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**Shrink Polymer Systems**

Cable Installation Materials – 24 volts to 36 kV

## INSTALLATION INSTRUCTION HEATSHRINK JOINT TO SUIT SINGLE CORE 12kV XLPE/ CWS NON ARMoured CABLES

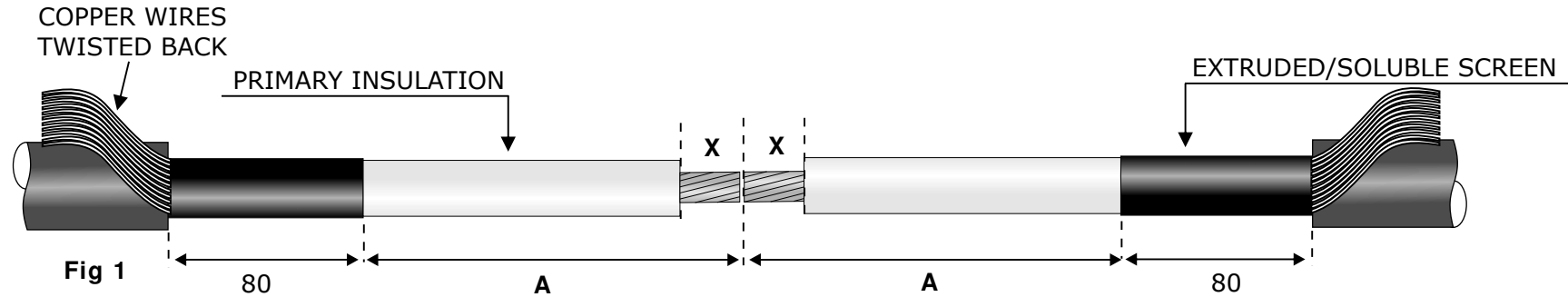


- THESE INSTRUCTIONS SHOULD BE FOLLOWED BY A TRAINED COMPETENT FITTER
- A PROPANE GAS TORCH IS THE PREFERRED METHOD FOR SHRINKING THESE MATERIALS
- ENSURE THAT THE MATERIALS ARE KEPT CLEAN AND DRY AND ARE FREE FROM DUST, SAND AND GREASE
- PLEASE CALL SHRINK POLYMER SYSTEMS FOR ANY ADVICE



DATE OF ISSUE:- 21.06.11

# CABLE PREPARATION



SIZE (mm <sup>2</sup> )	DIMENSION A	DIMENSION X	MAX CONNECTOR LENGTH
25-70	170mm	HALF LENGTH CONNECTOR + 5mm	110mm
95-185	190mm		150mm
185-300	200mm		160mm
400-630	220mm		200mm

**Table 1**

**Important:-** If you have a Cable size 185mm<sup>2</sup> and your kit ranges from 95-185mm<sup>2</sup>, Prepare the Cable to the 95-185mm<sup>2</sup> range not the 185-300mm<sup>2</sup> range

## Cable Preparation

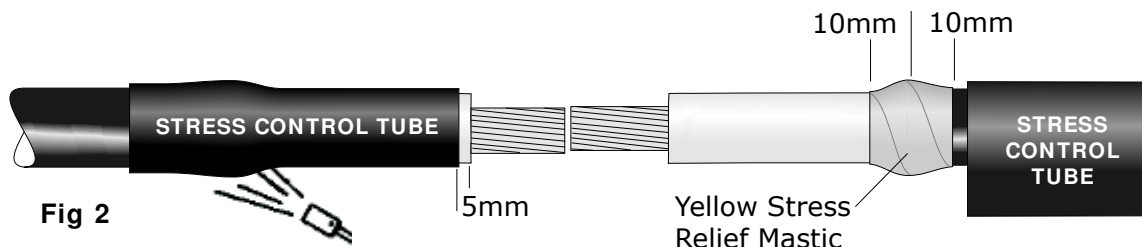
1. Ensure that the cables overlap before proceeding and the outer adhesive lined shrink tube is positioned over the cable end.

### Copper Wire Screen

2. Bend back the wires onto the outer cable sheath, these will be bonded at a later stage. Expose the black semi-conductive screen by 80mm (See Fig 1 and Table 1 for dimension A).

### Black Extruded Semi-Conductive Screen Removal

3. Carefully remove the semi-conductive screen layer using a suitable tool. Avoid scoring and damage to the primary insulation beneath. **Note:-** Screen removal tools are available and videos on screen removal feature on our website.

