

INSTALLATION SEQUENCE

- 1 STRAIGHTEN & SET UP THE CABLES AT THE JOINT POSITION. ALLOW THE CABLES TO OVERLAP PRIOR TO JOINTING
- 2 SLIDE THE COPPER SLEEVE OVER ONE OF THE CABLES AND PARK TO ONE SIDE.
- 3 REMOVE THE OUTER SHEATH & ARMOUR WIRES OF THE CABLE FOR A DISTANCE OF 2 x [A]
- 4 REMOVE A FURTHER LENGTH OF CABLE SHEATH ACCORDING TO DISTANCE [B]
- 5 THOROUGHLY ABRASE THE SHEATH OF THE CABLE FOR A DISTANCE OF 75mm BEYOND DIMENSION [B]
- 6 REMOVE THE LEAD SHEATH LEAVING A DISTANCE 'C' BEYOND THE ARMOUR WIRES.
- 7 CLEAN ALL DIRT OIL & GREASE FROM ALL PARTS OF THE LEAD SHEATH. REMOVE ALL PEAKS OF THE SHEATH & BELL THE END.
- 8 REMOVE THE INNER SHEATH FROM THE CONDUCTOR LEAVING 5mm DISTANCE BEYOND THE LEAD SHEATH STARTING 5mm ONTO THE OVERALL SCREEN APPLY ONE HALF-LAPPED LAYER OF SCOTCH 2228 OVER THE INNER SHEATH.
- 9 WHERE APPLICABLE UNWIND THE SCREEN TAPES AROUND THE LAID UP CORES, CUT BACK 25mm IN FRONT OF LEAD SHEATH.
- 10 WHERE APPLICABLE UNWIND THE INDIVIDUAL SCREEN TAPES & LAY BACK READY TO REWIND OVER THE CORE AFTER CONNECTIONS.
- 11 REMOVE THE OUTER SHEATH & ARMOUR WIRES OF THE CABLE FOR A TOTAL DISTANCE OF 2 x [A] FROM THE C L
- 12 REMOVE A FURTHER LENGTH OF CABLE SHEATH ACCORDING TO DISTANCE [B]
- 13 THOROUGHLY ABRASE THE SHEATH OF THE CABLE FOR A DISTANCE OF 75mm BEYOND DIMENSION [B]
- 14 REMOVE THE LEAD SHEATH LEAVING A DISTANCE 'C' BEYOND THE ARMOUR WIRES.
- 15 CLEAN ALL DIRT OIL & GREASE FROM ALL PARTS OF THE LEAD SHEATH. REMOVE ALL PEAKS OF THE SHEATH & BELL THE END.
- 16 REMOVE THE INNER SHEATH FROM THE CONDUCTOR LEAVING 5mm DISTANCE BEYOND THE LEAD SHEATH STARTING 5mm ONTO THE OVERALL SCREEN APPLY ONE HALF-LAPPED LAYER OF SCOTCH 2228 OVER THE INNER SHEATH.
- 17 WHERE APPLICABLE UNWIND THE COLLECTIVE SCREEN TAPES AROUND THE CORES & CUT BACK TO A DISTANCE [C]
- 18 WHERE APPLICABLE UNWIND THE INDIVIDUAL SCREEN TAPES & CUT BACK TO 25mm IN FRONT OF DISTANCE [C]
- 19 JOIN THE CONDUCTORS AND DRAIN WIRES OF THE CABLES TOGETHER IN THE CORRECT SEQUENCE, USING THE RECOMMENDED SCOTCHLOK CONNECTORS. STAGGER THE CONNECTORS ACROSS THE JOINT AS SHOWN.
- 20 CONDUCTOR CONTINUITY CHECKS, ETC. MAY BE CARRIED OUT WHEN ALL CONDUCTOR JOINTS HAVE BEEN MADE.
- 21 WHERE APPLICABLE THE LAYED BACK SCREENS ON CABLE 1 SHOULD NOW BE REMOVED OVER EACH INDIVIDUAL CORE AND BOUND DOWN TO THE SCREENS ON CABLE 2 WITH HIGHLY STRETCHED No. 23 TAPE.
- 22 LAY THE CONDUCTORS AND CONNECTORS NEATLY IN POSITION AND OVERTAPE ONE HALF-LAPPED LAYER OF SCOTCH No. 24 TAPE AND BIND DOWN ONTO OVERALL SCREEN WITH STRETCHED No. 23 TAPE.
- 23 BIND THE CONDUCTORS AND CONNECTORS TOGETHER USING THE CABLE TIES PROVIDED.
- 24 CLEAN AND SCRAPE THE ARMOUR WIRES TO ENSURE A GOOD CONTACT.
- 25 LAY THE ARMOUR CONTINUITY CONDUCTOR ALONG THE WIRE ARMOUR AND TEMPORARILY FIX IN POSITION.
- 26 CONNECT THE ARMOUR CONTINUITY BRAID TO THE ARMOURING ACCORDING TO FIG.3.



www.cablejoints.co.uk
Thorne and Derrick UK
 Tel 0044 191 490 1547 Fax 0044 191 477 5371
 Tel 0044 117 977 4647 Fax 0044 117 9775582
 www.thorneandderrick.co.uk

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.	
DESIGN:	CAD FILE : 2296-3-1
ISSUE DATE:	1st ISSUE DATE : 16.5.96
MODIFY:	1st CHANGE DATE: 15.05.97
DRAWN :	ADP
CHECKED :	2nd CHANGE DATE: 30.12.97 (RD)
RELEASED:	3rd CHANGE DATE:
	4th CHANGE DATE:

SCOTCHCAST IN LINE JOINT
 IR20 TO IR60
 FOR .5mm² / 1.5mm² MULTICORE
 PVC LC SWA PVC
 OVERALL SCREEN WITH DRAIN WIRE.

