

HVS-T-2580E 25kV Class

Trifurcating Transition Splice for 3/C PILC to 3-1/C Extruded Dielectric (Poly/EPR) Power Cables

ENERGY DIVISION

Suggested Installation Equipment (not supplied with kit)

- Cable preparation tools
- Tyco Electronics P63 cable preparation kit or cable manufacturer approved solvent
- Clean, lint-free cloths
- Non-conducting abrasive cloth, 120 grit or finer
- Electrician's tape
- Connector(s) and installation tools
- Tyco Electronics recommended torch

Safety Instructions

DANGER: When installing electrical power system accessories, failure to follow applicable personal safety requirements and written installation instructions could result in fire or explosion and serious or fatal injuries.

To avoid risk of accidental fire or explosion when using gas torches, always check all connections for leaks before igniting the torch and follow the torch manufacturer's safety instructions.

To minimize any effect of fumes produced during installation, always provide good ventilation of confined work spaces.

As Tyco Electronics has no control over field conditions which influence product installation, it is understood that the user must take this into account and apply his own experience and expertise when installing product.

Customer Service

For 24 hour customer service, call 800-327-6996.

Recommended Tyco Electronics Torches

Install heat-shrinkable cable accessories with a "clean burning" torch, i.e., a propane torch that does not deposit conductive contaminants on the product.

Clean burning torches include the Tyco Electronics FH-2629, FH-2649 (uses refillable propane cylinders) and FH-2618A (uses disposable cylinder).

Adjusting the Torch

Adjust regulator and torch as required to provide an overall 12-inch bushy flame. The FH-2629 will be all blue, the other torches will have a 3- to 4-inch yellow tip. Use the yellow tip for shrinking.

Regulator Pressure

FH-2618A	Full pressure
FH-2649	25 psig
FH-2629	15 psig

Cleaning the Cable

Use an approved solvent, such as the one supplied in the P63 Cable Prep Kit, to clean the cable. Be sure to follow the manufacturer's instructions. Failure to follow these instructions could lead to product failure.

Some newer solvents do not evaporate quickly and need to be removed with a clean, lint-free cloth. Failure to do so could change the volume resistivity of the substrate or leave a residue on the surface. Please follow the manufacturer's instructions carefully.

General Shrinking Instructions

- Apply outer 3- to 4-inch tip of the flame to heat-shrinkable material with a rapid brushing motion
- Keep flame moving to avoid scorching
- Unless otherwise instructed, start shrinking tube at center, working flame around all sides of the tube to apply uniform heat

To determine if a tube has completely recovered, look for the following, especially on the back and underside of the tube:

1. Uniform wall thickness
2. Conformance to substrate
3. No flat spots or chill marks
4. Visible sealant flow if the tube is coated

Note: When installing multiple tubes, make sure that the surface of the last tube is still warm before positioning and shrinking the next tube. If installed tube has cooled, re-heat the entire surface.

Installation Instructions

1. Product selection

Check kit selection with cable diameter dimensions in Table 1.

Table 1 Kit	PILC/Poly Nominal Cable Range	PILC Insulation Diameter Range	Poly Insulation Diameter Range	Poly Maximum Jacket Diameter	Maximum Connector Dimensions	
					Length	Diameter
HVS-T-2582E	#1-250	0.85-1.20" (22-30mm)	0.90-1.25" (22-32mm)	1.55" (39mm)	5.5" (140mm)	1.10" (28mm)
HVS-T-2583E	350-500	1.15-1.40" (28-36mm)	1.15-1.50" (28-38mm)	2.00" (51mm)	7.0" (178mm)	1.35" (34mm)
HVS-T-2584E	750-1000	1.50-1.70" (38-43mm)	1.60-1.90" (41-48mm)	2.15" (55mm)	8.0" (203mm)	1.85" (47mm)

2. Check ground braid

Verify that ground braid(s) or bond wire have equivalent cross-section to cable metallic shield. Additional braid may be needed for LC shield, lead sheath cables, or if external grounding or shield interrupting is required.

Tyco Electronics HVS-EG supplies ground braid, spring clamp and suggested modifications to make an external ground or shield interrupt.

3. Prepare cables

Choose the splice type (Choice 1-5) and follow the directions given.

Table 2 Kit	Poly Jacket Cutback A	Poly Semi-con Cutback B	PILC Jacket Cutback C*
HVS-T-2582E	11" (279mm)	6-1/2" (165mm)	20" (508mm)
HVS-T-2583E	13" (330mm)	7-1/2" (191mm)	23" (584mm)
HVS-T-2584E	14" (356mm)	8-0" (205mm)	23-1/2" (600mm)

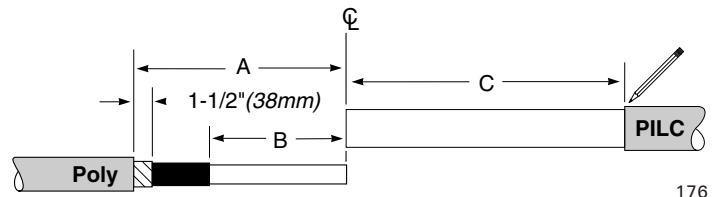
*Mark PILC cable, if unjacketed.

CHOICE 1

If PILC to Metallic Tape Shield, Lead Sheath or LC Shield Cable

Refer to Table 2 and prepare the cables as shown.

Go to Step 4, page 3.



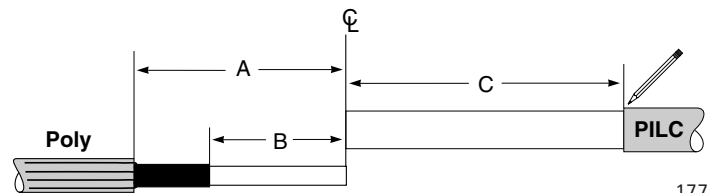
176

CHOICE 2

If PILC to Drain Wire Shield Cable

Refer to Table 2 and prepare the cables as shown.

Go to Step 4, page 3.



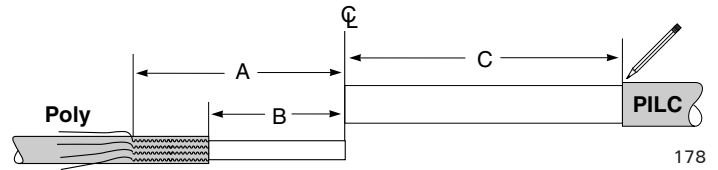
177

CHOICE 3

If PILC to UniShield Cable

Refer to Table 2 and prepare the cables as shown. Pull back the drain wires to Dimension A.

Go to Step 4, below.



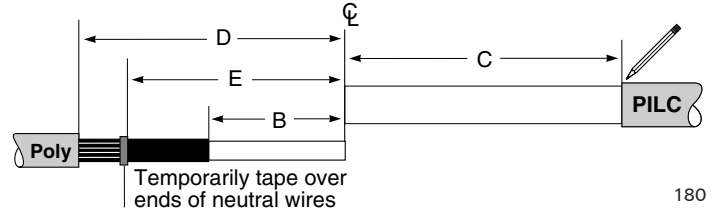
178

CHOICE 4

If PILC to Jacketed Concentric Neutral Cable

Refer to Table 3 and prepare the cables as shown. Cut neutral wires to dimension E and temporarily tape over ends.

Go to Step 4, below.



180

Table 3

Kit	Poly Jacket Cutback D	Poly Wire Cutback E	Poly Semi-con Cutback B	PILC Jacket Cutback C*
HVS-T-2582E	14" (356mm)	10" (254mm)	6-1/2" (165mm)	20" (508mm)
HVS-T-2583E	17" (432mm)	12" (305mm)	7-1/2" (191mm)	23" (584mm)
HVS-T-2584E	18" (460mm)	12" (305mm)	8-0" (205mm)	23-1/2" (600mm)

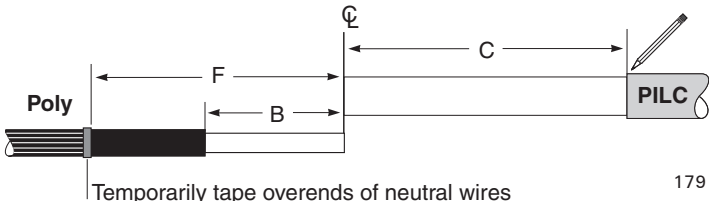
*Mark PILC cable, if unjacketed.

CHOICE 5

If PILC to Unjacketed Concentric Neutral Cable

Refer to Table 4 and prepare the cables as shown. Cut neutral wires to Dimension F and temporarily tape over ends.

