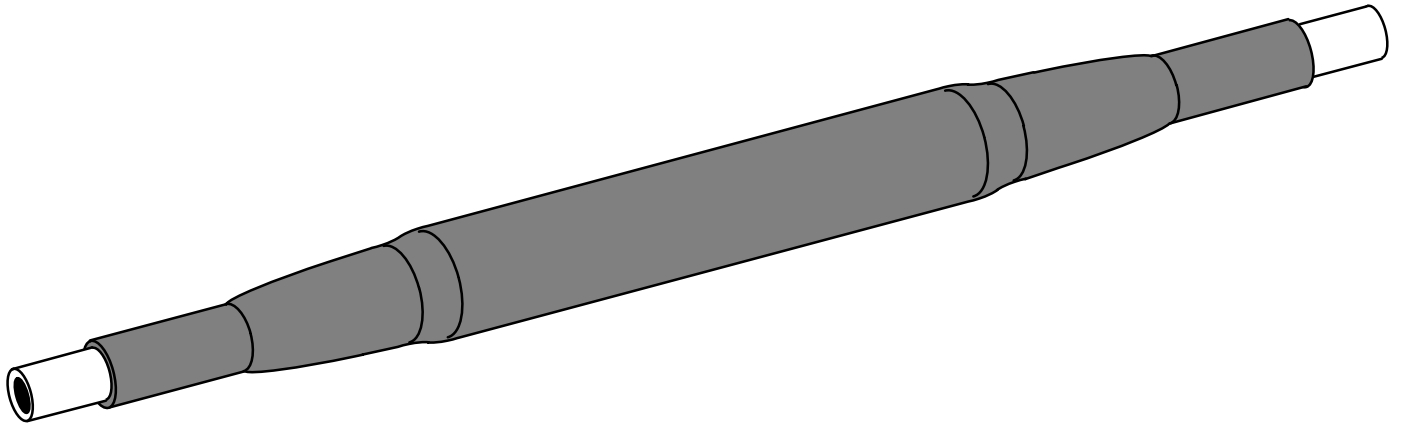


3M QS 1000



Kit no.	Diameter over Cable Jacket max (mm)	Diameter over Insulation E (mm)	Cross Section (mm ²)		Diameter over Connector (mm)	Connector Length max (mm)
			6/10 kV	8,7/15 kV		
92-AG611-1	39	17.7 – 26.0	70 – 150	50 – 150	14.2 – 28.0	135
92-AG621-1	46	22.3 – 33.2	185 – 240	150 – 240	18.0 – 33.2	145
92-AG631-1	56	28.4 – 42.0	300 – 400	300 – 400	23.3 – 42.0	220

3M Laboratories (Europe)
Branch of 3M Deutschland GmbH

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ALL STATEMENTS, TECHNICAL INFORMATION AND RECOMMENDATIONS CONTAINED HEREIN ARE BASED ON TESTS WE BELIEVE TO BE RELIABLE HOWEVER, SINCE THE CONDITION OF USE AND THE APPLICATION ARE BEYOND OUR CONTROL THE PURCHASER IS RESPONSIBLE FOR THE PERFORMANCE OF THE SPLICES AND TERMINATIONS MADE IN CONNECTION WITH THE USE OF DATA OR SUGGESTIONS HEREIN.

3M QS 1000
INLINE SPLICE
92-AG611-1 up to 92-AG631-1
WITH PST SHRINK TUBE
SUITABLE FOR POLYMERIC SINGLE CORE CABLES
WITH COPPER WIRE SCREEN
6/10 (12) kV and 8.7/15 (17.5) kV
acc to VDE 0276-620 (IEC 60502)

