLT SIZE	W	L	B	E	C	T	Kg per 100	CRIMP CODE
	CIRCULAR STRANDED	FLEXIBLE										
25	7/2.14 19/1.35	196/0.40 b	41100	Pilot	26	44	13	29	16	1.8	1.5	HH
			41106	M6	15	32	13	17	10	1.8	0.9	
			41108	M8	16	34	13	19	11	1.8	1.1	
			41109	M10	19	37	13	22	12	1.8	1.3	
			41104	M12	26	44	13	29	16	1.8	1.5	
		196/0.40 m 783/0.20 m	41110	Pilot	26	44	13	29	16	1.8	1.5	
			41116	M6	15	32	13	17	10	1.8	0.9	
			41118	M8	16	34	13	19	11	1.8	1.1	
			41119	M10	19	37	13	22	12	1.8	1.3	
			41114	M12	26	44	13	29	16	1.8	1.5	
35	19/1.53	276/0.40 b	41120	Pilot	26	48	17	30	16	2.3	2.5	HI
			41126	M6	16	38	17	19	11	2.3	2.0	
			41128	M8	16	38	17	19	11	2.3	2.0	
			41129	M10	19	42	17	23	13	2.3	2.3	
			41124	M12	26	48	17	30	17	2.3	2.5	
50	19/1.78	276/0.40 m 1107/0.20 m	41130	Pilot	26	48	17	30	16	2.3	2.5	
			41136	M6	16	38	17	19	11	2.3	2.0	
			41138	M8	16	38	17	19	11	2.3	2.0	
			41139	M10	19	42	17	23	13	2.3	2.3	
			41134	M12	26	48	17	30	17	2.3	2.5	
			41140	Pilot	26	48	17	30	16	2.3	2.5	
			41146	M6	16	38	17	19	11	2.3	2.0	
			41148	M8	16	38	17	19	11	2.3	2.0	
			41149	M10	19	42	17	23	13	2.3	2.3	
			41144	M12	26	48	17	30	17	2.3	2.5	
70	19/2.14	396/0.40 m 702/0.30 m 1566/0.20 m	41150	Pilot	26	53	21	29	16	3.3	4.3	HK
			41156	M6	19	46	21	22	12	3.3	3.7	
			41158	M8	19	46	21	22	12	3.3	3.7	
			41159	M10	19	46	21	22	12	3.3	3.7	
			41154	M12	26	53	21	29	16	3.3	4.3	
			41155	M16	26	53	21	29	16	3.3	4.3	
		360/0.50 b	41160	Pilot	26	53	21	29	16	3.3	4.3	
			41169	M10	19	46	21	22	12	3.3	3.7	
			41164	M12	26	53	21	29	16	3.3	4.3	
			41165	M16	26	53	21	29	16	3.3	4.3	