Go to Step 4, below.



179

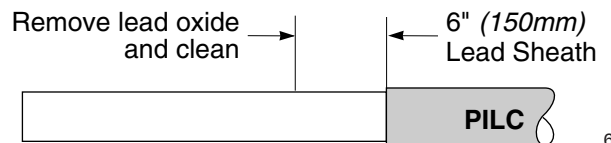
Table 4

Kit	Poly Wire Cutback F	Poly Semi-con Cutback B	PILC Jacket Cutback C*
HVS-T-2582E	13" (330mm)	6-1/2" (165mm)	20" (508mm)
HVS-T-2583E	15" (381mm)	7-1/2" (191mm)	23" (584mm)
HVS-T-2584E	16" (405mm)	8-0" (205mm)	23-1/2" (600mm)

*Mark PILC cable, if unjacketed.

4. Prepare lead sheath

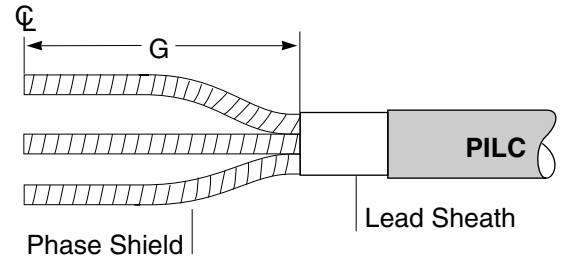
Remove lead oxide from the lead sheath and clean with approved solvent.



653

5. Remove lead sheath as shown

Kit	Lead Sheath Cutback G
HVS-T-2582E	15" (381mm)
HVS-T-2583E	17" (432mm)
HVS-T-2584E	17.5" (445mm)

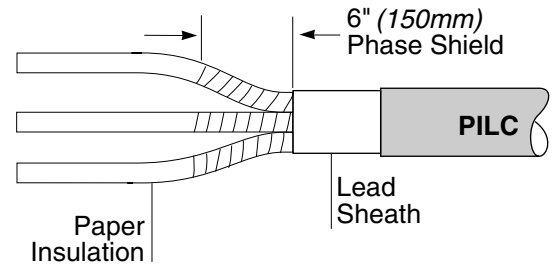


101

6. Cut back shield

Cut back any bedding and/or shielding tapes over all three phases to lead sheath cutback. Cut back phase shields and remove any conductive material from paper insulation as shown.

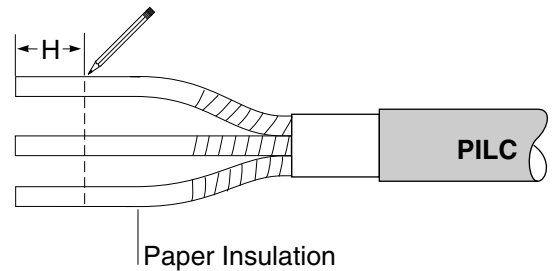
Tack solder metal tape shields to prevent unwrapping and tape over sharp edges with one wrap of electrician's tape.



102

7. Mark insulation as shown

Kit	H
HVS-T-2582E	4" (107mm)
HVS-T-2583E	5" (127mm)
HVS-T-2584E	5-1/2" (140mm)

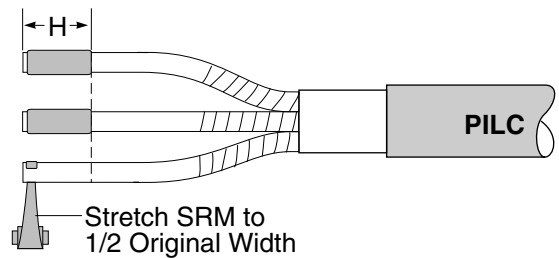


104

8. Apply Stress Relief Material (SRM)

Remove backing strip from one side of a long strip of SRM. Roll up the SRM and remaining backing strip into a convenient size.

Removing the remaining backing strip, tightly wrap one, half-lapped layer of SRM around each phase as shown. Wrap SRM in same direction as insulating papers on cable.

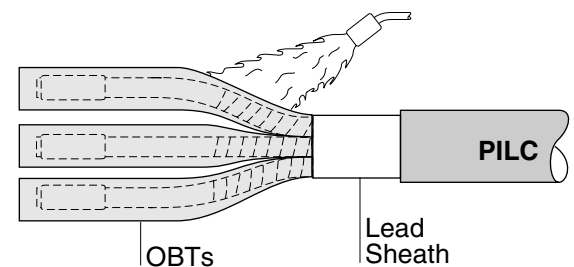


105

9. Position OBT; shrink in place

Place an Oil Barrier Tube (OBT) over each phase, butted to the lead sheath (or belt paper) cutback. Shrink the three OBTs in place starting at the lead sheath cutback.

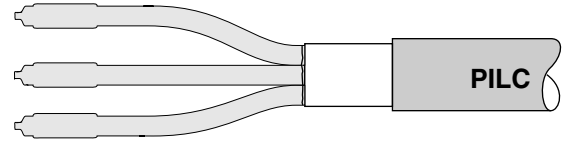
Note: To achieve a smooth, wrinkle-free installation, use a reduced flame to install the thin-walled OBT.



394

10. Inspect OBTs

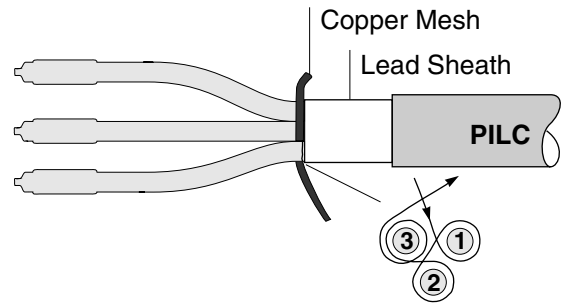
The installed OBTs should have a smooth, wrinkle-free surface after shrinking. Reheat to smooth any wrinkled areas.



395

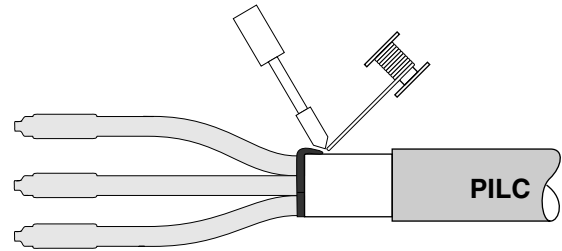
11. Install 1" wide copper mesh

Fold the 1 inch (25mm) wide copper mesh in half lengthwise and wind it around each phase shield as closely as possible to the lead sheath cut.



290

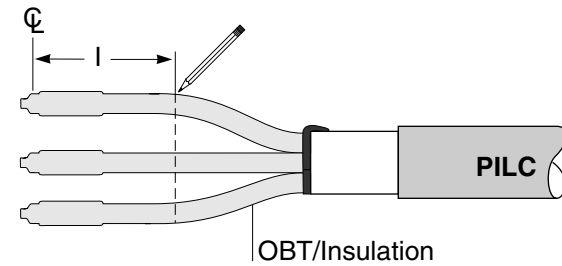
Solder copper mesh to the lead sheath. Cut off excess mesh close to lead sheath.



207

12. Mark OBT/ Insulation at "I"

Kit	I
HVS-T-2582E	7-1/2" (191mm)
HVS-T-2583E	8-1/2" (216mm)
HVS-T-2584E	9" (230mm)

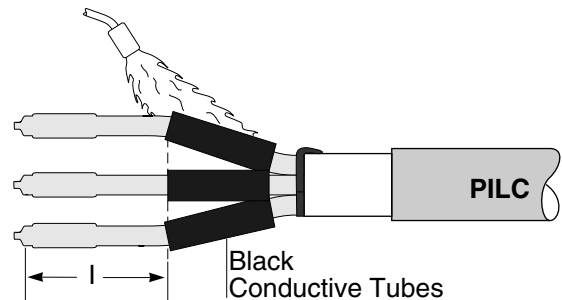


220

13. Position black conductive tubes; shrink in place

Place black conductive tube over each phase and position at dimension I.

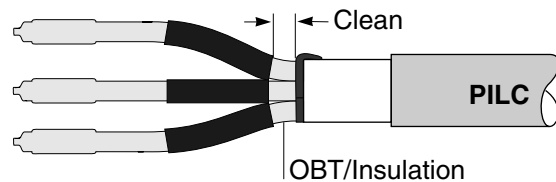
Shrink in place starting at the end nearest to the center of the splice.