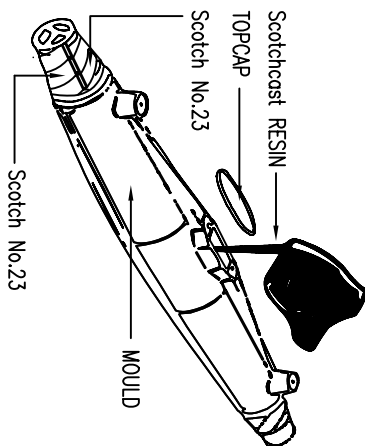
FIG.3 EARTH & ARMOUR CONTINUITY

- 20 SLIDE THE COPPER SCREEN SLEEVE OVER THE ENTIRE JOINT, FIX THE COPPER SCREEN SLEEVE TO THE LEAD SHEATH AND THE ARMOUR USING THE CONSTANT FORCE SPRINGS AND REMOVE EXCESS SLEEVE.
- 21 NOTE IF TWO OF THE CONSTANT FORCE SPRINGS ARE SMALLER, USE THESE ON THE LEAD SHEATH.
- 22 OVERTAPE CONSTANT FORCE SPRING WITH 2 HIGHLY STRETCHED HALF-LAPPED LAYERS OF SCOTCH No.23 TAPE ENSURING THAT TAPING IS CARRIED OUT IN THE SAME DIRECTION AS TH SPRING IS APPLIED.
- 23 OVERTAPE CONSTANT FORCE SPRINGS AND ARMOURING ONTO CABLE SHEATH WITH SCOTCH No. 2228 TAPE.

MOULD PREPARATION

- 24 TRIM EACH MOULD EXIT TO FIT THE CABLES. WRAP TWO OR THREE LAYERS OF SCOTCH No. 23 TAPE AROUND THE CABLE SHEATHS WHERE THE ENDS OF THE MOULD WILL BE LOCATED. THIS TAPE SHOULD BE HIGHLY STRETCHED IN ORDER TO EFFECT AMALGAMATION BETWEEN THE LAYERS OF TAPE. PLACE THE MOULD HALVES AROUND THE JOINT, WITH THE POURING HOLE UPPERMOST AND PRESS THE TWO HALVES TOGETHER. THE GROOVE AND TONGUE MUST SNAP TOGETHER AUDIBLY TO ENSURE A SOUND FIXING. CHECK THE CLEARANCE BETWEEN THE JOINT COMPONENTS AND THE INSIDE OF THE MOULD. SEAL THE TAPERED ENDS OF THE MOULD WITH SCOTCH No.23 TAPE. CAREFULLY SET THE JOINT LEVEL.
- 25 MIX AND POUR THE SCOTCHCAST RESIN INTO THE JOINT MOULD IN ACCORDANCE WITH THE INSTRUCTIONS CONTAINED IN THE KIT.
- 26 WHEN THE MOULD IS COMPLETELY FILLED WITH RESIN UP TO THE TOP OF THE FILLING DOME, PLACE THE TOP CAP INTO POSITION TO CLOSE THE FILLING OPENING OF THE MOULD.

KIT	No. PAIRS	MAX CABLE O.D.	PREPARATION DIMENSIONS			TOTAL JOINT IN MOULD	MOULD SIZE	SHEATH IN EACH END OF MOULD
			PVC 'A'	ARMOUR 'B'	LEAD 'C'			
IR 20	1	X	X	X	X	X	X	X
IR 21	2	25.5	64	20	20	168	198	15
IR 30	5	30.0	92	30	30	244	288	22
IR 40	10	40.1	113	30	30	286	330	22
IR 50	15	44.8	113	30	30	286	330	22
IR 51	20	50.2	140	30	30	340	450	55
IR 60	50	70.6	228	30	30	516	616	50



www.cablejoints.co.uk
Thorne and Derrick UK
 Tel 0044 191 490 1547 Fax 0044 191 477 5371
 Tel 0044 117 977 4647 Fax 0044 117 9775582
 www.thornederrick.co.uk

© TSD UK. PLC. 1996
 TECHNICAL CENTRE, EASTHAMSTEAD Rd,
 BRACKNELL, BERKS. RG12 1JE, ENGLAND

ISSUE: 3
 ISSUE DATE: 30.12.97

ALL STATEMENTS, TECHNICAL INFORMATION AND RECOMMENDATIONS CONTAINED HEREIN ARE BASED ON TESTS WE BELIEVE TO BE RELIABLE. HOWEVER, SINCE 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.

DESIGN:	CAD FILE	2296-3-2
1st ISSUE DATE:	16.5.96	
2nd CHANGE DATE:	15.5.97	
3rd CHANGE DATE:	30.12.97 (RD)	
4th CHANGE DATE:		

Scotchcast®
 SCOTCHCAST IN LINE JOINT
 IR20 TO IR60
 FOR .5mm² / 1.5mm² MULTICORE
 PVC LC SWA PVC
 OVERALL SCREEN WITH DRAIN WIRE.

TSD ELECTRICAL PRODUCTS

XE 0091-2296 3 SHEET 2 OF 2 A3