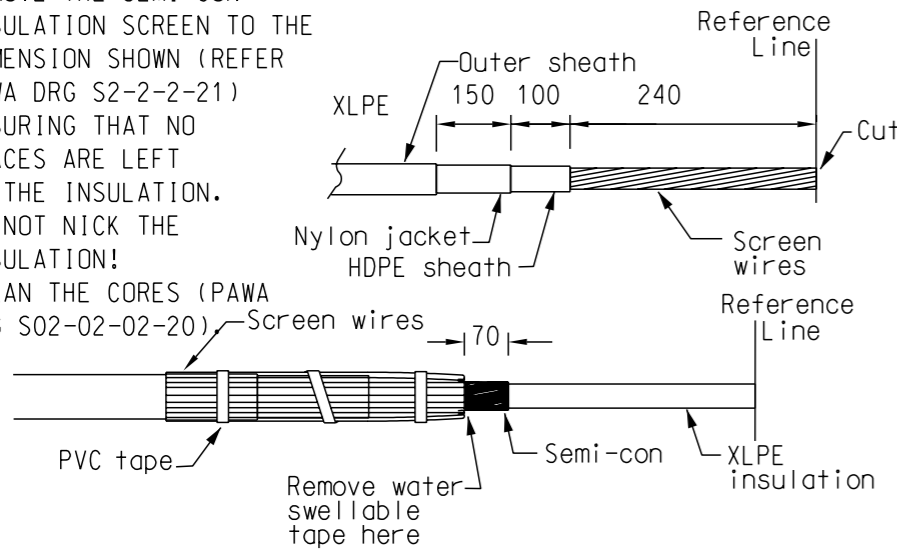


10. XLPE - CLEAN AND DEGREASE THE OUTER SHEATHS FOR A LENGTH OF 1m. CUT THE CABLES AT THE REF LINE. REMOVE THE OUTER SHEATHS, NYLON AND INNER HDPE SHEATHS TO THE DIMENSIONS SHOWN. BEND BACK THE SCREEN WIRES AND SECURE WITH PVC TAPE, COVER WITH PLASTIC WRAP. REMOVE WATER SWELLABLE TAPE BACK TO THE SCREEN WIRES.

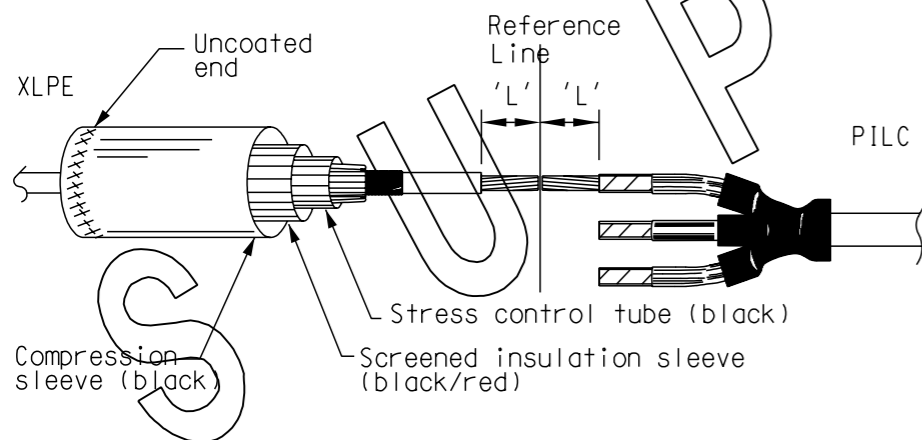
REMOVE THE SEMI-CON INSULATION SCREEN TO THE DIMENSION SHOWN (REFER PAWA DRG S2-2-2-21) ENSURING THAT NO TRACES ARE LEFT ON THE INSULATION. DO NOT NICK THE INSULATION!

CLEAN THE CORES (PAWA DRG S02-02-02-20)



11. SLIDE A COMBINED TUBING SET OVER EACH XLPE CABLE. NOTE: TAKE CARE THAT THE UNCOATED END OF THE COMPRESSION SLEEVE POINTS TOWARDS THE SHEATH OF THE XLPE CABLE.