221

14. Clean OBTs

Using an approved solvent, clean the OBT/Insulation as shown.

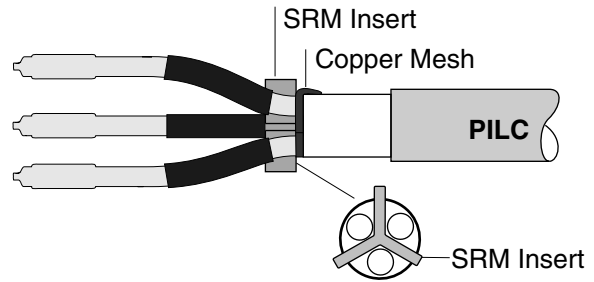


222

15. Install SRM insert

Assemble SRM insert per box instructions. Spread the phases and position the insert as shown.

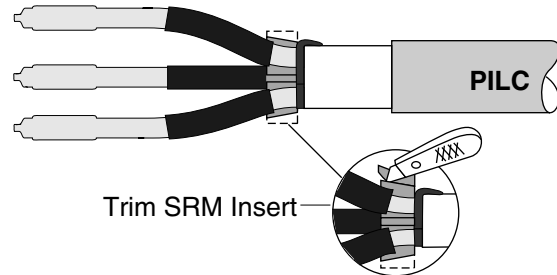
Note: The SRM insert is packaged inside the conductive breakout.



223

16. Trim excess SRM insert

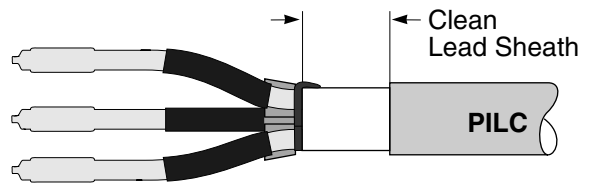
Trim SRM insert to extend 1/8" (3mm) beyond each phase.



224

17. Clean lead sheath

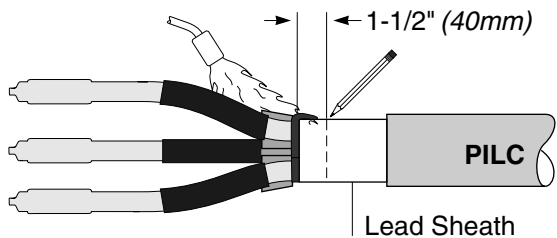
Reclean lead sheath as shown using an approved solvent.



225

18. Mark lead sheath as shown

Note: To ensure SRM to OBT adhesion, gently heat the SRM insert and adjacent OBT before moving on to the next step.

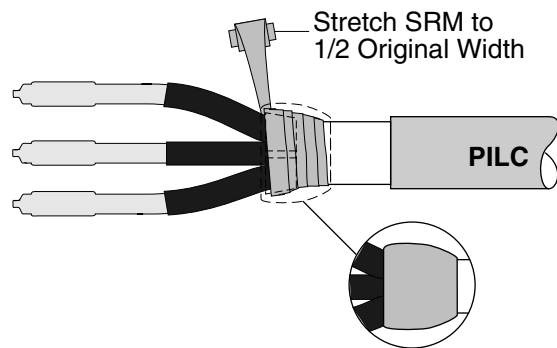


357

19. Install oil seal

Remove backing from one side of a long strip of SRM. Roll the SRM and remaining backing strip into a convenient size. Removing the remaining backing strip, tightly wrap the SRM from the mark on the lead sheath to the outer edge of the SRM insert. Four to six strips of SRM should be used to build the SRM to the shape shown.

Note: Do not over apply. The finished SRM diameter should not exceed that of the breakout installed in the next step.

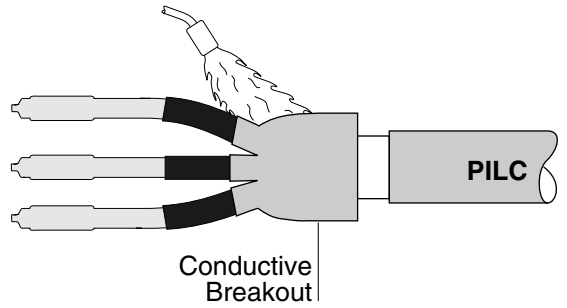


358

20. Position conductive breakout; shrink in place

Position the conductive breakout over the SRM so that the inside butts up hard against the SRM.

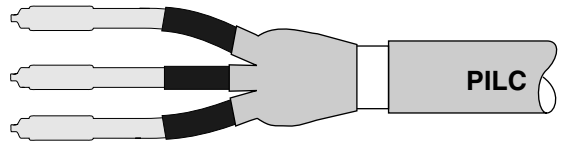
Shrink in place starting at the fingers and working toward the other end.



359

21. Inspect breakout

After the breakout has shrunk, continue to apply heat until the breakout has a smooth, uniform surface.



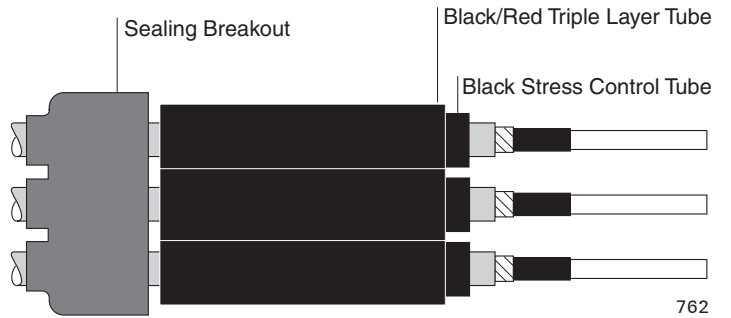
360

22. Position splice components

Abrade insulation, if necessary, to remove imbedded semi-con. Clean Poly cable jackets for 30" (760mm).

Place sealing breakout over the Poly cables with the fingers pointing away from the splice center.

Place one set of nested tubes over each clean Poly cable.

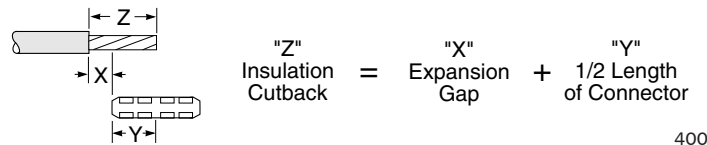


762

23. Remove insulation

Refer to Table 5 and cutback the insulation as shown.

Note: If crimping, make sure connector has center oil stop.



400

Table 5

Kit	Max Length	Max O.D.	Expansion Gap "X"
HVS-T-2582E	5-1/2" (140mm)	1.15" (29mm)	1/4" (5mm)
HVS-T-2583E	7" (178mm)	1.35" (34mm)	1/2" (10mm)
HVS-T-2584E	8" (205mm)	1.85" (47mm)	1/2" (10mm)

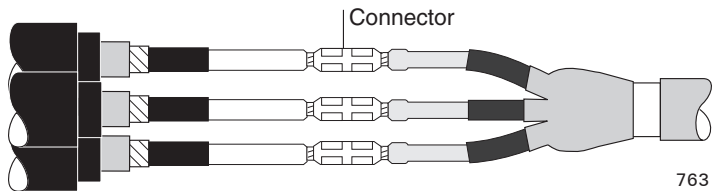
24. Install connectors

Note: Tyco Electronics recommends the use of connectors with rounded or "tapered" ends, but they are not required.

If soldering, protect OBT by wrapping it with cotton or glass fiber tape

After installation, deburr connections.

Note: A Poly tape shield to PILC splice is shown in this instruction as an example. Any cable combination discussed earlier can be used.

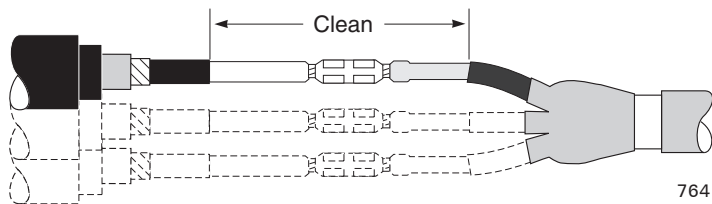


763

25. Clean connector area

Complete Steps 25-29 working on one phase at a time.

Using an oil-free solvent, clean the insulation as shown, paying particular attention to the OBT/insulation surface.



