

FIG.1

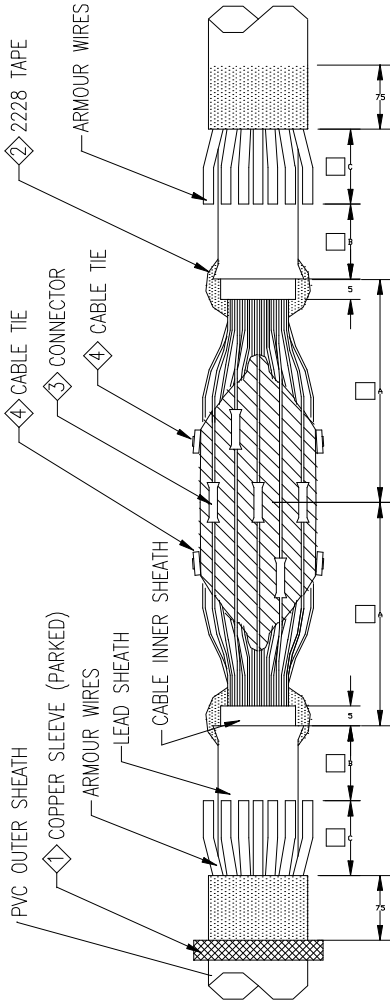


FIG.2

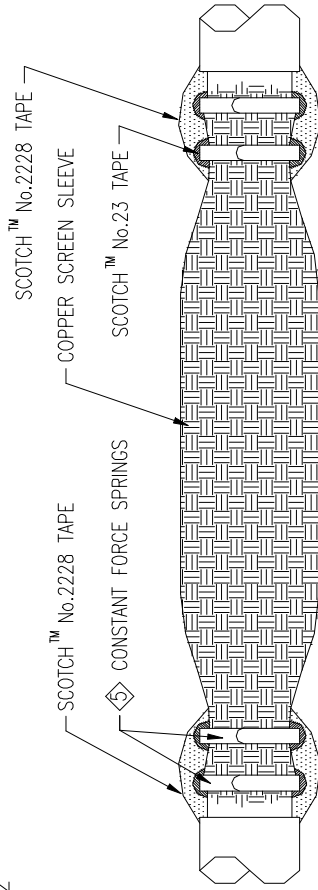
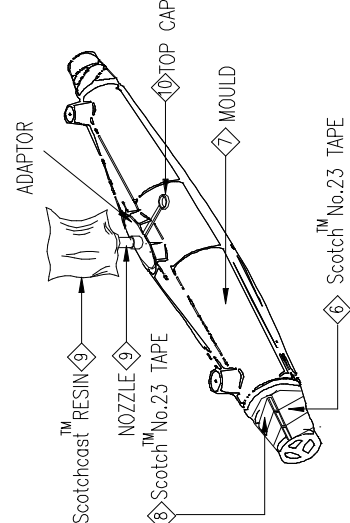


FIG.3



INSTALLATION SEQUENCE

FIG.1 CABLE PREPARATION

- 1.1 STRAIGHTEN & SET UP THE CABLES AT THE JOINT POSITION. SLIDE THE COPPER SLEEVE OVER ONE SIDE OF THE CABLES & PARK TO ONE SIDE.
- 1.2 MARK THE CENTRE POSITION OF THE JOINT ON BOTH CABLES.
- 1.3 CAREFULLY REMOVE THE SHEATHS OF THE CABLES AT DISTANCE [A] + [B] + [C] FROM THE CENTRE POSITION OF THE JOINT. THE SHEATHS OF THE CABLES FOR A DISTANCE OF 75mm BEYOND DIMENSION [A].
- 1.4 APPLY TEMPORARY WIRE BINDERS AROUND THE OUTER SHEATH CLOSE TO THE TERMINATION OF THE OUTER SHEATH ON BOTH CABLES.
- 1.5 REMOVE THE ARMOUR WIRE UP TO A DISTANCE [C] IN FRONT OF THE CABLE SHEATHS.
- 1.6 REMOVE THE INNER CORROSION PROTECTION AND/OR BEDDING FROM THE LEAD SHEATH.
- 1.7 CLEAN ALL DIRT, OIL & GREASE FROM ALL PARTS OF THE LEAD SHEATH & REMOVE IT UP TO A DISTANCE OF [B] BEYOND THE ARMOUR WIRES. REMOVE ALL PEAKS OF THE SHEATH & BELL THE SHEATH END.
- 1.8 REMOVE THE INNER SHEATH FROM THE CONDUCTORS LEAVING 5mm DISTANCE BEYOND THE LEAD SHEATH.
- 1.9 STARTING 5mm ONTO THE CORES APPLY ONE HALF LAP LAYER OF SCOTCH No.2228 TAPE OVER THE INNER SHEATH.
- 1.10 CLEAN & SCRAPE THE ARMOUR WIRES TO ENSURE A GOOD CONTACT.
- 1.11 SPLAY THE CONDUCTORS OF THE CABLES RETAINING THEM IN THE CORRECT SEQUENCE.
- 1.12 JOIN THE CONDUCTORS OF THE CABLES TOGETHER IN THE CORRECT SEQUENCE USING THE RECOMMENDED SCOTCHLOK CONNECTORS. FOLLOW THE INSTRUCTIONS ON THE PACKAGING FOR PROPER INSTALLATION. THE CONNECTORS SHOULD BE NEATLY ARRANGED IN ORDER TO MINIMISE THE OVERALL SIZE OF THE COMPLETED JOINT.
- 1.13 CONDUCTOR CONTINUITY CHECKS, ETC. MAY BE CARRIED OUT WHEN ALL THE CONDUCTOR JOINTS HAVE BEEN MADE.
- 1.14 LAY THE CONDUCTORS & CONNECTORS NEATLY IN POSITION, ENSURING THAT THEY WILL BE CENTRALLY IN THE MOULD. IF NECESSARY BIND THE CONDUCTORS & CONNECTORS TOGETHER USING THE CABLE TIES PROVIDED.