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Hotpress Copper Cable Lugs

Range 95mm² - 185mm²

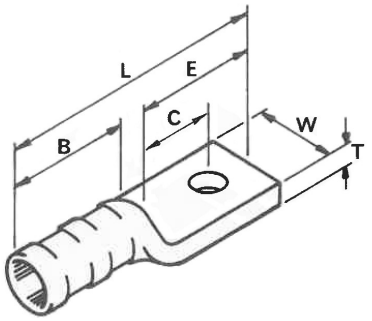


CONDUCTOR			ERMA CAT No.	DIMENSIONAL INFORMATION (mm)								DIE SELECTION
C.S.A (mm²)	No. & DIAMETER OF STRANDS (mm)			BOLT SIZE	W	L	B	E	C	T	Kg per 100	CRIMP CODE
	CIRCULAR STRANDED	FLEXIBLE										
95	19/2.52 37/1.78	360/0.50 m 999/0.30 m 2214/0.20 m	41170	Pilot	26	56	23	30	17	3.3	5.5	HL
			41176	M6	19	49	23	23	13	3.3	4.8	
			41178	M8	19	49	23	23	13	3.3	4.8	
			41179	M10	19	49	23	23	13	3.3	4.8	
			41174	M12	26	56	23	30	17	3.3	5.5	
			41175	M16	26	56	23	30	17	3.3	5.5	
		475/0.50 b	41180	Pilot	26	56	23	30	17	3.3	5.5	
			41189	M10	19	49	23	23	13	3.3	4.8	
			41184	M12	26	56	23	30	17	3.3	5.5	
			41185	M16	26	56	23	30	17	3.3	5.5	
120	37/2.03	475/0.50 m 1332/0.30 m 2997/0.20 m 608/0.50 b	41190	Pilot	26	59	26	29	16	4.1	7.3	HM
			41196	M6	19	52	26	22	12	4.1	6.3	
			41198	M8	19	52	26	22	12	4.1	6.3	
			41199	M10	19	52	26	22	12	4.1	6.3	
			41194	M12	26	59	26	29	16	4.1	7.3	
			41195	M16	26	59	26	29	16	4.1	7.3	
150	37/2.25	608/0.50 m	41200	Pilot	32	73	32	35	19	6.6	13.5	HN
			41209	M10	19	56	30	22	12	4.6	9.1	
			41204	M12	26	63	30	29	16	4.6	9.5	
			41205	M16	32	73	32	35	19	6.6	13.0	
			41206	M20	32	73	32	35	19	6.6	12.0	
185	37/2.52	756/0.50 m	41410	Pilot	38	76	35	35	18	6.6	19.8	HP
			41419	M10	38	76	35	35	18	6.6	19.6	
			41414	M12	38	76	35	35	18	6.6	19.2	
			41415	M16	38	76	35	35	18	6.6	18.5	
			41416	M20	38	76	35	35	18	6.6	17.5	

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Hotpress Copper Cable Lugs

Range 240mm² - 1000mm²



CONDUCTOR			ERMA CAT No.	DIMENSIONAL INFORMATION (mm)								DIE SELECTION
C.S.A (mm²)	No. & DIAMETER OF STRANDS (mm)			BOLT SIZE	W	L	B	E	C	T	Kg per 100	CRIMP CODE
	CIRCULAR STRANDED	FLEXIBLE										
240	61/2.25	925/0.50 m	41720	Blank	38	109	52	47	28	9.8	40	DE
			41729	M10	38	109	52	47	28	9.8	39	
			41724	M12	38	109	52	47	28	9.8	39	
			41725	M16	38	109	52	47	28	9.8	38	
			41726	M20	38	109	52	47	28	9.8	37	
300	61/2.52	1221/0.50 m	41730	Blank	45	109	52	47	25	11.1	51	DF
			41734	M12	45	109	52	47	25	11.1	50	
			41735	M16	45	109	52	47	25	11.1	49	
			41736	M20	45	109	52	47	25	11.1	48	
400	61/2.85 91/2.36	1525/0.50 m	41740	Blank	48	123	61	51	27	12.1	73	DG
			41745	M16	48	123	61	51	27	12.1	71	
			41746	M20	48	123	61	51	27	12.1	70	
		2013/0.50 m	41760	Blank	48	123	61	51	27	12.1	68	
			41765	M16	48	123	61	51	27	12.1	64	
			41766	M20	48	123	61	51	27	12.1	63	
500	61/3.20 91/2.65		41750	Blank	48	123	61	51	27	12.1	67	
			41755	M16	48	123	61	51	27	12.1	63	
			41756	M20	48	123	61	51	27	12.1	62	
630*	127/2.52	1769/0.60 m	41770	Blank	57	136	67	57	28	12.8	94	DH
			41776	M20	57	136	67	57	28	12.8	90	
			41778	M24	57	136	67	57	28	12.8	89	
800**	127/2.85	2257/0.60 m	41780	Blank	70	160	79	68	39	16.1	144	DI
			41786	M20	70	160	79	68	39	16.1	138	
			41788	M24	70	160	79	68	39	16.1	136	
1000**	127/3.20		41790	Blank	70	160	79	68	39	16.1	166	DJ
			41796	M20	70	160	79	68	39	16.1	160	
			41798	M24	70	160	79	68	39	16.1	158	

* Cable lug or connector to be crimped twice , ** three times

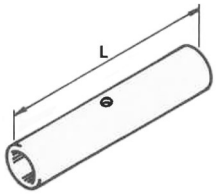
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Hotpress