REMOVE INSULATION ON ALL CORES TO A DISTANCE OF L + 5mm WHERE L = DEPTH OF CONNECTOR HOLE. NOTE: 240sq.mm - MAX CONNECTOR LENGTH 160mm, MAX DIA 36mm



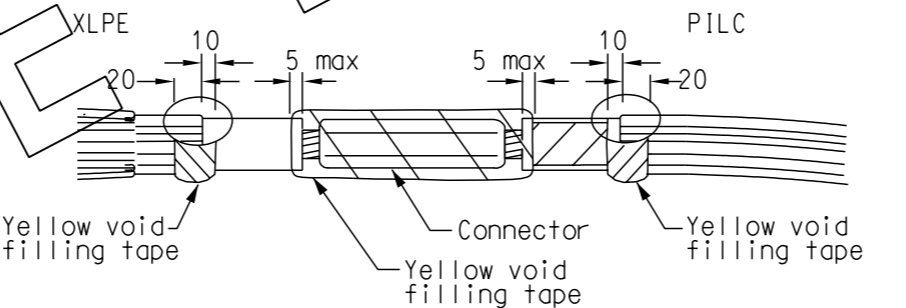
11 ..CONT  
WET WIRE BRUSH (ie UNDER A LIGHT FILM OF JOINTING COMPOUND) THE CONDUCTORS. CRIMP CONNECTORS WITH THE APPROPRIATE DIE, REMOVE SHARP EDGES AND THOROUGHLY CLEAN OFF EXCESS GREASE FROM CONNECTOR AND CORE INSULATION (PAWA DRG S02-02-02-20) - THEN DON'T TOUCH IT!.

12. XLPE - REMOVE THE RELEASE PAPERS FROM THE YELLOW VOID FILLING STRIP WITH THE POINTED ENDS. WRAP THE VOID FILLER AROUND THE SEMI-CON STARTING 20mm ONTO THE SEMI-CON AND CONTINUING 10mm ONTO THE XLPE INSULATION. STRETCH TO HALF ITS WIDTH TO ACHIEVE A FINE THIN EDGE ON THE XLPE.

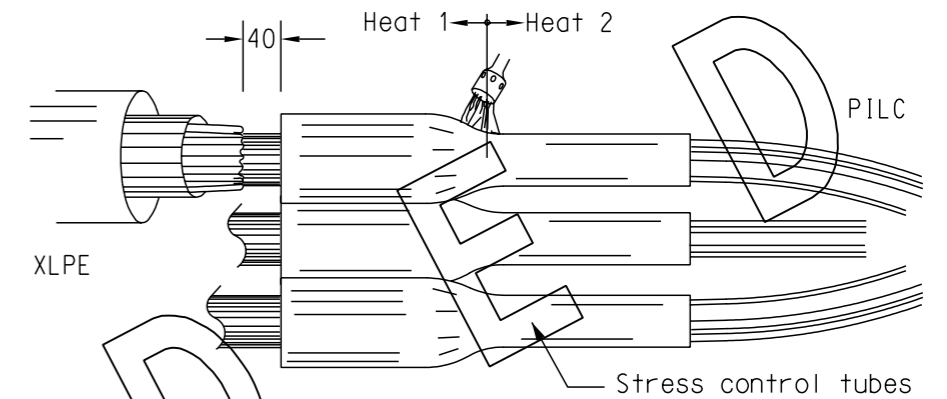
PILC - WRAP ONE LAYER OF YELLOW VOID FILLING STRIP AROUND THE END OF THE BLACK CONDUCTIVE TUBING OF EACH CORE STARTING 20mm ON THE CONDUCTIVE TUBING AND CONTINUING 10mm ONTO THE CLEAR TUBING. STRETCH TO HALF ITS WIDTH TO ACHIEVE A FINE THIN EDGE ON THE CLEAR TUBING.

REMOVE PRINTED RELEASE PAPER FROM THE LONG YELLOW VOID FILLING TAPE AND ROLL IT UP. APPLY WITH A 50% OVERLAP STRETCHING TO ABOUT HALF ITS ORIGINAL WIDTH. FILL UP THE GAPS AND OVER THE CONNECTOR AREA CONTINUING ONTO THE CLEAR TUBING 5mm MAX.

NOTE: DO NOT USE TOO MUCH VOID FILLER - THE FINAL DIAMETER SHOULD BE ONLY SLIGHTLY GREATER THAN THE CORE OR CONNECTOR DIAMETER, WHICHEVER IS THE LARGER.



