



Cold Shrink QS-III Splicing Kit

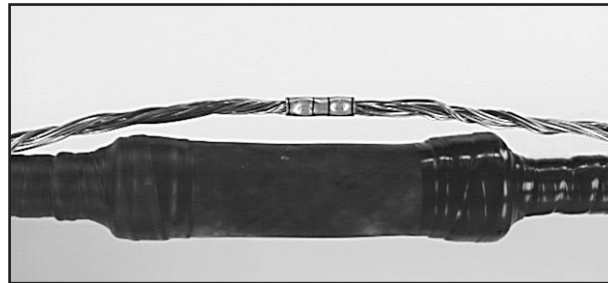
Instructions

For Concentric Neutral (CN), Jacketed Concentric Neutral (JCN) and Flat Strap Neutral Cable

IEEE Std. 404

35 kV Class

250 kV BIL



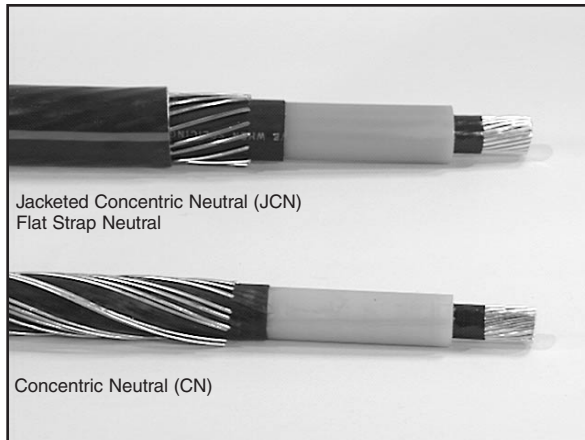
Selection Chart

Kit Number	Cable Insulation O.D. Range	Conductor Size Range
5468A-WG	1.24" to 2.07" (31,5 mm to 52,6 mm)	350–1000 kcmil* (185–500 mm ²)

* Splices (including size transitions) can be made to smaller or larger conductors (but larger conductors may require special neutral handling), provided both cables are within the Insulation O.D. Range and the connector meets the dimensional requirements shown below.

Connector Dimensional Requirements

	Minimum inches (mm)	Maximum inches (mm)
Outside Diameter	0.87" (22,1 mm)	2.07" (52,6 mm)
Length Aluminum (Al/Cu)	-----	7.50" (191 mm)
Length Copper (Cu)	-----	8.25" (210 mm)



3M™ Cold Shrink
QS-III Splicing Kit
5468A-WG

78-8126-0345-0-B

CAUTION

Working around energized high-voltage systems may cause serious injury or death. Installation should be performed by personnel familiar with good safety practice in handling high-voltage electrical equipment. De-energize and ground all electrical systems before installing product.

Kit Contents:

Quantity	Description
15468A-WG Splice Body
2Tubes of P55/R Compound
15468A-WG Splice Instruction
1Adapter Tube
2Cable Preparation Templates
4Scotch™ 2230 Mastic Sealing Strips, 6" length

Instructions for Jacketed Concentric Neutral (JCN), Concentric Neutral (CN), and Flat Strap Neutral Cable



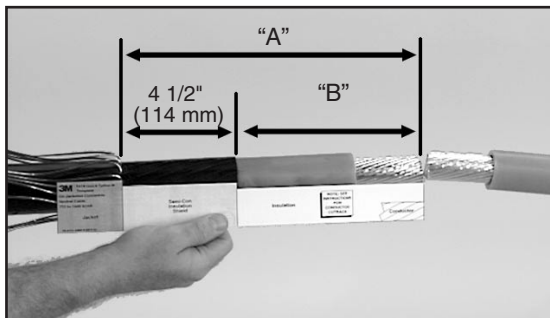
**Jacketed Concentric Neutral (JCN)
or Flat Strap Neutral**



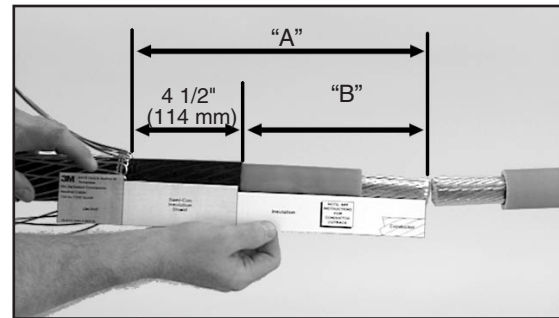
Concentric Neutral (CN)

1.0 Prepare Cables

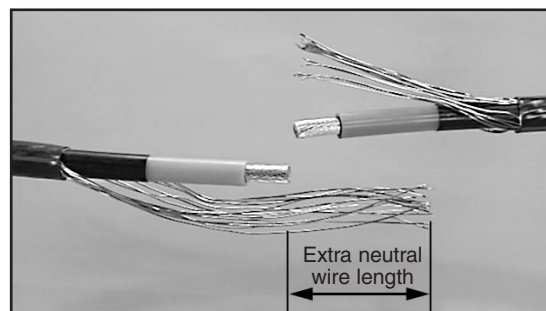
- 1.1 Prepare cables according to standard procedures. Refer to illustration below for proper dimensions. Additional distance is required on one cable to provide extra neutral wire length for connecting the neutrals.