COPPER COMPRESSION FITTINGS

Butt Connectors

Range 4mm² - 185mm²



CONDUCTOR			ERMA CAT No.	DIMENSIONAL INFORMATION (mm)		DIE SELECTION
C.S.A (mm²)	No. & DIAMETER OF STRANDS (mm)			L	Kg per 100	CRIMP CODE
	CIRCULAR STRANDED	FLEXIBLE				
4	1/2.25 7/0.85	56/0.30	41021	11.0	0.1	HD
6	1/2.76 7/1.04		41031	11.0	0.1	
		84/0.30 b	41041	11.0	0.1	
10	1/3.57		41051	17.0	0.4	HF
	7/1.35	80/0.40 b	41061	17.0	0.4	
16	1/4.50		41071	20.0	0.8	HG
	7/1.70		41081	20.0	0.8	
		126/0.40 b 126/0.40 m 513/0.20 m 573/0.20 m	41091	20.0	0.8	
25	7/2.14 19/1.35	196/0.40 b	41101	29.0	1.5	HH
		196/0.40 m 783/0.20 m	41111	29.0	1.4	
35	19/1.53	276/0.40 b	41121	33.0	2.9	HI
50	19/1.78	276/0.40 m 110/0.20 m	41131	33.0	2.5	
			41141	33.0	2.2	
70	19/2.14	396/0.40 m 702/0.30 m 1566/0.20 m	41151	38.0	4.9	HK
		360/0.50 b	41161	38.0	4.5	
95	19/2.52 37/1.78	360/0.50 m 999/0.30 m 2214/0.20 m	41171	42.0	6.5	HL
		475/0.50 b	41181	42.0	6.2	
120	37/2.03	475/0.5 m 1332/0.3 m 2997/0.2 m 608/0.5 b	41191	45.0	8.0	HM
150	37/2.25	608/0.50 m	41201	55.0	12.5	HN
185	37/2.52	756/0.50 m	41411	58.0	19.5	HP

* Cable lug or connector to be crimped twice,
** three times

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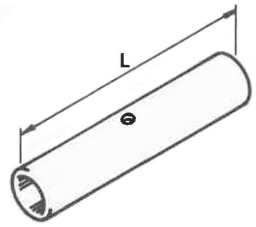
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Hotpress

COPPER COMPRESSION FITTINGS

Butt Connectors

Range 240mm² - 1000mm²



CONDUCTOR			ERMA CAT No.	DIMENSIONAL INFORMATION (mm)		DIE SELECTION
C.S.A (mm²)	No. & DIAMETER OF STRANDS (mm)					
	CIRCULAR STRANDED	FLEXIBLE		L	Kg per 100	CRIMP CODE
240	61/2.25	925/0.50 m	41721	84.0	27	DE
300	61/2.52	1221/0.50 m	41731	87.0	38	DF
400	61/2.85 91/2.36	1525/0.50 m	41741	103.0	60	DG
		2013/0.50 m	41761	103.0	50	
500	61/3.20 91/2.65		41751	103.0	45	
630*	127/2.52	1769/0.60 m	41771	115.0	63	DH
800**	127/2.85	2257/0.60 m	41781	128.0	111	DI
1000**	127/3.20		41791	135.0	122	DJ

The Erma Crimping Code

A feature central to the entire range of Erma crimping products and essential to their proper use is a universal system of coding. Each correctly matched lug and conductor pairing carries an exclusive Erma Crimping Code, which precisely identifies the crimping dies and tools which should be used to achieve a high integrity connection, as a foolproof means to avoid the problems of incorrect selection and fitting.

The contact face of the correctly selected die set carries the same Erma Crimp Code as that of the lug or connector, which on compression becomes permanently embossed on the crimping barrel of the fitting. In addition to the immediate check after the crimping operation, this provides considerable advantages to subsequent quality control inspection, or circuit fault investigation.

Special Purpose Hotpress Copper Cable Lugs

The versatility of the manufacturing methods employed by Sicame UK means that special purpose products can be easily manufactured to suit your particular application. The following Hotpress copper lug variations can be quoted for on request : -

Blank Palm Lugs—Bolt holes to be drilled out by the user for adapting to your requirement.

Multi-Hole Fixings—The Hotpress range of cable lugs can be supplied with single, two, four or any number of bolt holes dependant on the physical constraints of the cable lug.

Angled Palm Lugs—Hotpress cable lug palms can be bent at customer specified angles. The most commonly requested angles are 45° and 90°.

Special Plating Finishes—The Hotpress range of fittings are as standard, electro-tinned to BS1872, but other finishes are available if required. e.g. Natural bright copper or Nickle plated.

Or, you could even have any combination of the above. But in any event please feel free to contact Sicame UK so that we may discuss your requirement and solve your application problems.

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