ID-0212-2334-5

1. ISSUE DATE: 29.09.97

LANGUAGE: English

5. CHANGE DATE: 21.06.02

DRAWN: M. Hubrich

6. CHANGE DATE: 05.02.03

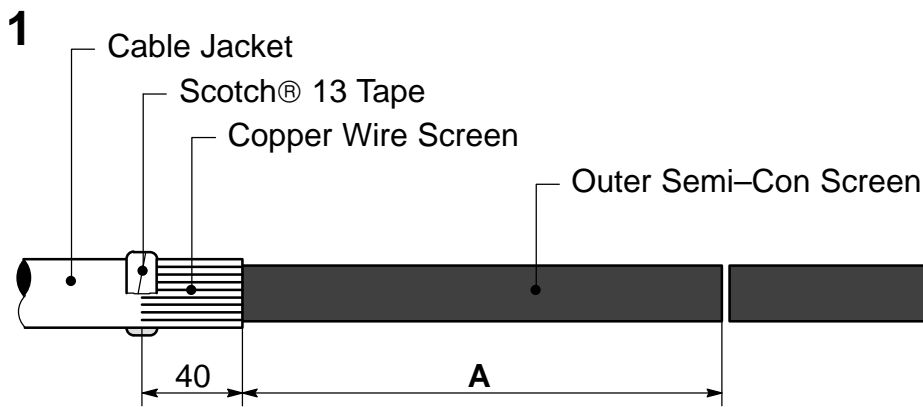
CHECKED: W. Röhling

7. CHANGE DATE: 19.03.03

8. CHANGE DATE:

3M ELECTRICAL PRODUCTS

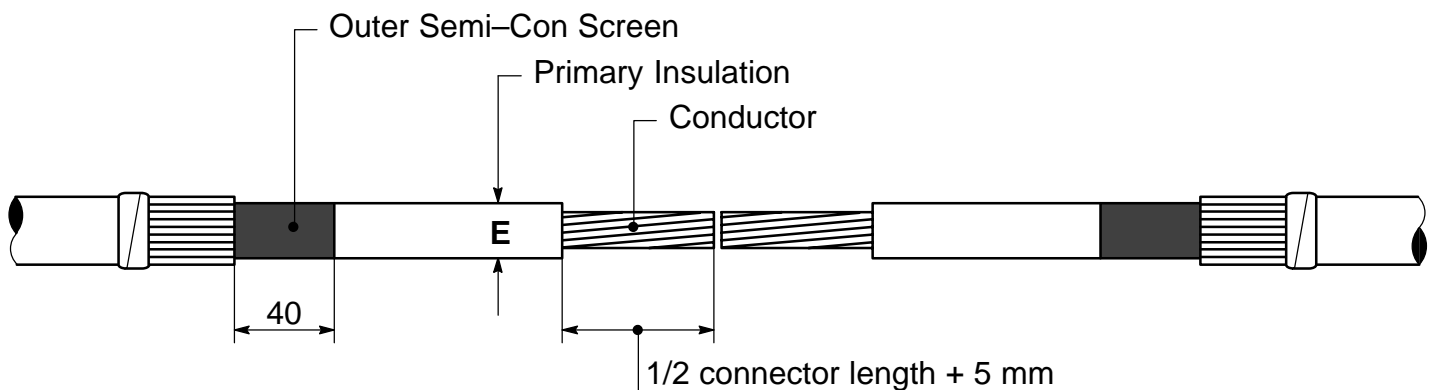
XE 0091-2334-2



Kit no.	A (mm)
92-AG611-1	170
92-AG621-1	170
92-AG631-1	210

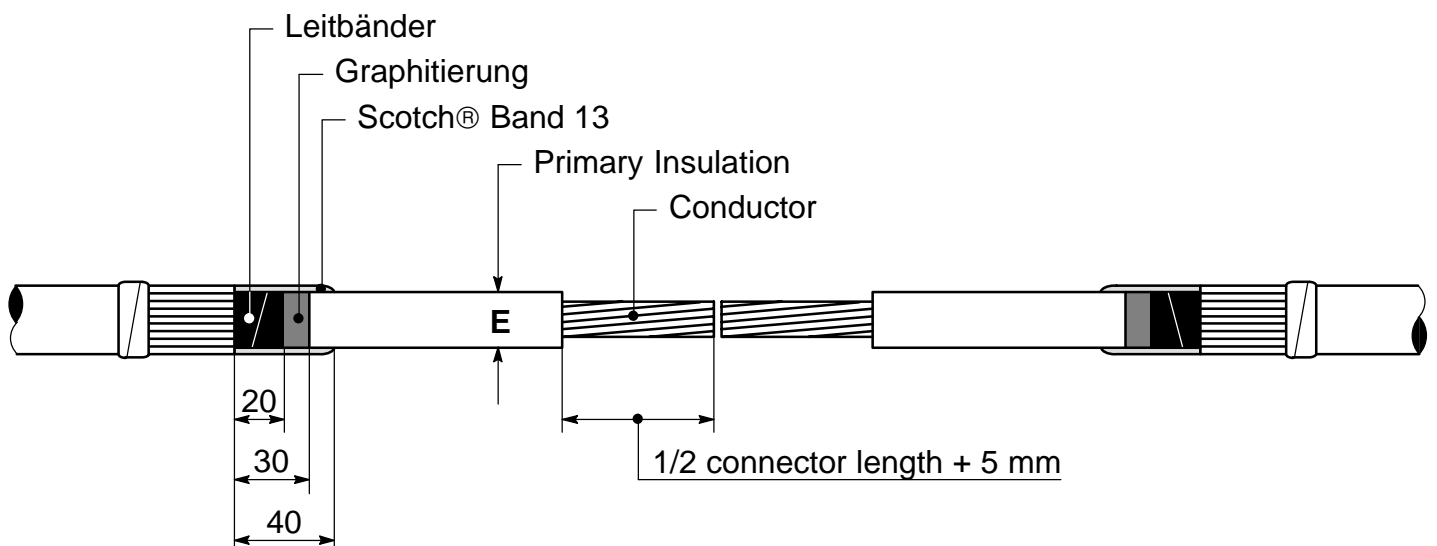
- 1.1 Remove the cable jacket acc to dimension **A**.