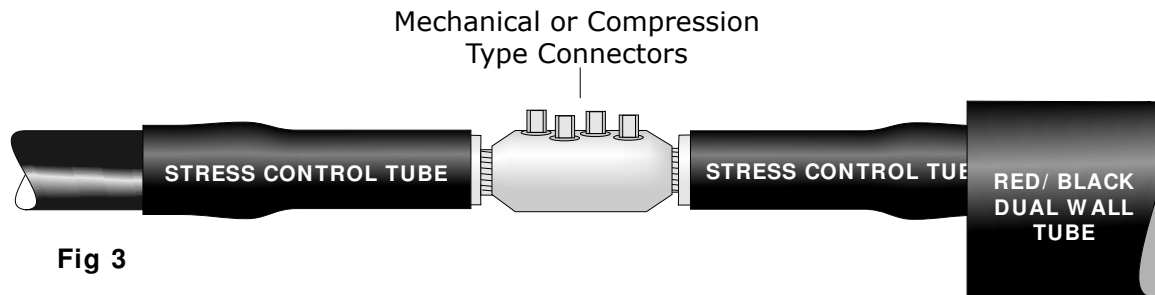


4. Position the stress control and red/black dual wall tubes over each core.

Stretch the yellow stress relief tape and apply over the screen cut area, extending onto the primary insulation and conductive screen by 10mm either side as shown in Fig 2.

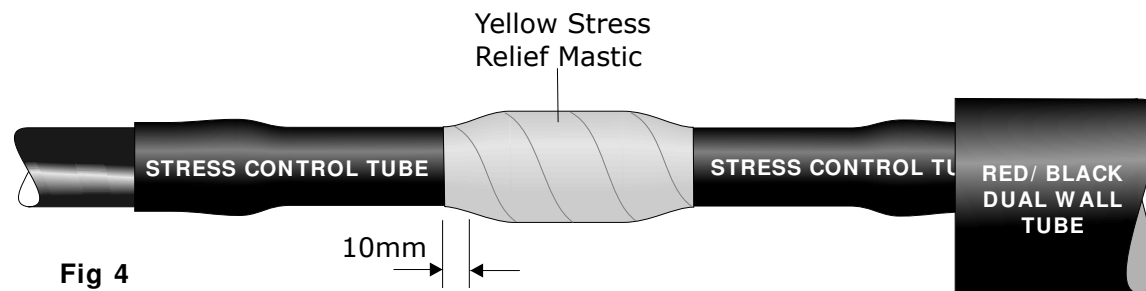
5. Now position the stress control tubes as shown also in Fig 2, 5mm back from the end of the insulation. Starting from the insulation end, apply heat all around the tubes using a soft flame torch. Heat until fully recovered.

6. Fit the approved MV 'tapered' connectors using the appropriate tool. Clean and de-grease before proceeding.



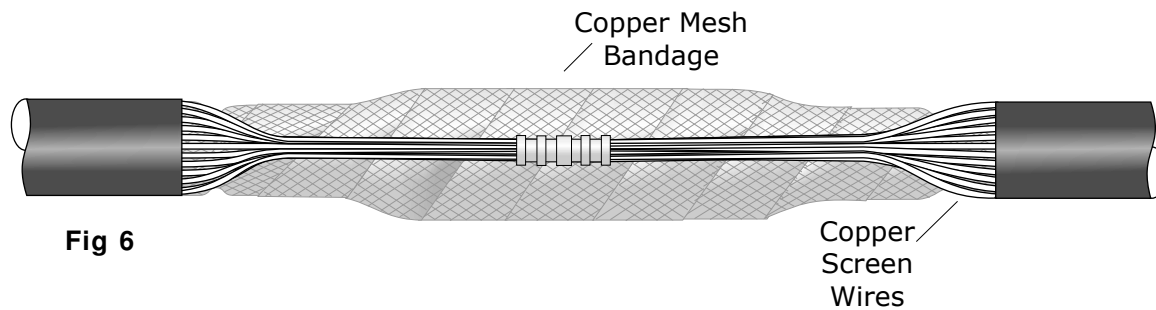
7. Apply the yellow stress relief mastic over the connector area under tension and with a 50% overlap. Extend onto the short stress control tubes by 10mm, as shown in Fig 4.

**Important:-** Fill in the gap between primary insulation and connector. Also if mechanical connectors used, fill any voids that the bolts leave after they have been sheared.



8. Finally, centrally position the red/black dual wall tubes so that they cover the screen end points. Starting in the middle and working towards the ends, shrink them whilst keeping the flame moving all around the tubes to ensure an even recovery and wall thickness.





**Fig 6**

9. Apply a layer of the tinned copper mesh bandage with 50% overlap around the core extending around the copper wire screens on both sides.

Twist the copper screen wires together to form a conductor and join together with a suitable connector as shown in Fig 6. Apply a further layer of copper mesh bandage around the joint and tie off at each end.



**Fig 7**

10. Clean, de-grease and abrade the outer cable sheaths. Position the outer adhesive lined shrink tube centrally over the joint gap. Start shrinking from the centre to one end at a time. Keep the flame on the move to ensure an even wall thickness. The tube should be wrinkle free and sealants should be visible at the ends.

11. Allow the completed joint to cool before applying any mechanical strain.



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