

STEP 1.
LOCATE THE CABLE IN ITS APPROXIMATE FINAL POSITION, LEAVING A MINIMUM OF 600mm PAST THE CONNECTION POINT. (EXTRA LENGTH IS NEEDED TO ALLOW FOLDED BACK SCREEN WIRES TO REACH THE EARTHING POINT). CLEAN THE CABLE. HOLD THE TOP OF THE GREY TUBE AGAINST THE CABLE AT THE LUG CONNECTION POINT, AND APPLY A PVC MARKER TAPE LEVEL WITH THE BOTTOM OF THE TUBE.

STEP 2.
REMOVE OUTER SHEATH, NYLON AND INNER SHEATH TO 70mm ABOVE THE TAPE MARKER. STEP BACK NYLON AND PVC SHEATHS AS SHOWN. APPLY A WRAP OF GREY SEALANT TAPE OVER JACKETS, FOLD BACK SCREEN WIRES AND BED THEM INTO THE SEALANT TAPE, THEN BIND THEM DOWN WITH PVC TAPE. REMOVE WATER SWELLABLE TAPE.

STEP 3.
USING THE GREY TUBE MEASURE UP FROM INNER SHEATH AND CUT OFF EXCESS CABLE. CAREFULLY REMOVE SEMI-CONDUCTIVE INSULATION SCREEN (REFER INSTRUCTION ON DRAWING S02-02-02-21) FROM CABLE TO DIMENSION SHOWN. REMOVE INSULATION FROM CONDUCTOR EQUAL TO LENGTH OF BARREL +5mm. CUT A 3mm BEVEL ON INSULATION END.

STEP 4.
WET WIRE BRUSH (ie UNDER A THIN FILM OF JOINTING COMPOUND) THE CONDUCTOR. CRIMP ON APPROPRIATE LUG. REMOVE ANY BURRS AND CLEAN OFF EXCESS GREASE FROM LUG AND CABLE. THOROUGHLY CLEAN DOWN INSULATION (REFER INSTRUCTION ON DRAWING NO S02-02-02-20), WIPING FROM LUG END TOWARD THE SCREEN WIRES. CLEAN SEMICONDUCTIVE LAYER.

STEP 5.
POSITION THE BLACK STRESS CONTROL TUBING OVER THE INSULATION AND SEMICONDUCTIVE LAYER TO THE TOP OF THE INNER SHEATH AS SHOWN. SHRINK ON USING A SOFT FLAME, (REFER INSTRUCTION ON DRAWING NO S02-02-02-20) STARTING AT THE TOP (INSULATION END) AND SLOWLY WORKING TOWARD THE SCREEN WIRES. HEAT THE TUBE EVENLY ALL ROUND TO ENSURE UNIFORM SHRINKAGE, AND APPLY SUFFICIENT HEAT TO ENSURE THE SEALANT IN THE STRESS CONTROL TUBE IS MELTED.