764

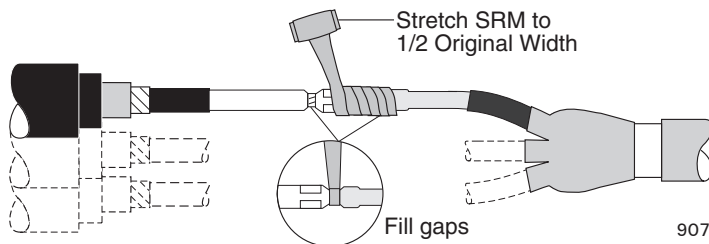
26. Apply SRM over connector

Remove backing from one side of a long strip of SRM. Roll the SRM and remaining backing strip into a convenient size. Removing the remaining backing strip, tightly wrap the SRM around the connector and exposed conductor. Be sure to fill the gaps and low spots around the connector.

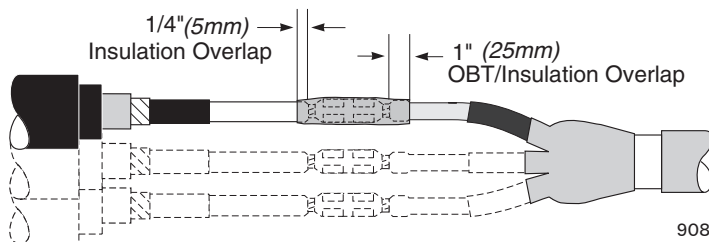
Continue to wrap the SRM onto the insulation as shown.

Make sure the area between the connector end and the end of the insulation is filled in up to the top of the insulation.

Note: If the connector diameter is larger than the insulation diameter, apply two half-lapped layers of SRM over the entire connector. Discard any excess SRM (long strips).



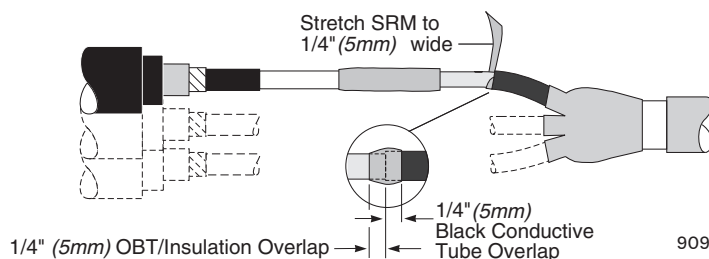
907



908

27. Apply SRM at black conductive tube step

Remove backings from the short angle-cut piece of SRM. Place tip of SRM at black conductive tube step and tightly wrap to fill the step. Overlap black conductive tube and OBT/Insulation and taper down to meet OBT/Insulation as shown.



909

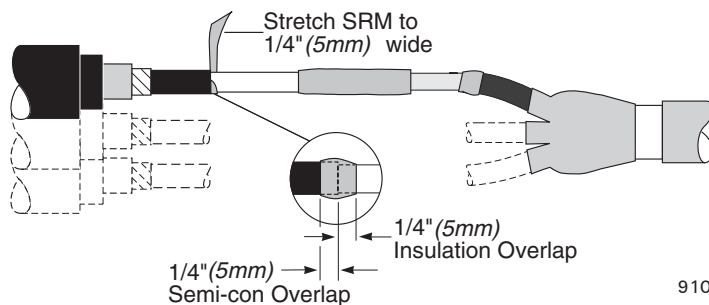
28. Apply SRM at semi-con cutback; apply Silicone Grease (SG)

Remove backings from the short angle-cut piece of SRM. Place tip of SRM at semi-con step and tightly wrap to fill the step. Overlap semi-con and insulation and taper down to meet insulation as shown. Apply a thin film of silicon grease over the applied SRM.

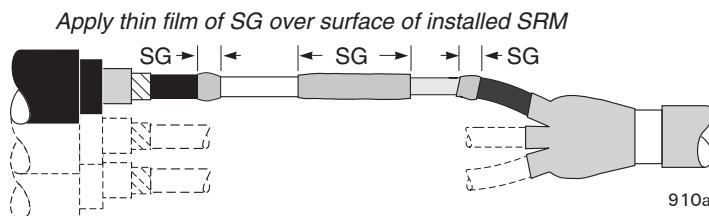
Note: If using UniShield* cable, apply SRM as shown to fill conductive jacket step.

Snip open the end of the SG ampule and apply a thin film of compound on the SRM over the connector and semi-con steps.

*UniShield is a trademark of general Cable Technologies Corporation



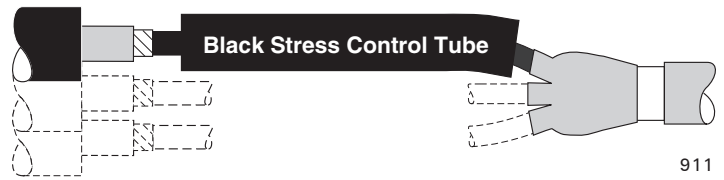
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29. Position black stress control tube

Center black stress control tube over the completed connector area. Be sure to equally overlap the Poly cable semi-con and the PILC cable black conductive tube.



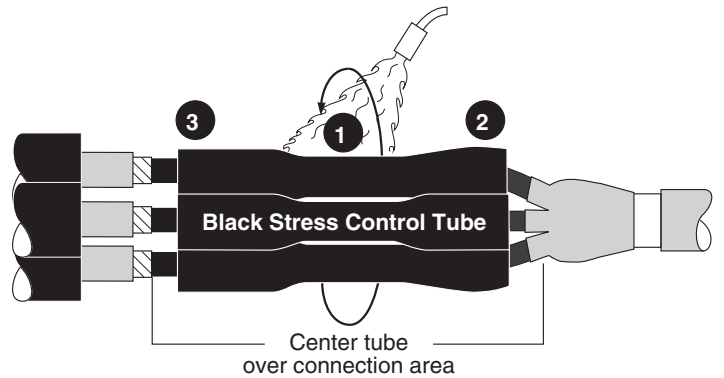
Repeat Steps 25-29 for the remaining phases.

30. Check position of black stress control tubes; shrink all 3 in place at the same time

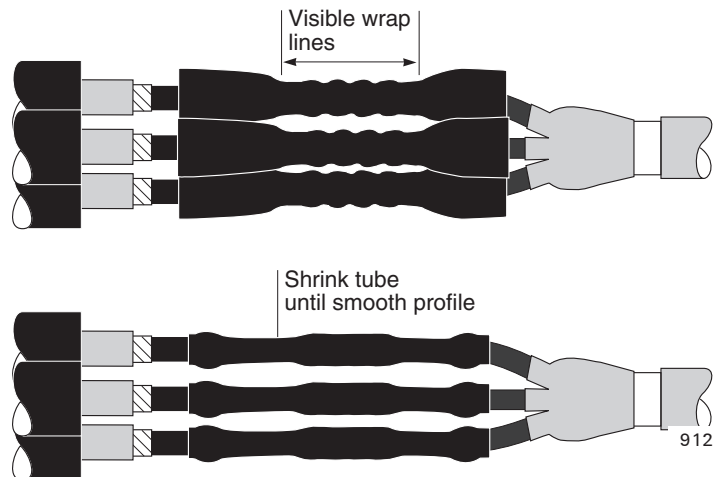
Make sure each tube is centered over the connection area, equally overlapping the semi-con (Poly side) and black conductive tube (PILC side). Shrink all three tubes in place at the same time.

Begin shrinking at center of tubes (1), working torch with a smooth brushing motion around the tubes. After center portions shrink, work torch as before toward one end (2), then to the opposite end (3).

Note: Do not point the flame at the cable semi-con.



The rings from the SRM wraps may be visible as the tubing is shrunk.



Post heat the connector area until the tube surface is smooth and the underlying SRM wraps are no longer visible.

31. Apply red sealant

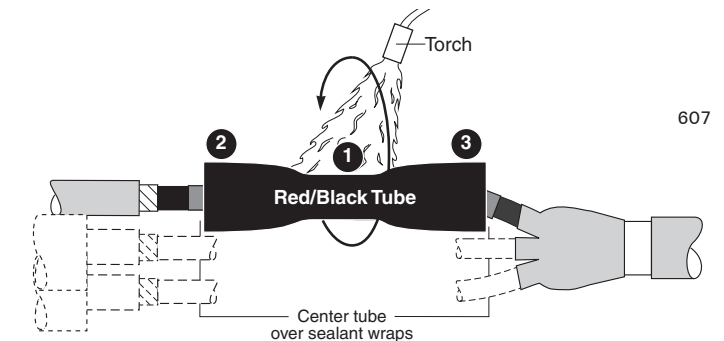
Remove backing from red sealant. Using light tension, wrap sealant over the cable, butted against the black stress control tube as shown. Build the sealant to the level of the black stress control tube.



