



INSTRUCTION MANUAL

ELECTRICAL CABLE SPLICING KIT

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CABLE SPLICING INSTRUCTION

The following instruction can be applied to many but not to all types of cables or splice kits.

Two types of splice kits are available from Roctest:

A) A stainless steel housing with steel grommet connectors

B) A PVC housing with nylon or steel grommet connectors

In both cases, housing dimensions may vary in function of cable type and diameter.

A splicing kit includes one splice tube, two connectors and polyurethane filling.

Proceed as follows:

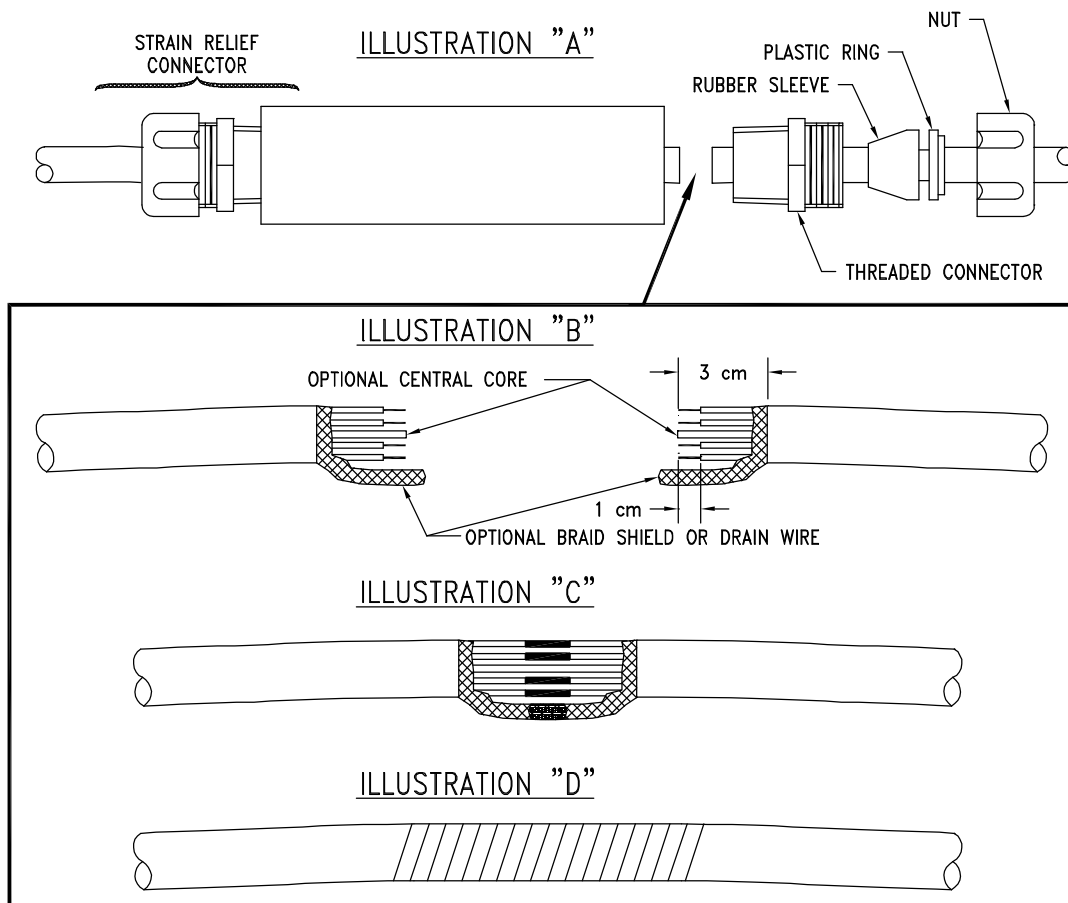
1. Cut carefully both ends of cable to splice.
2. Clean carefully both ends of the electric cable to be spliced over approximately 20 cm.
3. Slide the free connector on one end of the cable. On the other end, slip on the splice tube - with the second connector screwed on it -until the end of the cable exceeds the tube approximately 30 centimeters (see illustration "A").
4. On both ends of the cable, remove approximately 3 centimeters of the outer jacket. Remove one centimeter of insulation jacket on each conductor (see illustration "B"). Do not get rid of the braid shield and central reinforcement core, if they exist, as they will be reconnected afterwards. With an IRC-41A cable or similar, discard the aluminum foil but keep the drain wire.
5. Make the connection of each conductor respecting the color code. For best results, the use of a soldering iron with soldering wire is highly recommended. Skilled personnel should conduct the soldering operation in order to avoid "cold" solders. Isolate each conductor with heat shrink tubing or, if not available, electrical tape (see illustration "C").
6. Form a twisted wire with braid shield or drain wire and solder each end together, again using a soldering iron.
7. Attach together each end of central reinforcement core suitably, in order to restore mechanical strength of cable, either by using a suitable crimp, or brazing. Be careful not to damage the conductors when using the brazing torch.
8. Tie all the connections together by using electrical tape (see illustration "D").
9. Slide and center the splice tube over the connections and screw tight the first connector to the end of the tube (if not already in place).
10. Tube filling with potting may be done following one of two ways whether the tube is fitted or not with plugs.

If the tube is fitted with plugs, proceed as follows:

- Slide and screw the second connector in place.
- Remove the two plugs on the top of the splice tube.
- Mix the polyurethane compound according to right proportions.
- While holding the tube horizontally, pour the polyurethane in the tubing until it is completely full.
- Screw in tightly the two plugs back into the filling holes.

If the tube is not fitted with plugs, proceed as follows:

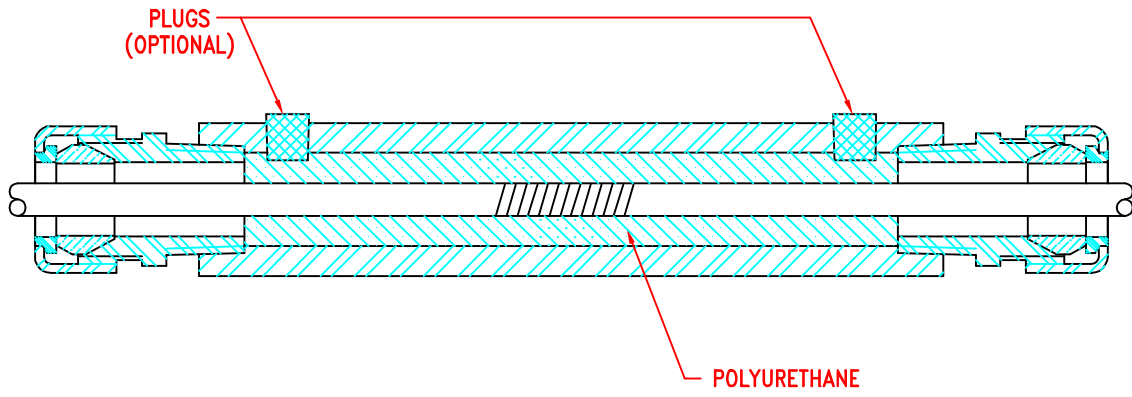
- Mix the polyurethane compound according to right proportions.
- Pour the polyurethane in the opening left by the unscrewed connector, while holding the tube vertically.
- When filled up, slide and screw the second connector.



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Figure 1: Cable Splicing Steps

ILLUSTRATION "E"



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Figure 2: Cable Splicing Assembly