



HEAT SHRINKING PROCEDURE

COMPONENTS	A) TUBING B) SLEEVE (WITH INNER HOT MELT ADHESIVE COATING)
CUTTING TUBING OR SLEEVES	ALL CUTS MUST BE CLEAN AND SMOOTH. JAGGED OR UNEVEN ENDS WILL SPLIT WHEN HEATED. CUT THE TUBING AND SLEEVES WITH SCISSORS IN ONE CUT OR BY PLACING THE COMPONENT ON FLAT SURFACE AND CUTTING WITH A SHARP KNIFE.
CLEANLINESS	ANY SURFACE ON WHICH HEAT SHRINKABLE COMPONENTS ARE TO BE APPLIED WITH THE INTENTION OF MAKING A MOISTURE PROOF SEAL MUST BE THOROUGHLY CLEANED WITH ISO ALCOHOL WIPES (S/C 502262) TO REMOVE ALL TRACES OF GREASE AND DIRT.
SHRINKING ON TO METAL FITTINGS	PACKING IS REQUIRED WHEN TUBING OR SLEEVES ARE SHRUNK OVER PROFILES WITH SUDDEN CHANGES. USE BUTYL RUBBER BEDDING FROM THE CABLE OR P.V.C. INSULATION TAPE AS A PACKING. ALL METAL COMPONENTS MUST BE GENTLY PREHEATED UNTIL UNCOMFORTABLE TO TOUCH. ALL BI-METAL LUGS ARE TO BE HAVE THE ALUMINIUM/COPPER JOINT COVERED WITH HEATSHRINK.
FLAME	USE LP GAS WITH COMPANION BURNER No. 742 OR 942 (OR SIMILAR) USE A SOFT FLAME. DO NOT USE A FIERCE BLUE FLAME AS IT TENDS TO BURN THE COMPONENTS. SHRINK THEM TO QUICKLY AND PREVENTS THE INNER HOT MELT ADHESIVE COATING FROM MELTING TO FORM A GOOD MOISTURE PROOF SEAL. AVOID LOCALISED HEATING - KEEP FLAME MOVING AT ALL TIMES. DO NOT RUSH THE SHRINKING PROCESS. A BETTER JOB IS OBTAINED IF THE COMPONENTS ARE SHRUNK SLOWLY WITH A SOFT FLAME. WHEN WORKING OUTDOORS TAKE MEASURES TO SHIELD THE LOCATION FROM WIND. THIN WALL COMPONENTS REQUIRE LESS HEAT THAN THICK WALL HOT MELT ADHESIVE COATED COMPONENTS
SHRINKING TUBING	AVOID THE FORMATION OF BUBBLES OF AIR ESPECIALLY WHEN SHRINKING SLEEVES ON CRIMP LINKS WHICH HAVE A SHARP CHANGE IN PROFILE. MOVE THE FLAME AROUND CIRCUMFERENCE OF TUBING AND THEN SLOWLY ALONG THE TUBING. ISOLATED LENGTHS OF SLEEVES OR TUBING SHOULD BE SHRUNK AT THE MIDDLE AND THEN THE FLAME WORKED EACH END.
NOTE	1. SEE DGN S02-2-2-11 FOR PROVISION OF TERMITE BARRIER TO CRIMP LINK JOINT.

NO	DESCRIPTION	DRN	DATE	CKD	APPD
6	CLEANLINESS NOTES UPDATED	A.T.	JUN'14	A.T.	B.C.
5	OUTER JACKET ADDED	C.C.	JUN'11	A.T.	S.C.
4	REDRAWN ON CAD - INSTRUCTIONS AMENDED	C.M.	SEPT2010	A.T.	S.C.
AMENDMENTS					

PowerWater
NORTHERN TERRITORY

DES	G.R.	POWER NETWORKS - STANDARDS CABLE JOINTING & TERMINATIONS JOINTING - HEAT SHRINK - INSTRUCTIONS CABLE LUGS & LINKS
DRN	cwm	
CKD	C.H.Y.	
APPD	...	
SCALE	N.T.S.	
ISSUED	MAR 1994	DRAWING NUMBER S02-2-2-10
ALL DIM. IN mm		
DRAFTING STANDARD TO A.S.1100		CAD PRODUCT - DO NOT AMEND MANUALLY