32. Position black/red triple layer tubes: Shrink all 3 in place at the same time

Center the black/red tubes over the sealant wraps (there should be about 1" of sealant exposed from the ends of the tubes). Begin shrinking the center (1) of the tubes, working the torch around all sides of the tubes. After the center portion shrinks, work toward one end (2) then to the opposite end (3).

Do not point the flame at the cable semi-con.



If External Grounding or Shield Interrupting

Refer to the Tyco Electronics HVS-EG, "Guide for External Grounding and Shield Interrupting of Power Cable Splices" for modifications to these instructions.

33. Install ground on single core side of splice

Choose the appropriate cable type (Choice 1-5) and follow the directions given to ground each phase.

Note: Use smaller spring clamps on 1/C cables. The 2" spring clamp is for use on the 3/C PILC cable.

CHOICE 1

If Unjacketed Concentric Neutral Cable

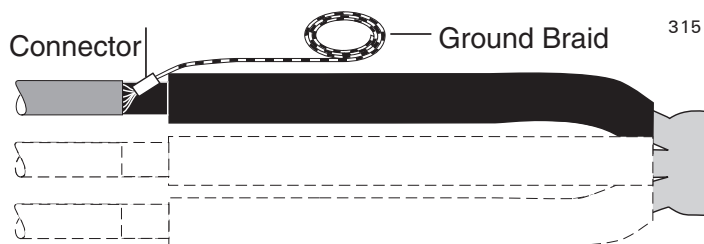
Go to Step 47, page 16.

CHOICE 2

If Drain Wire or UniShield Cable

Pigtail the shield wires and crimp on to the ground braid using the connectors provided.

Go to Step 34 on page 12.



CHOICE 3

If Metallic Tape, Flat Strap Neutral, or LC Shield Cable

1/C SIDE ONLY

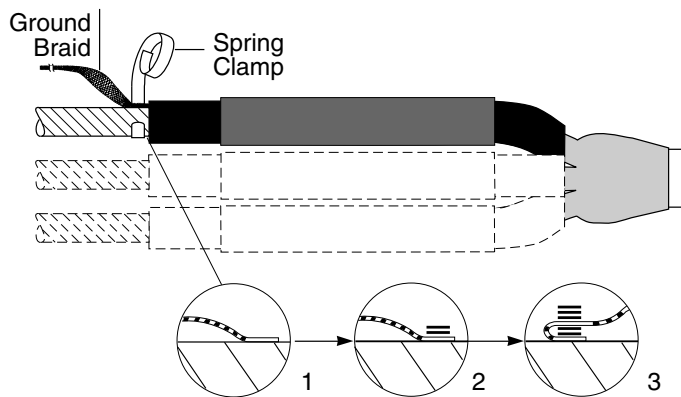
(1) Flare one end of the ground braid and place it onto the metallic tape, butted up to the red sealant. (2) Attach the braid to the shield by placing two wraps of the spring clamp over the braid. (3) Fold the braid back over the spring clamp wraps. Continue to wrap the remaining clamp over the braid. Tighten clamp by twisting it in the direction it is wrapped and secure with copper foil tape provided.

Repeat for remaining phases.

Discard drain wire connectors.

Note: Two braids and two spring clamps are recommended for LC and Flat strap cables. Wrap 2" (50mm) wide mesh around the flat straps similar to the lead sheath. Requires 1" (25mm) longer jacket cut to expose more shielding.

Go to Step 34 on page 12.



CHOICE 4

If Lead Sheath Cable

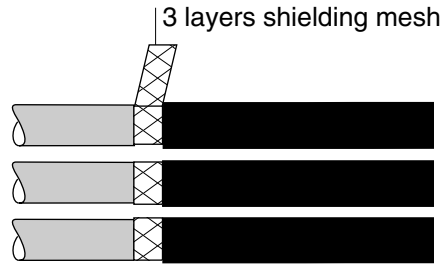
1/C SIDE ONLY

Wrap three layers of 2" (50mm) wide copper mesh around the lead sheath as shown. Tie off with a half-hitch.

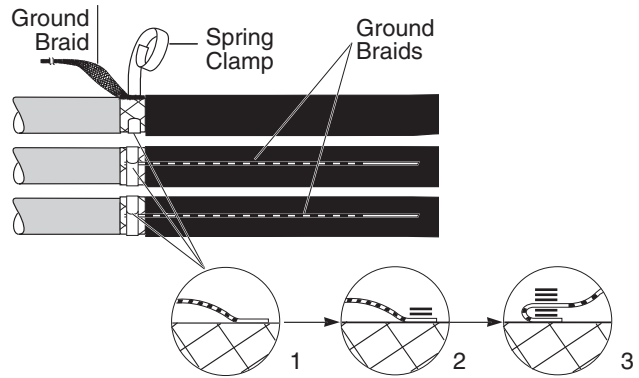
(1) Flare one end of the ground braid and place it onto the metallic tape, butted up to the red sealant. (2) Attach the braid to the shield by placing two wraps of the spring clamp over the braid. (3) Fold the braid back over the spring clamp wraps. Continue to wrap the remaining clamp wraps. Tighten clamp by twisting it in the direction it is wrapped and secure with copper foil tape provided.

Repeat for remaining phases.

Go to Step 34 on page 12.



319a



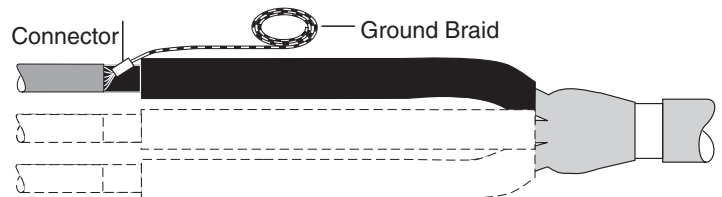
319b

CHOICE 5

If Jacketed Concentric Neutral Cable

Pigtail the neutral wires and crimp or solder to the ground braid.

Go to Step 34 on page 12.



*Connector not supplied in kit.

315

34. Install ground on 3/C PILC side of splice

Choose the application (Choice 1 below or Choice 2 on page 13) and follow the directions given.

CHOICE 1

35. Install ground braids without external grounding

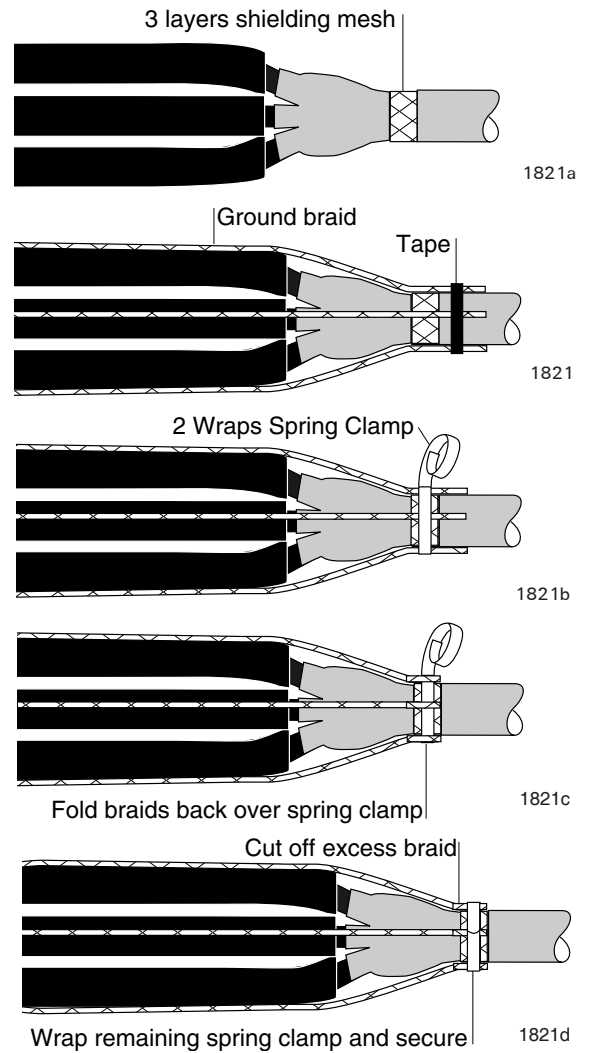
Wrap three layers of 2" (50mm) wide copper mesh around the lead sheath on the 3/C side. Tie off with a half-hitch.

