

**SWAGERS, SLEEVES & TOOLING (MADE IN JAPAN)**



**ARM - HOW TO SWAGE**

1. Cut wire

2. Thread Wire through Oval Sleeve

3. Loop the Wire Rope from Eyelet

4. Decide Length of Wire Rope Eyelet

5. Swage Oval Sleeve

PROPER WAY OF SWAGING SLEEVE

SWAGE 3 POINTS

QUALITY CHECK SLEEVE WITH GAUGE, PASS THROUGH SWAGING COMPLETE!

**ARM – SIZE CHART OF ARM OVAL SLEEVES & ARM SWAGING TOOLS**

| Wire Rope Ø mm<br>(")    | 1.5<br>1/16  | 2.0<br>5/64 | 2.5<br>3/32 | 2.8<br>7/64 | 3.0<br>1/8 | 3.5<br>- | 4.0<br>5/32  | 5.0<br>3/16 | 6.0<br>1/4 | 8.0<br>5/16 | 9.0<br>3/8 | 10.0<br>13/32 | 12.0<br>1/2 |
|--------------------------|--------------|-------------|-------------|-------------|------------|----------|--------------|-------------|------------|-------------|------------|---------------|-------------|
| Arm Oval Sleeves         | OS-1A        | OS-1B       | OS-2        | OS-2        | OS-3       | OS-3     | OS-4         | OS-5        | OS-6       | OS-8        | OS-9       | OS-10         | OS-12       |
| Swaging Tool<br>Required | HSC-350      |             |             |             |            |          | Cannot Swage |             |            |             |            |               |             |
|                          | HSC-600      |             |             |             |            |          | Cannot Swage |             |            |             |            |               |             |
|                          | HSC-600BB    |             |             |             |            |          | Cannot Swage |             |            |             |            |               |             |
|                          | Cannot Swage |             |             |             |            |          | HS-1000      |             |            |             |            |               |             |
|                          |              |             |             |             |            |          | Cannot Swage |             |            |             |            |               |             |
|                          |              |             |             |             |            |          | HS12-MH230*  |             |            |             |            |               |             |
|                          |              |             |             |             |            |          | HS-12-230V*  |             |            |             |            |               |             |
|                          |              |             |             |             |            |          | HS-12HB      |             |            |             |            |               |             |

\*REFER PAGE 40 & 41 FOR FURTHER DETAILS

**ARM SWAGING OVAL SLEEVE TECHNICAL INFORMATION**

**Checking point for Item No.**

**OS-3A**

A: line on one side  
B: line on both sides

Indicating the number of line on side of body, which should be equivalent to the Hole No. for HSC Swager.

3-lines on both sides **OS-3B**

3-lines on one side **OS-3A**

**Hole No.**

| Model No | Wire Rope Ø |       | Sleeve Image | Hole No. | Safety Load (using 2 wire ropes) |        |      | Wire Rope Destruction Load (using Arm equip) | Pack Qty | Item Weight (kg) | Carton Qty | Carton Weight (kg) |
|----------|-------------|-------|--------------|----------|----------------------------------|--------|------|----------------------------------------------|----------|------------------|------------|--------------------|
|          | (mm)        | (")   |              |          | 30deg.                           | 60deg. |      |                                              |          |                  |            |                    |
| OS-1A    | 1.5         | 1/16  |              | 1        | 56                               | 54     | 48   | 210                                          | 30       | 0.03             | 120        | 5.5                |
| OS-1B    | 2.0         | 5/64  |              | 1        | 96                               | 92     | 82   | 330                                          | 30       | 0.03             | 120        | 5.0                |
| OS-2A    | 2.5         | 3/32  |              | 2        | 152                              | 148    | 132  | 519                                          | 20       | 0.06             | 120        | 8.5                |
| OS-2B    | 2.8         | 7/64  |              | 2        | 182                              | 176    | 158  | 630                                          | 20       | 0.05             | 120        | 7.6                |
| OS-3A    | 3.0         | 1/8   |              | 3        | 220                              | 212    | 190  | 690                                          | 20       | 0.11             | 60         | 7.8                |
| OS-3B    | 3.5         | -     |              | 3        | 280                              | 270    | 242  | 1001                                         | 20       | 0.10             | 60         | 7.1                |
| OS-4A    | 4.0         | 5/32  |              | 4        | 282                              | 272    | 244  | 1204                                         | 20       | 0.10             | 60         | 9.5                |
| OS-5A    | 5.0         | 3/16  |              | 5        | 446                              | 430    | 386  | 1731                                         | 20       | 0.13             | 60         | 12.9               |
| OS-6A    | 6.0         | 1/4   |              | 6        | 556                              | 536    | 480  | 1975                                         | 20       | 0.30             | 10         | 3.2                |
| OS-8A    | 8.0         | 5/16  |              | 8        | 990                              | 956    | 856  | 3284                                         | 20       | 0.50             | 10         | 5.0                |
| OS-9A    | 9.0         | 3/8   |              | 9        | 1250                             | 1206   | 1082 | 4018                                         | 20       | 1.00             | 10         | 9.7                |
| OS-10A   | 10.0        | 13/32 |              | 10       | 1546                             | 1494   | 1338 | 5365                                         | 20       | 0.90             | 10         | 9.2                |
| OS-12A   | 12.0        | 1/2   |              | 12       | 2226                             | 2150   | 1926 | 7456                                         | 20       | 1.90             | 10         | 18.3               |