FIG.2 EARTH & ARMOUR CONTINUITY

- 2.1 SLIDE THE COPPER SCREEN SLEEVE OVER THE ENTIRE JOINT
- 2.2 FIX THE COPPER SCREEN SLEEVE TO THE LEAD SHEATH & THE ARMOUR USING THE CONSTANT FORCE SPRINGS & REMOVE EXCESS SLEEVE.  
\* NOTE: IF TWO OF THE CONSTANT FORCE SPRINGS ARE SMALLER USE THESE ON THE LEAD SHEATH.
- 2.3 APPLY CONSTANT FORCE SPRINGS WITH TWO HIGHLY STRETCHED HALF LAPPED LAYERS OF SCOTCH No.23 TAPE ENSURING THAT TAPING IS CARRIED OUT IN THE SAME DIRECTION AS THE SPRING WAS APPLIED.
- 2.4 OVERTAPE CONSTANT FORCE SPRINGS & ARMOURING ONTO CABLE SHEATH WITH SCOTCH No.23 TAPE.

FIG.3 MOULD ASSEMBLY (CR2-CR5)

- 3.1 TRIM THE MOULD EXITS TO FIT THE CABLE BY REMOVING THE NECESSARY STEPPED ENDS OF THE MOULD.
- 3.2 WRAP TWO OR THREE LAYERS OF SCOTCH No.23 TAPE AROUND THE CABLE SHEATHS WHERE THE ENDS OF THE MOULD WILL BE LOCATED.
- 3.3 PLACE THE MOULD HALVES CENTRALLY AROUND THE JOINT POSITION WITH THE POURING HOLE UPPERMOST, & PRESS THE TWO HALVES OF THE MOULD TOGETHER. THE GROOVE & TONGUE MUST SNAP TOGETHER AUDIBLY TO ENSURE A SOUND FIXING.
- 3.4 SEAL THE TAPERED ENDS OF THE MOULD WITH SCOTCH No.23 TAPE, CAREFULLY SET THE JOINT LEVEL.
- 3.5 MIX & POUR SCOTCHCAST RESIN INTO THE JOINT MOULD IN ACCORDANCE WITH THE INSTRUCTIONS CONTAINED IN THE KIT.
- 3.6 WHEN THE MOULD IS COMPLETELY FILLED WITH THE RESIN UP TO THE TOP OF THE FILLING DOME, PLACE THE TOP CAP IN POSITION TO CLOSE THE FILLING OPENING OF THE MOULD.



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| KIT | No. OF CORES | MAX. CABLE OD (mm) | PREPARATION DIMENSIONS |        |          |
|-----|--------------|--------------------|------------------------|--------|----------|
|     |              |                    | PVC A                  | LEAD B | ARMOUR C |
| CR2 | 2 TO 6       | 23                 | 50                     | 20     | 20       |
| CR3 | 7 TO 12      | 30                 | 75                     | 30     | 30       |
| CR4 | 14 TO 21     | 39                 | 95                     | 30     | 30       |
| CR5 | 24 TO 37     | 46                 | 122                    | 30     | 30       |

|  |          |
|--|----------|
| THE CONDITIONS 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 STATED HEREIN. |          |
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SCOTCHCAST INLINE JOINT  
 1.5mm<sup>2</sup> – 2.5mm<sup>2</sup> MULTICORE  
 5C TO 37C  
 XLPE LEAD SHEATHED  
 SWA P.V.C. CONTROL CABLES

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