- 1.2 Bend the copper wire screen back onto the cable jacket, cut the wires for 40 mm and fix them with two layers of Scotch® 13 tape.

2 Cable with Extruded Semi-Conductive Screen

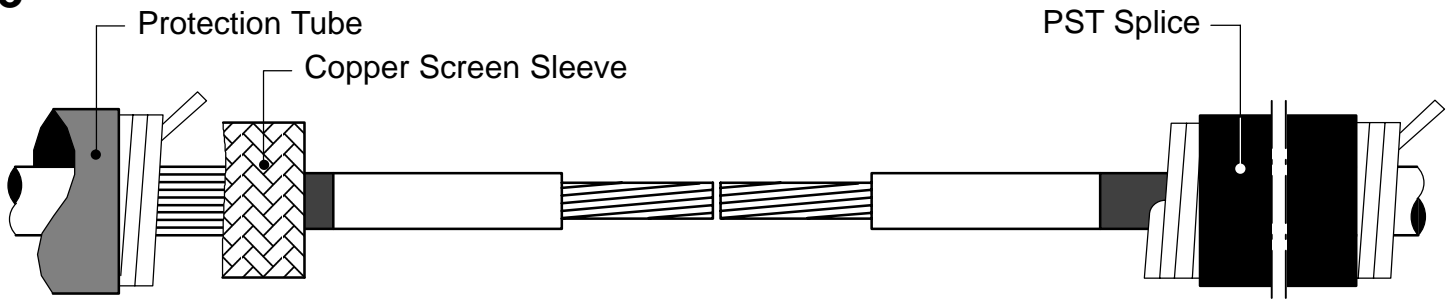


- 2.1 Remove cotton tapes.
- 2.2 Remove outer semi-conductive screen leaving 40 mm exposed.
- 2.3 Remove primary insulation for $\frac{1}{2}$ connector length + 5 mm.

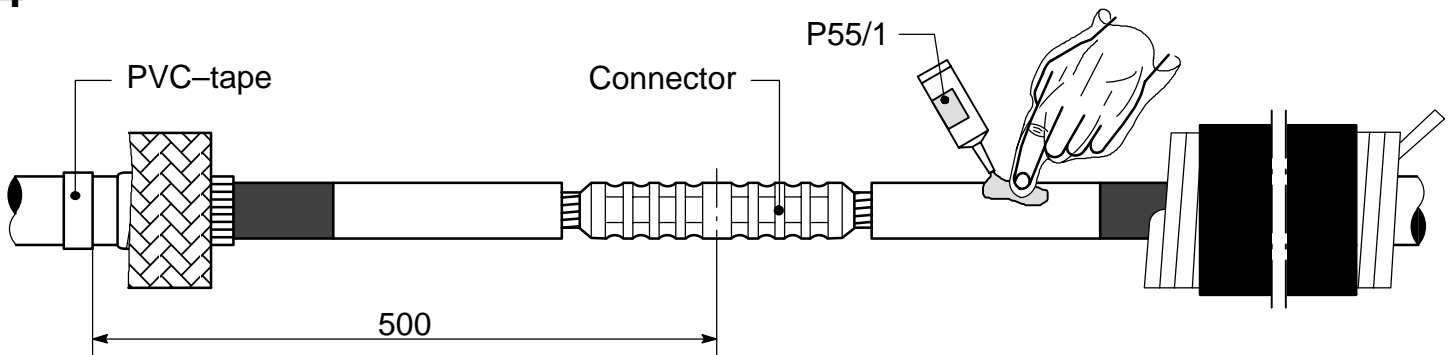
Cable with Semi-Conductive Tapes and Graphite Layer