Lay the three braids across the joint evenly spaced around the joint circumference so that the braids overlap the mesh and temporarily tape the braids in position.

Make two wraps of the LARGE spring clamp over the braids and mesh.

Remove the temporary tape.

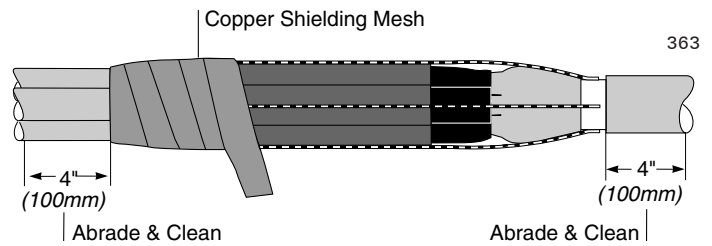
Fold back the overlapping braids over the spring clamp and wrap the remaining spring clamp. Tighten and secure the spring clamp with copper foil tape provided. Cut off excess braids.



36. Apply shielding mesh

Starting over the ground connections on the extruded dielectric side of the splice, wrap one half-lapped layer of 2" (50mm) wide shielding mesh across the splice and to the PILC cable lead sheath and tie off with a slip knot.

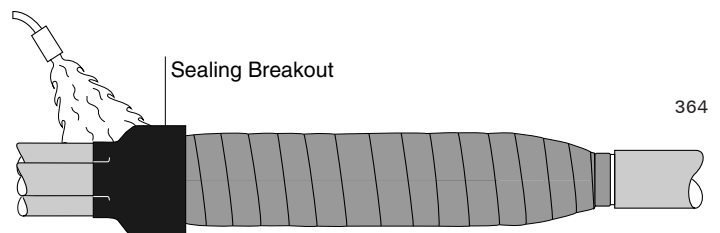
Abrade and solvent clean cable jackets (or lead sheath) as shown using an approved solvent.



37. Position non-conductive sealing breakout; shrink in place

Make sure that the full length of the fingers of the breakout are over the extruded dielectric cable jackets with the body extending over the splices.

Shrink in place starting at the fingers and working toward the splice center.



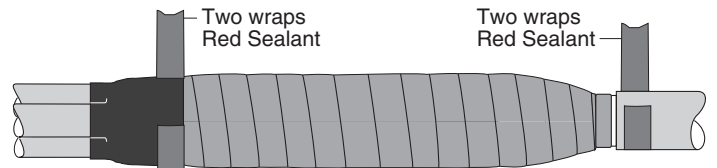
38. Apply red sealant

Allow breakout to cool sufficiently to touch before proceeding.

Apply two wraps of red sealant over the body of the breakout as shown.

Apply two wraps of red sealant over the PILC outer sheath as shown.

Skip to Step 44, Page 15.



CHOICE 2

39. Install ground braids with external grounding

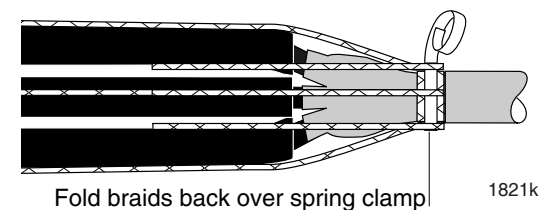
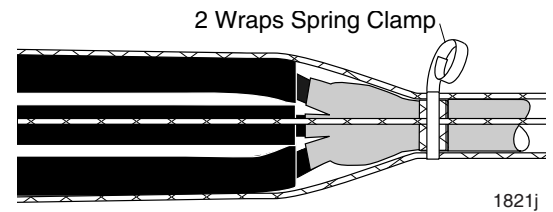
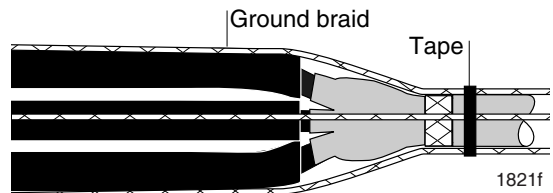
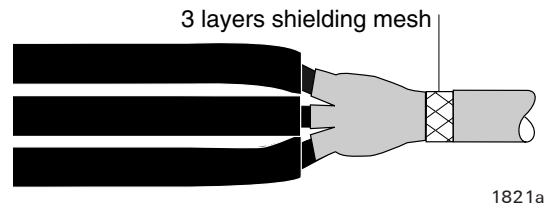
Wrap three layers of 2.0" (50mm) wide copper mesh around the lead sheath on 3/C side of the joint. Tie off with a half-hitch.

Lay the three braids across the joint evenly spaced around the joint circumference so that the braids overlap the mesh by about three inches on Side 1. Temporarily tape the braids in position.

Make two wraps of LARGE spring clamp over the braids and mesh on 3/C side.

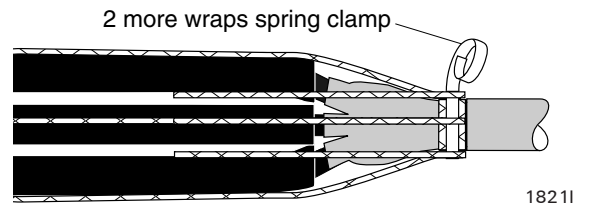
Remove the temporary tape and fold back the braids back over the spring clamp towards the splice.

Go to Step 40 on Page 14.

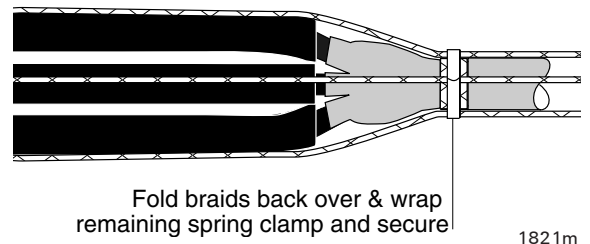


40. Install ground clamp, solder block braids, apply sealant

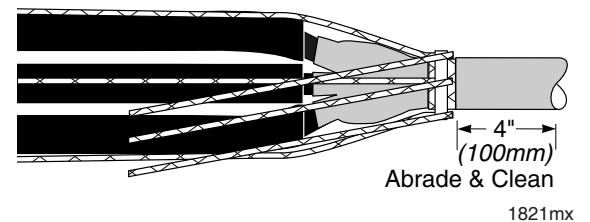
Apply 2 more wraps of the spring clamp.



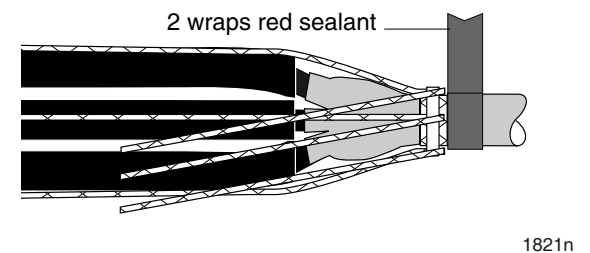
Fold back the braids back over the spring clamp and wrap the remaining spring clamp. Tighten and secure the spring clamp with copper foil tape provided.



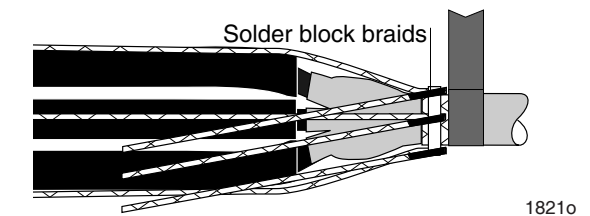
Solvent clean and abrade cable jacket for 4" (100mm) as shown.



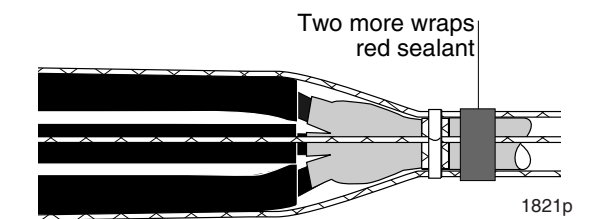
Apply two wraps of thick red sealant onto the cable jacket as shown.



IMPORTANT: Solder block the braids where they will be pressed into the previously applied red sealant.



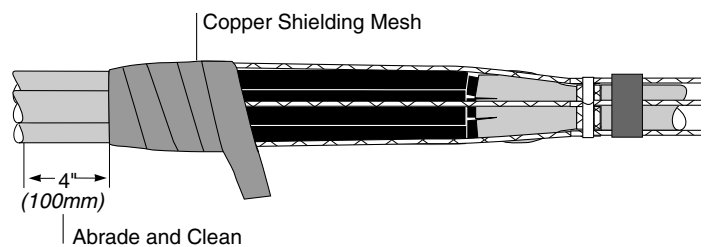
Fold the braids back over and press into the red sealant. Apply two more wraps of red sealant on top of the braids and the previously applied layer of sealant for a total of 4 wraps.



