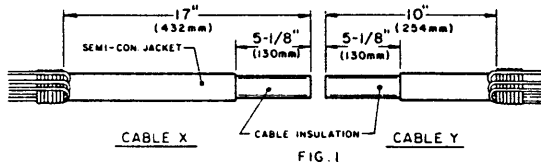


CAUTION: CHECK THE INSULATION DIAMETER. THE DIAMETER MUST BE BETWEEN .795 & .940 INCHES.

**A. PREPARE CABLES ACCORDING TO STANDARD PROCEDURES (FIGURE 1)**

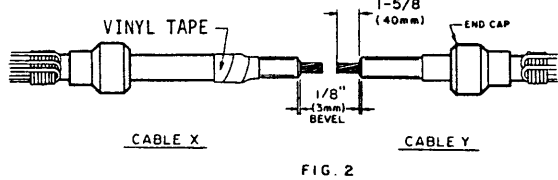
1. Allow sufficient concentric neutral wires for connection.
2. Gently fold neutral wires back over cable jackets. Avoid sharp bends.
3. Continue preparation of cables according to Figures 1 & 2.



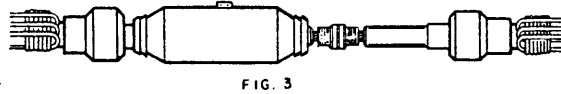
4. Clean cables.
  - a. Do not use solvent on semi-conductive jacket.
  - b. Do not use abrasive cloth on insulation or semi-con jacket.

**B. INSTALLATION PROCEDURES (FIGURES 2,3 and 4)**

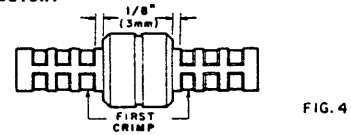
1. In order to facilitate splice installation wrap a small amount of vinyl tape around the edge of the jacket on cable X to form a ramp. This tape must be removed after step 8.
2. Lubricate the insulation of both cables with silicone grease furnished in kit.
3. Slide end caps onto their respective cables.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



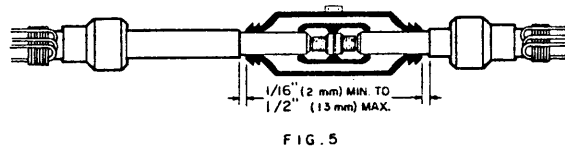
5. Install splice body onto cable X.



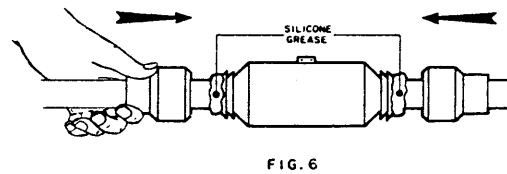
6. Install connector. See connector and crimping tool table below.



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



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.



**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.**

REDUCED COPY

**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 PT 651  
 \*\* — 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

**IMPORTANT NOTICE TO PURCHASER:** All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed, and the following is made in lieu of all warranties, express or implied:

Seller's and manufacturer's only obligation shall be to replace such quantity of the product proved to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Before using, user shall determine the suitability of the product for his intended use, and user assumes all risk and liability whatsoever in connection therewith.

No statement or recommendation not contained herein shall have any force or effect unless in an agreement signed by officers of seller and manufacturer.

ISSUE	DATE	REV.	CH.
7	8 JUNE 77		
NOT TO SCALE		CH	
DR.	APP.		
N.E. WROBEL	<i>[Signature]</i>		
<b>2047 T 17</b>			
Electro-Products Division <b>3M</b>			

**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)