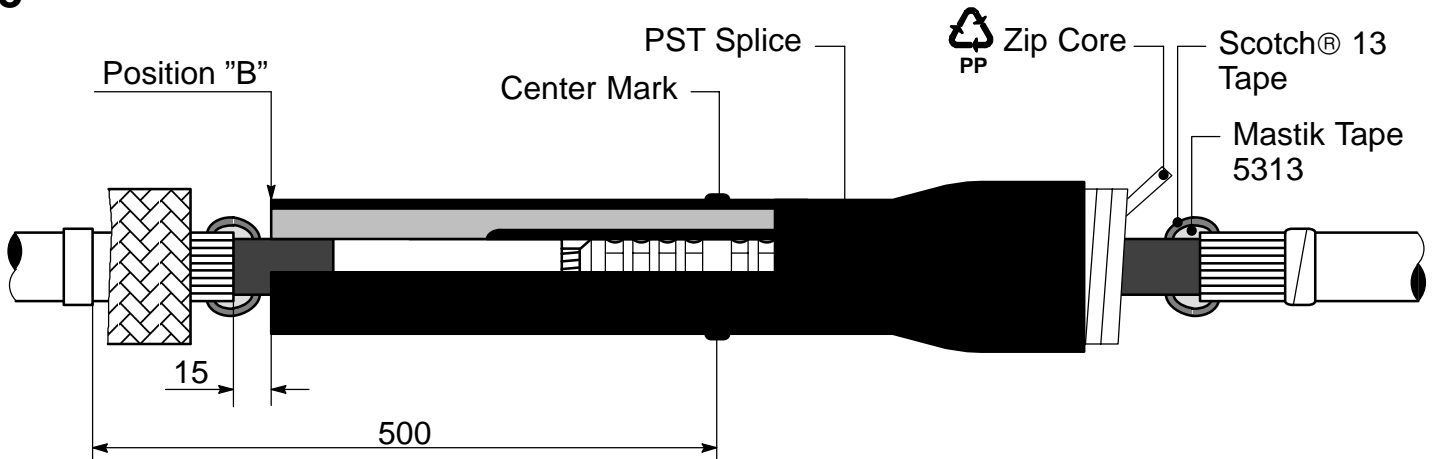
- 2.1 Remove semi-conductive tapes leaving 20 mm in front of the cable jacket.
- 2.2 Remove graphite layer leaving 30 mm in front of the cable jacket.
- 2.3 Apply one half-lapped layer of Scotch® 13 tape from the semi-conductive tapes onto the primary insulation and back again.
- 2.4 Remove primary insulation for $\frac{1}{2}$ connector length + 5 mm.

3

- 3.1 Position the protection tube, copper screen sleeve and the PST splice onto the cable ends.