**Jacketed Concentric Neutral (JCN)
or Flat Strap Neutral**



Concentric Neutral (CN)



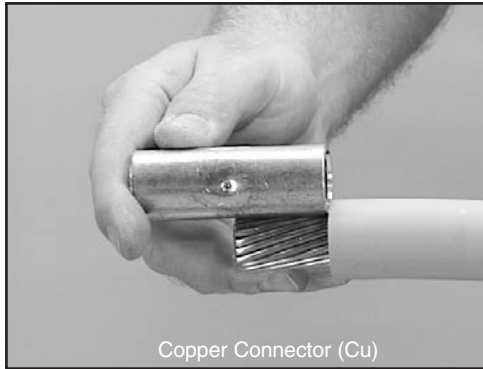
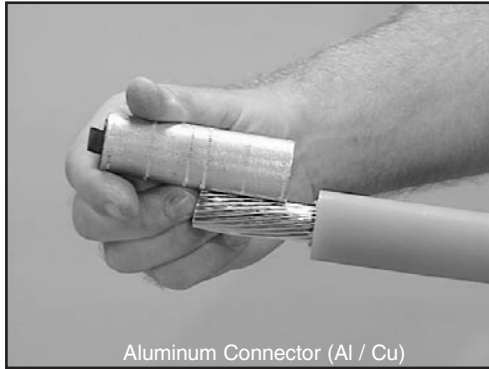
Typical Conductor Size* kcmil (mm ²)	Insulation OD Range Inches (mm)	Jacket Cutback "A" Inches (mm)	Semi-con Cutback "B" Inches (mm)
350**–500 (185–300)	1.24–1.70 (31,5–43,2)	13 3/4 (349)	9 1/4 (235)
750–1000** (325–500)	1.59–2.07 (40,4–52,6)	13 1/4 (337)	8 3/4 (222)

*For 100% and 133% insulation levels, Insulation OD is the final determining factor.

**Cables must be within the Insulation OD Range of the splice kit and the connector must meet the dimensional requirements shown on the front page.

- 1.2 Carefully bend neutral wires back over edge of cable jackets or bindings (CN). Press them firmly against cables and temporarily secure with vinyl tape.
- 1.3 Remove cable insulation for 1/2 connector length plus an allowance * for increases in connector length due to crimping. Insulation removal length shall not exceed 4 1/8 inches (105 mm) from conductor end. **Do not install connector now.**

**Note: This assumes that the installer has determined the increased length of an aluminum connector crimped with a specific tool and die.*

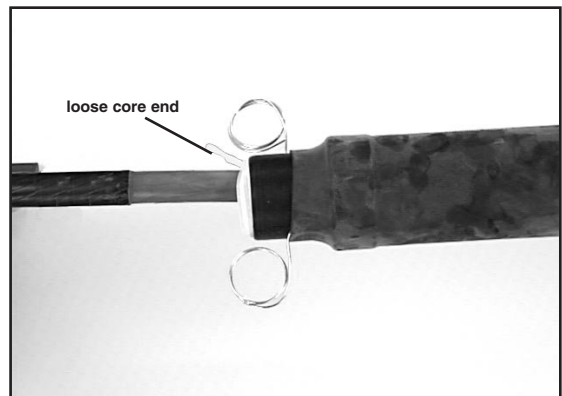


Aluminum (Al/Cu) Connector Growth Chart

Conductor Size	Typical length allowance (per end)
350 kcmil	1/4" (6 mm)
500 kcmil	1/4" (6 mm)
750 kcmil	3/8" (10 mm)
1000 kcmil	3/8" (10 mm)

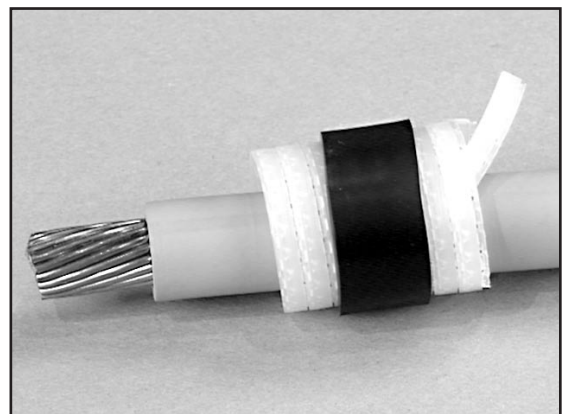
*Note: 1) Copper connectors do not require a length change allowance.
2) Maximum aluminum connector crimped length allowed is 8.25" (210 mm).*

- 1.4 Slide splice body onto cable, loose core end first.