41. Apply shielding mesh

Starting over the ground connections on the extruded dielectric side of the splice, wrap one half-lapped layer of 2" (50mm) wide shielding mesh across the splice and tie off with a slip knot to the PILC cable lead sheath.

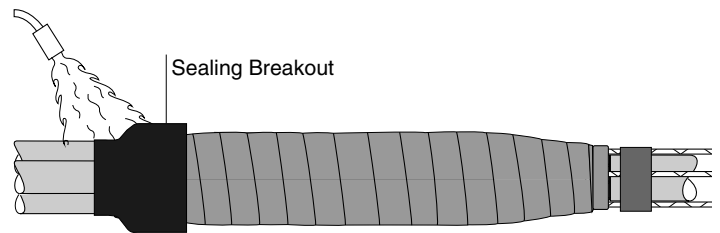
Abrade and solvent clean cable jackets (or lead sheath) as shown using an approved solvent.



42. Position non-conductive sealing breakout; shrink in place

Make sure that the full length of the fingers of the breakout are over the extruded dielectric cable jackets with the body extending over the splices.

Shrink in place starting at the fingers and working toward the splice center.

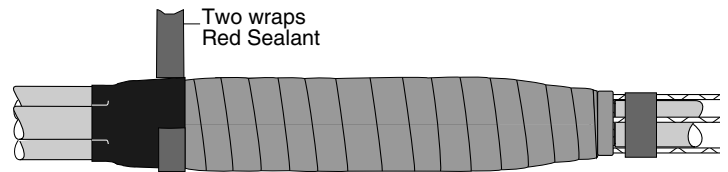


364x

43. Apply red sealant

Allow breakout to cool sufficiently to touch before proceeding.

Apply two wraps of red sealant over the body of the breakout as shown.

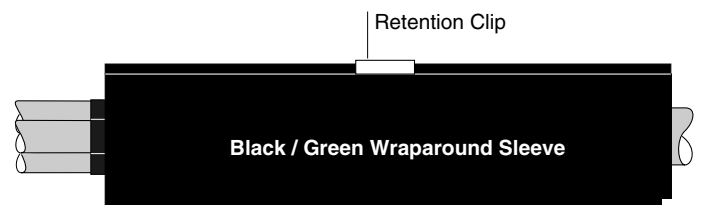


365x

44. Position wraparound sleeve

Remove or tape over all sharp points to prevent puncture of wraparound sleeve.

Remove backing from the wrap-around sealing sleeve and center sleeve over splice. Slide metal retention clip onto butted rails.



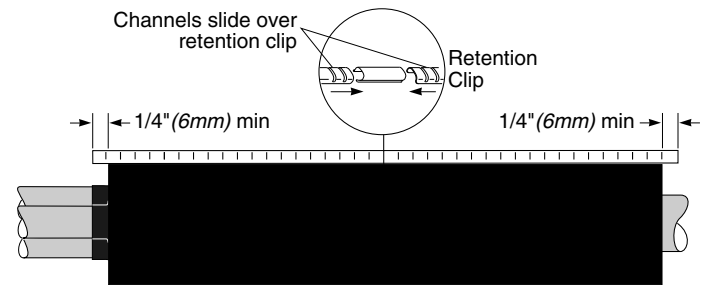
366

45. Install channels

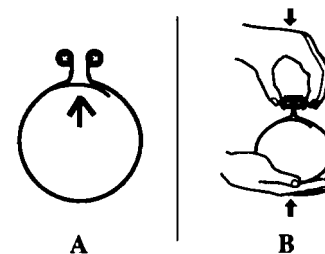
Slide the channels toward the center from each end of the sleeve and over the retention clip. A minimum of 1/4" (5mm) of channel should be extended beyond the edges of the sleeve.

If channels slide on easily go to step 46. If channel fit seems tight, continue with next paragraph.

As shown in illustration A, make sure flap is not pinched between the rails. Push the sleeve up from the bottom and down from the top while sliding on channel as shown in illustration B. The idea is to flatten the rails together to prevent the channels from binding.



367



46. Shrink wraparound sleeve

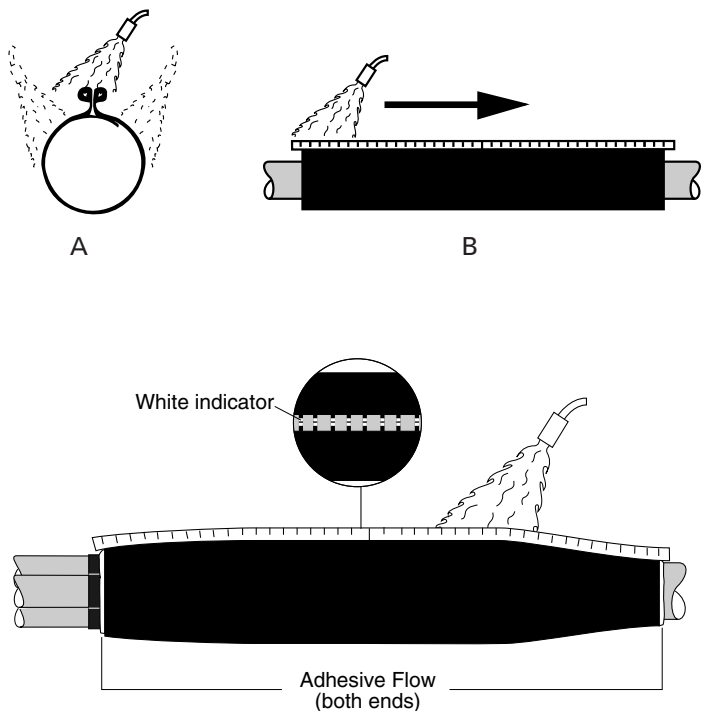
Preheat evenly along both sides of the rail/channel area until this area begins to shrink. To achieve uniform heating, move the flame back and forth from one side of the channel to the other as shown in illustration "A" while moving flame along the entire length of the channel as shown in illustration "B" until the sleeve starts to shrink. This technique will assure a properly preheated rail and channel area.

Begin shrinking at the center of the sleeve and work toward each end. Apply heat until the sleeve is fully shrunk and the heat-sensitive green paint is completely converted to black. Continue heating the rail/channel area for another 5 seconds per foot. A white line should be visible in the channel gaps indicating sufficient heating.

Note: Green heat-sensitive paint will turn black as sleeve shrinks in place.

This completes the splice.

Note: Allow to cool before moving or placing in service.



368

Unjacketed Concentric Neutral Cable Only

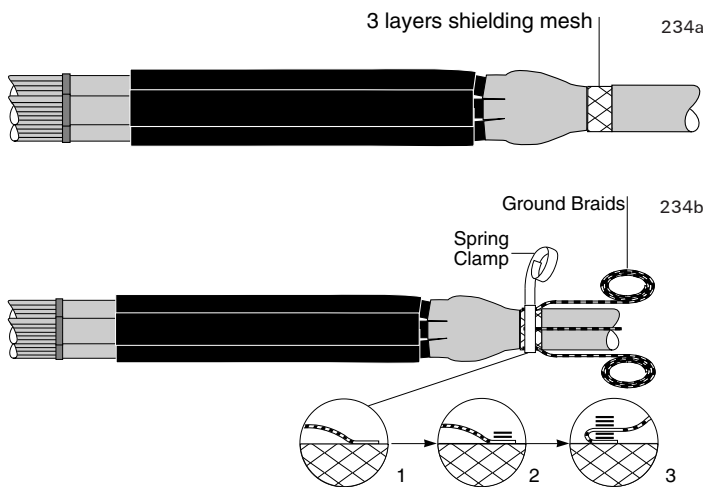
47. Apply mesh; install ground braids

Wrap three layers of 1" (25mm) wide copper mesh around the lead sheath on the 3/C side of the joint. Tie off with a half-hitch

Lay the three braids over the splice evenly spaced around the joint circumference so that the braids overlap the mesh and temporarily tape the braids in position.

Make two wraps of the LARGE spring clamp over the braids and mesh.

Fold back the overlapping braids over the spring clamp and wrap the remaining spring clamp. Tighten and secure the spring clamp. Cut off excess braids.