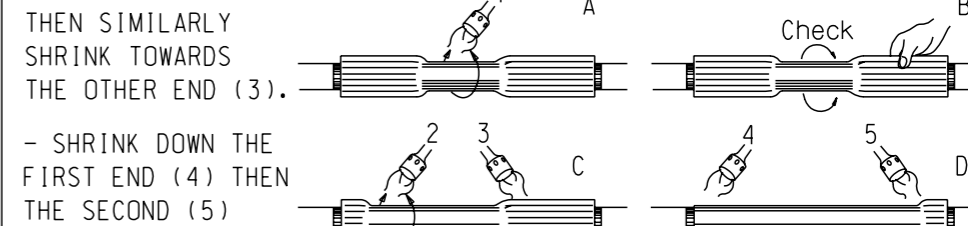
SLIDE THE BLACK STRESS CONTROL TUBE OVER THE COMPLETED CONNECTOR AREA AS PROTECTION BEFORE TAPING THE OTHER CORES. AT THE XLPE CABLE END LEAVE A 40mm GAP TO THE HDPE SHEATH AS SHOWN.



13. START SHRINKING ALL 3 DOWN IN THE CENTRE WORKING TOWARDS THE ENDS. WHEN COMPLETED THEY SHOULD BE WRINKLE FREE. REFER TO DIAGRAM ABOVE.

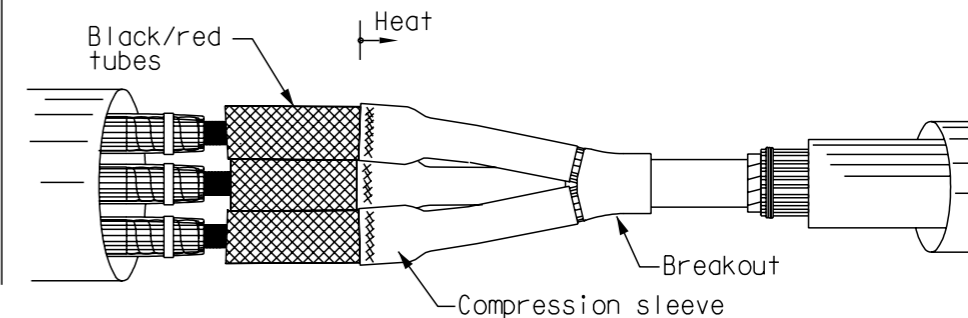
14. POSITION THE 3 BLACK/RED SCREENED INSULATING TUBINGS CENTRALLY OVER THE STRESS CONTROL TUBES.

- START SHRINKING IN THE CENTRE (1).
- CHECK FULLY SHRUNK BY TWISTING THE ENDS - THE TUBES SHOULD NOT MOVE.
- CONTINUE SHRINKING TOWARDS ONE END (2), STOPPING 50mm BEFORE THE END.



THE SLEEVES SHOULD BE FULLY SHRUNK WITHOUT LEAVING RIDGES.

15. POSITION THE COMPRESSION SLEEVES OVER THE PILC CORES SO THAT THEY COVER THE SCREENED INSULATING SLEEVE AND THE TURRETS OF THE BREAKOUT. SHRINK ALL THREE, STARTING AT THE CONNECTOR AREA WORKING TOWARDS THE BREAKOUT.



NO	DESCRIPTION	DRN	DATE	CKD	APPD
1	SUPERSEDED	A.T.	DEC'12	B.C.	B.C.
AMENDMENTS					



DES	JEH/ICV 11/96	POWER STANDARD DRAWING	
DRN	R. INNES	<b>CABLE JOINTING &amp; TERMINATIONS</b>	
CKD	-	<b>RAYCHEM JOINTING INSTRUCTIONS</b>	
APPD	F. ROBSON	<b>22kV 3C 240sq.mm Cu SCREENED PILC</b>	
SCALE	NO SCALE	<b>TO 22kV 1C 240sq.mm Cu XLPE.</b>	
ISSUED	MAY'98	A3	DRAWING NUMBER S02-02-02-44 SHEET 2 of 3
ALL DIM.	IN mm		
DRAFTING STANDARD TO A.S.1100		CAD PRODUCT - DO NOT AMEND MANUALLY	