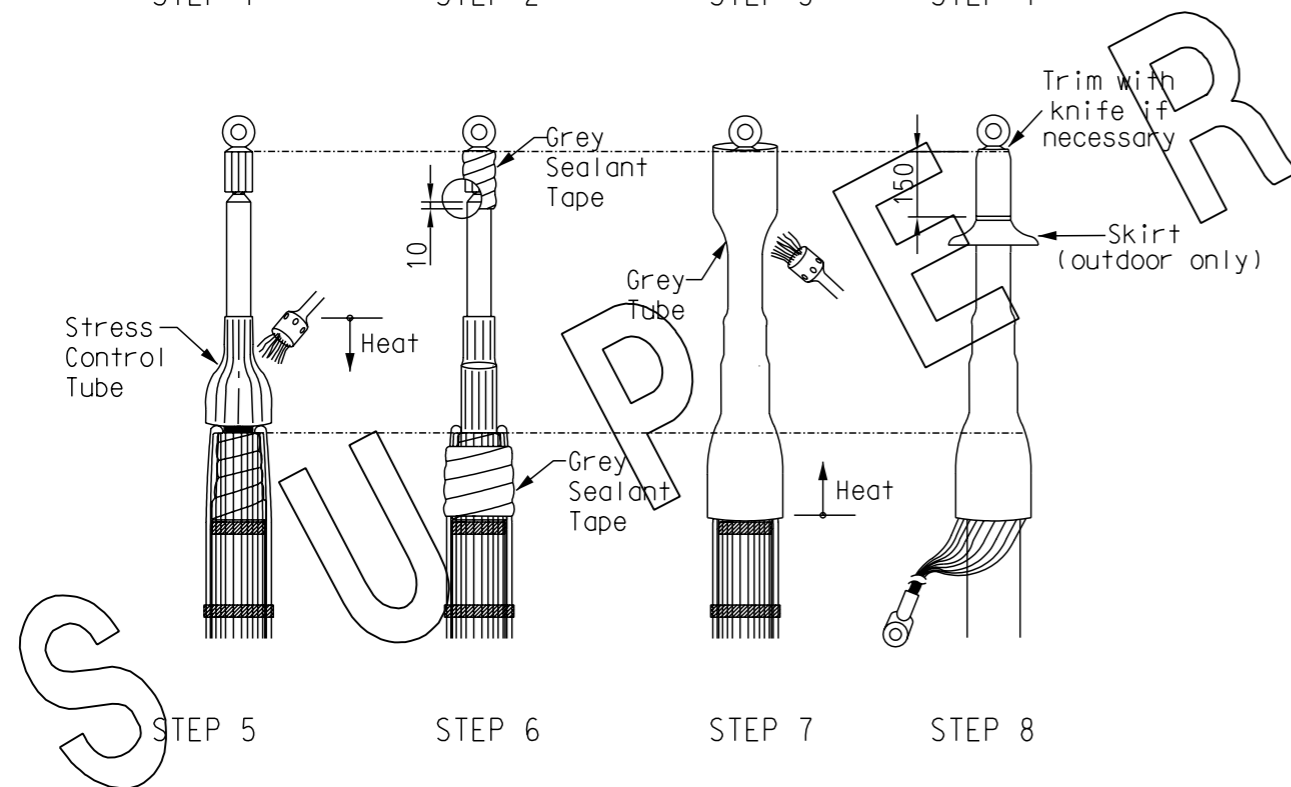
STEP 6.
APPLY A FURTHER WRAP OF GREY SEALANT TAPE OVER THE SCREEN WIRES SO THEY ARE BEDDED BETWEEN LAYERS OF SEALANT. DECREASE THE LUG, AND PREHEAT IT SLIGHTLY. APPLY A LAYER OF GREY SEALANT AROUND THE LUG AND OVER THE INSULATION BY APPROX 10mm. APPLY SUFFICIENT TAPE TO THE LUG BARREL TO ENSURE A SMOOTH PROFILE, AND A FINISHED DIAMETER AT LEAST EQUAL TO THAT OF THE INSULATION.

STEP 7.
POSITION THE GREY OUTER TUBING OVER THE CORE DOWN TO THE TAPE MARKER, (THIS ENSURES AN OVERLAP OF 70mm OVER THE CABLE JACKET). SHRINK THE GREY TUBING INTO POSITION, BY STARTING AT THE BOTTOM AND SLOWLY UPWARDS TOWARD THE CABLE LUG. HEAT THE TUBE EVENLY ALL ROUND TO ENSURE UNIFORM SHRINKAGE.

STEP 8.
REMOVE PVC BINDING TAPE AND GATHER CONCENTRIC NEUTRAL WIRES TOGETHER TO FORM THE EARTH CONDUCTOR. CUT TO REQUIRED LENGTH, AND CRIMP ON APPROPRIATE LUG.

FOR OUTDOOR TERMINATIONS, SHRINK ON ONE SKIRT 150mm FROM TOP OF GREY TUBE (LUG END) AS SHOWN.

KIT STOCK CODES: 35sq.mm 255976, 95sq.mm 255984, 240/400sq.mm 255992



DES	DPH 07/96	POWER STANDARD DRAWING	
DRN	R. INNES	CABLE JOINTING & TERMINATIONS SIGMAFORM TERMINATION INSTRUCTIONS 11kV XLPE	
CKD	-		
APPD	F. ROBSON	A3	DRAWING NUMBER S02-02-02-46
SCALE	NO SCALE		
ISSUED	MAY '98	DRAFTING STANDARD TO A.S.1100	
ALL DIM.	IN mm		
CAD PRODUCT - DO NOT AMEND MANUALLY		AMDT	

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