4

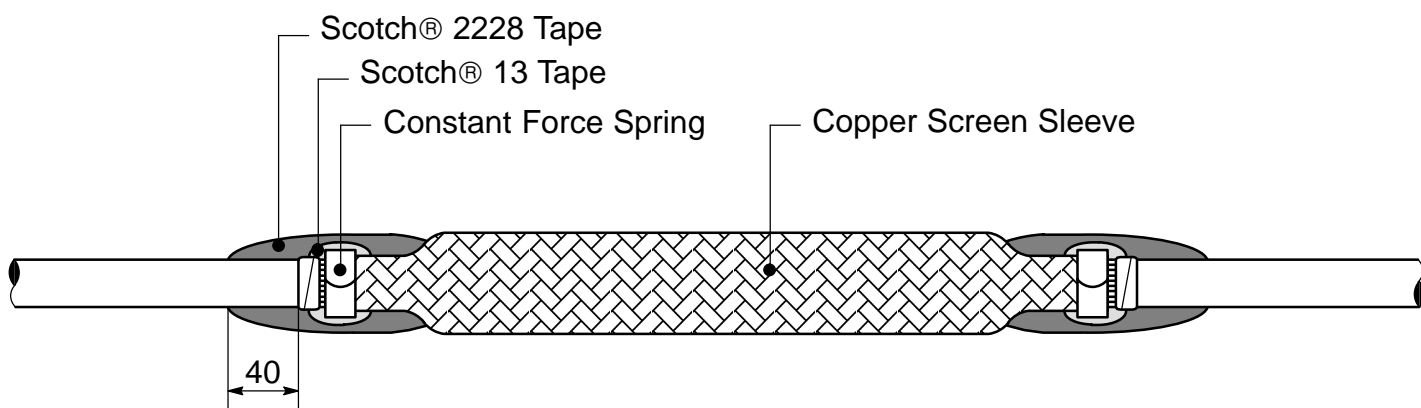
- 4.1 Crimp the connector, remove the excess grease, smooth and clean the connector.
 4.2 Place a PVC-tape on the cable jacket at a distance of 500 mm to the connector center.
 4.3 Apply a liberal amount of P55/1 over the end of the semi-conductive layer, onto the exposed cable insulation and connector using the plastic glove provided.

5

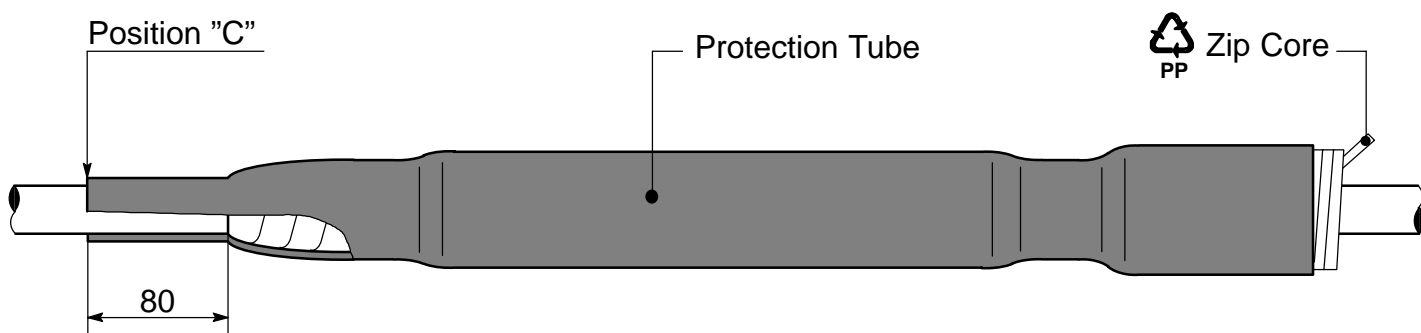
- 5.1 Slide the PST splice over the connection up to position "B".
 5.2 Shrink the PST splice into position by pulling out and unwinding the core in counter clockwise direction.
 5.3 After shrinking ensure the symmetrical position of splice body acc. to gauge 500 mm. Otherwise make correction by displacement.
 5.4 Apply in front of each cable jacket one layer of Mastik tape 5313. Cover the mastic with two layers of Scotch® 13 tape.

6

Kit no.	Min Diameter over Scotch® 2228 Tape (mm)
92-AG611-1	32
92-AG621-1	34
92-AG631-1	36



- 6.1 Slide the copper screen sleeve over the splice and fix it by means of a constant force spring on the metallic screen. Cut off the remaining wires of the sleeve.
- 6.2 Overwrap the constant force springs with two half-lapped layers of Scotch® 13 tape as shown.
- 6.3 Wrap the Scotch® 2228 tape over the Scotch® 13 tape, cable jacket and copper screen sleeve acc illustration. Ensure min diameter over Scotch® 2228 tape.

7

- 7.1 Slide the protection tube over the connection up to position "C" and pull out the plastic spiral. The tube then begins to shrink from that point over the splice body.