48. Solder block ground braids

To prevent the ingress of moisture, solder-block the ground braids for 2" (50mm) from the PILC jacket cut measurement (or equivalent measurement if unjacketed).



437

49. Clean PILC cable jacket

Solvent clean and abrade the cable jacket as shown.



438

50. Apply red sealant

Apply two layers of red sealant onto the cable jacket as shown.



51. Apply red sealant

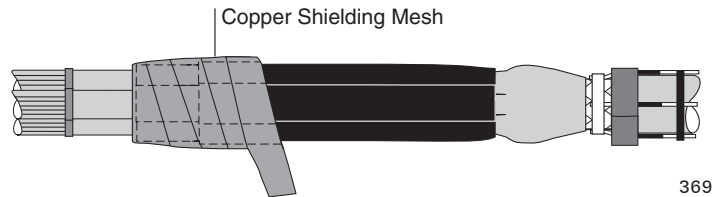
Bring the braids forward and temporarily tape them to the PILC cable to hold them in position.

Press the braids onto the sealant. Apply two layers of sealant directly over the braids and the first layer of sealant.



52. Apply shield mesh

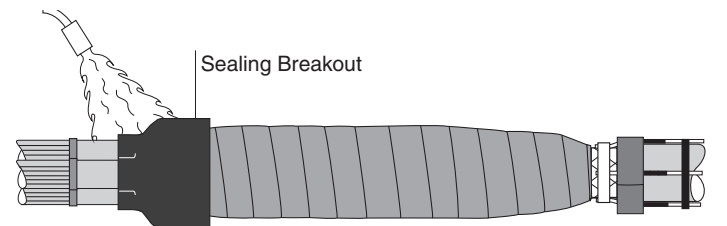
Starting at the poly cable semi-con, wrap one half-lapped layer of 2" (50mm) wide shielding mesh across the splice and solder to the PILC cable lead sheath.



53. Position non-conductive sealing breakout; shrink in place

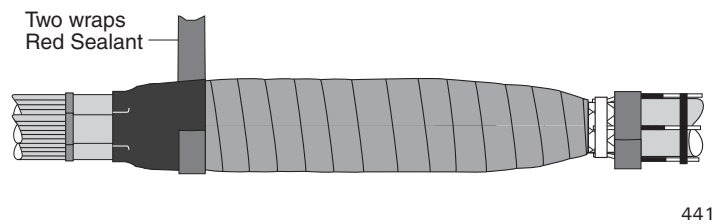
Position the breakout on the poly cable semi-con, with the fingers clear of the neutral wires and the body over the three splices.

Shrink in place starting with the fingers and working toward the splice center.



54. Apply red sealant

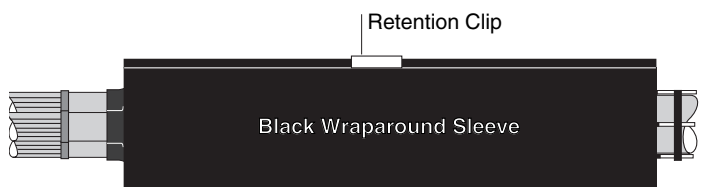
When the breakout has cooled sufficiently to touch, apply two wraps of red sealant to the body of the breakout.



55. Position wraparound sleeve

Remove or tape over all sharp points to prevent puncture of wraparound sleeve.

Remove backing from the wrap-around sealing sleeve and center sleeve over splice. Slide metal retention clip onto butted rails.

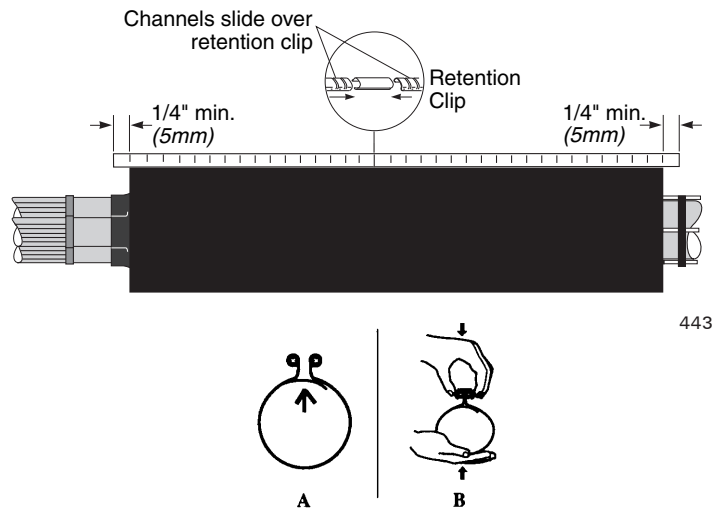


56. Install channels

Slide the channels toward the center from each end of the sleeve and over the retention clip. A minimum of 1/4" (5mm) of channel should be extended beyond the edges of the sleeve.

If channels slide on easily go to step 57. If channel fit seems tight, continue with next paragraph.

As shown in illustration A, make sure flap is not pinched between the rails. Push the sleeve up from the bottom and down from the top while sliding on channel as shown in illustration B. The idea is to flatten the rails together to prevent the channels from binding.



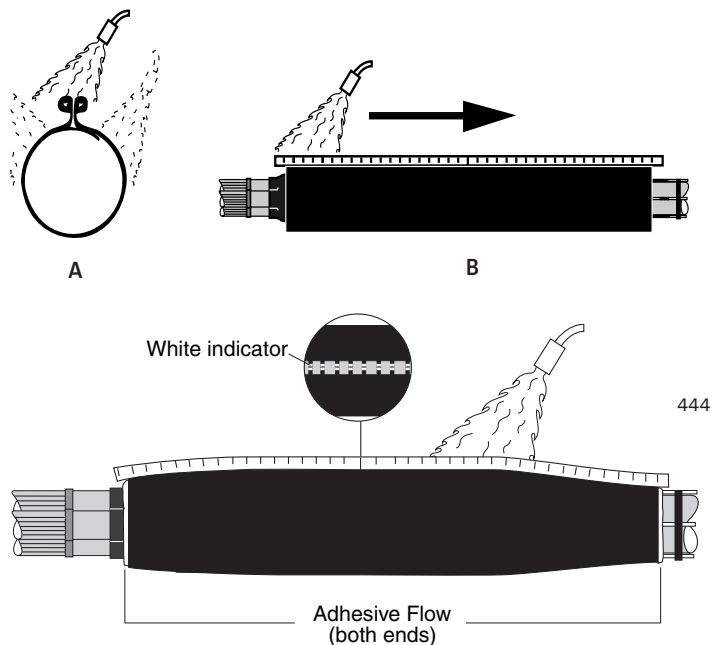
443

57. Shrink wraparound sleeve

Preheat evenly along both sides of the rail/channel area until this area begins to shrink. To achieve uniform heating, move the flame back and forth from one side of the channel to the other as shown in illustration "A" while moving flame along the entire length of the channel as shown in illustration "B" until the sleeve starts to shrink. This technique will assure a properly preheated rail and channel area.

Begin shrinking at the center of the sleeve and work toward each end. Apply heat until the sleeve is fully shrunk and the heat-sensitive green paint is completely converted to black. Continue heating the rail/channel area for another 5 seconds per foot. A white line should be visible in the channel gaps indicating sufficient heating.

Note: Green heat-sensitive paint will turn black as sleeve shrinks in place.



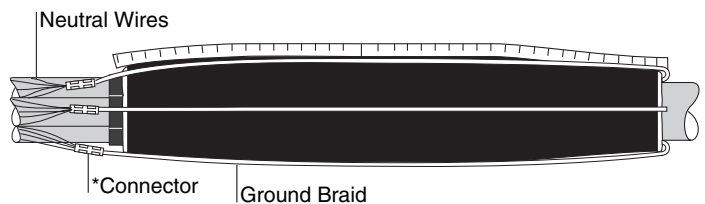
444

58. Connect ground braids

Fold braids back over the splice and crimp or solder to the concentric neutral wires.

This completes the splice.

Note: Allow to cool before moving or placing in service.



*Not supplied in kit.

445

The Information contained in these installation instructions is for use only by installers trained to make electrical power installations and is intended to describe the correct method of installation for this product. However, Tyco Electronics Corporation has no control over the field conditions which influence product installation. It is the user's responsibility to determine the suitability of the installation method in the user's field conditions. Tyco Electronics' only obligations are those in Tyco Electronics' standard Conditions of Sale for this product and in no case will Tyco Electronics be liable for any other incidental, indirect or consequential damages arising from the use or misuse of the products.

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