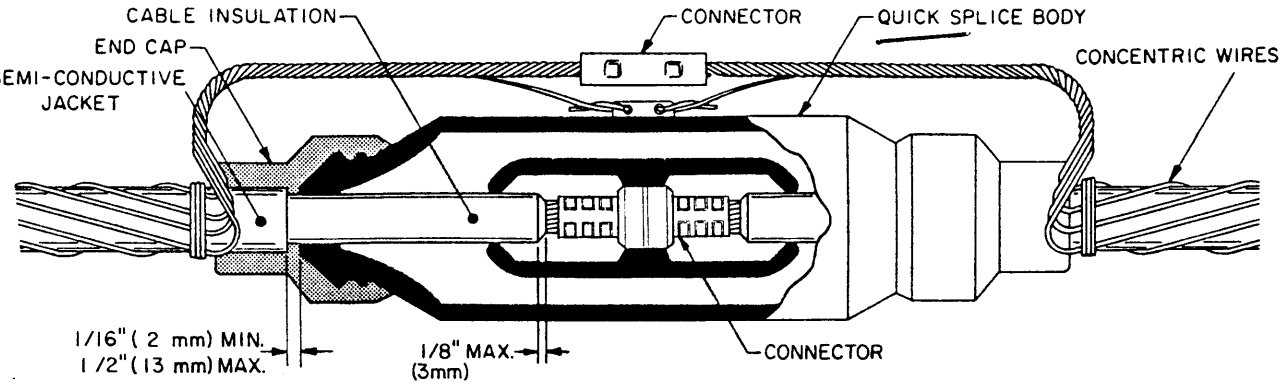

CAUTION: CHECK THE INSULATION DIAMETER. THE DIAMETER MUST BE BETWEEN .795 & .940 INCHES.

A. PREPARE CABLES ACCORDING TO STANDARD PROCEDURES (FIGURE 1)
1. Allow sufficient concentric neutral wires for connection.
2. Gently fold neutral wires back over cable jackets. Avoid sharp bends.
3. Continue preparation of cables according to Figures 1 & 2.

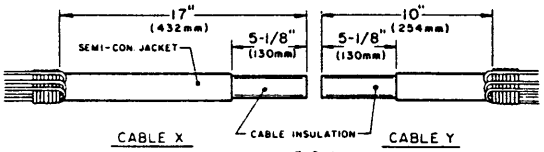

FIG. 1

4. Clean cables.
   a. Do not use solvent on semi-conductive jacket.
   b. Do not use abrasive cloth on insulation or semi-con jacket.

B. INSTALLATION PROCEDURES (FIGURES 2,3 and 4)
1. In order to facilitate splice installation wrap a small amount of vinyl tape around the edge of the jacket on cable X to form a ramp. This tape must be removed after step 8.
2. Lubricate the insulation of both cables with silicone grease furnished in kit.
3. Slide end caps onto their respective cables.
4. Clean and generously relubricate insulation of cable X.

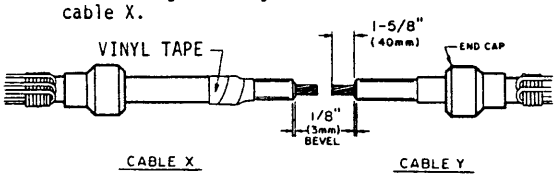

FIG. 2

5. Install splice body onto cable X.

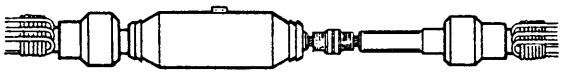
FIG. 3

6. Install connector. See connector and crimping tool table below.

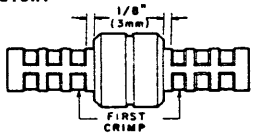

FIG. 4

7. Reclean and lubricant exposed insulation.
8. Center splice body over connector as in Figure 4.

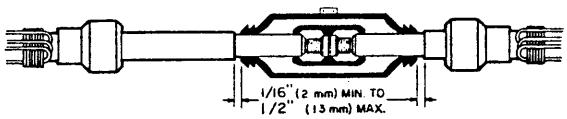

FIG. 5

9. Apply silicone grease over exposed insulation.
10. Firmly seat one end cap against splice body and twist onto splice body. Two locking grooves exist on the splice body. THE WORKMAN SHOULD FEEL TWO SNAPS.
11. Check for proper spacing between splice body and jacket of other cable.
12. Firmly seat remaining end cap against splice body.

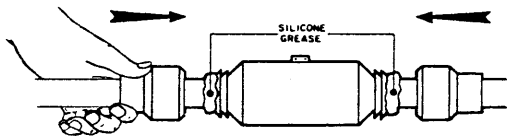

FIG. 6

C. GROUNDING THE SPLICE
1. Attach one wire from each cable to the grounding eye and remainder to an inline connector as shown.

3M Systems for Splicing and Terminating.

CONNECTOR TABLE

CONDUCTOR SIZE		3M SPLICE CONNECTOR NO.
STRANDED	SOLID	
——	# 2	CI-22-A
# 2	# 1	CI-2-A
# 1	1/0	CI-1-A
1/0	——	CI-1/0-A

NOTE. A SPECIAL 3M "CI" SERIES CONNECTOR IS NECESSARY FOR USE IN ALL QUICK SPLICES

CRIMPING TOOL TABLE

CABLE SIZE	MFG.	MECHANICAL		HYDRAULIC	
		TOOL	DIE (CRIMPS PER END)	TOOL	DIE (CRIMPS PER END)
#2 AWG TO 1/0	BURNDY	MD6	BG(2)***	Y-35,Y-39,Y-45*	U26ART(2)
	KEARNEY	0-52,0-51	5/8-1(2)***	WH-2,WH-1	5/8-1(2)***
	T & B	TBM-8	OLIVE(2)	TBM-15	50(1)**
	ANDERSON	——	——	VC6	UNIVERSAL(2)***

* — USABLE WITH U-DIE ADAPTED PT651
** — EXCESS FLASH MUST BE FILED OFF TO ROUND OUT CONNECTOR
*** — SECOND CRIMP CAN OVERLAP FIRST (I.E. THREE IDENTATIONS)

TECHNICAL DATA

VOLTAGE RATING 25 KV

FOR CABLES RATED 90°C COND. TEMP.

AL. OR CU. COND.

PASSES TESTS REQUIRED IN IEEE PROPOSED STANDARD FOR POWER CABLE JOINTS

ISSUE	DATE	REV.	CH.
7	8 JUNE 77		
NOT TO SCALE		CH	
DR. N.E.WROBEL		APP.	

2047 T 17

Electro-Products Division 3M

3M QUICK-SPLICE
INLINE SPLICING KIT

5420

FOR USE ON CONCENTRIC NEUTRAL (URD) CABLE

CONDUCTOR SIZE #2 THRU 1/0

INSULATION O.D. .795" (20.19mm) TO .940" (23.88mm)

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