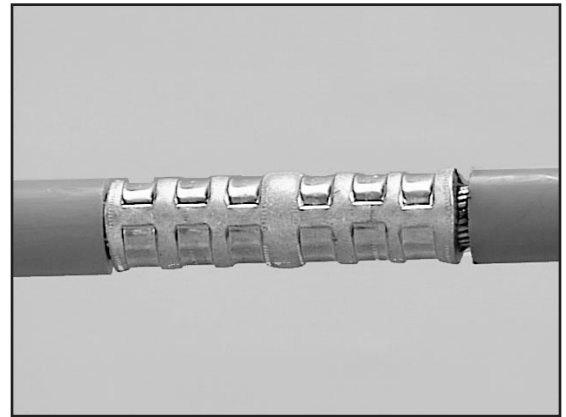
- 1.5 For 350 through 1000 kcmil copper connectors, 350 through 750 kcmil aluminum connectors, or connectors with an O.D. between 0.87" - 1.60" (22,1–40,6 mm):

Slide cold shrink adapter tube onto cable insulation.



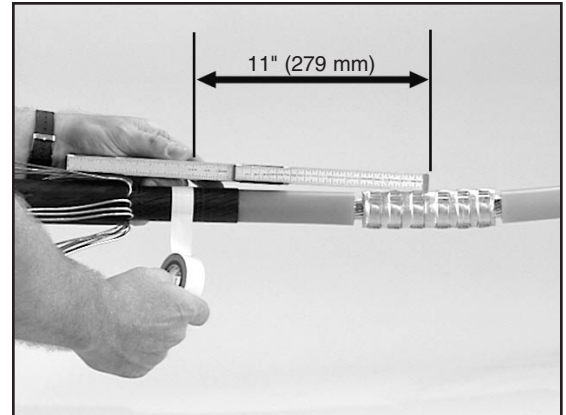
2.0 Install Splice

2.1 Install connector. See table (on cover) for proper connector dimensions. (For standard 3M™ connectors, refer to the table at the end of this instruction for crimping information.) Remove any excess oxidation inhibitor from connector ends if using an aluminum connector.



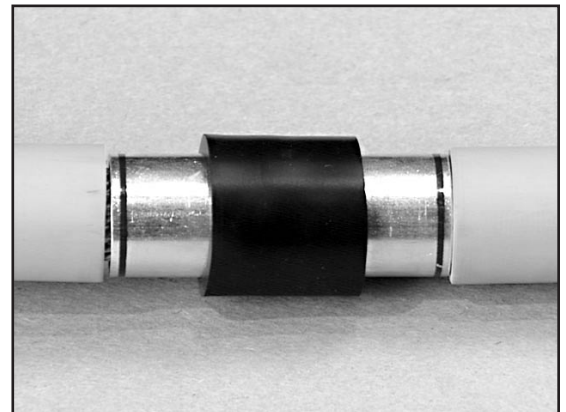
2.2 Apply a tape marker to semi-con insulation shield on cable which does not contain splice.

Measure 11" (279 mm) from center of connector.



2.3 **If using cold shrink adapter tube:**

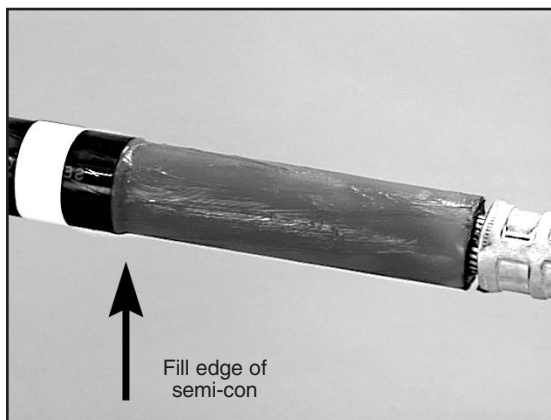
Position adapter tube over the connector. Shrink adapter near center of connector by pulling and unwinding the loose core end in a counter-clockwise direction.



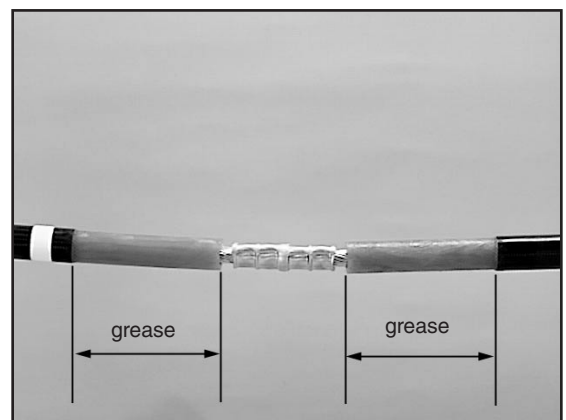
- 2.4 Clean cables using standard practice:
- Do not use solvent or abrasive on cable semi-conductive insulation shield.
 - If abrasive is used on cable insulation, do not reduce diameter below the 1.24" (31,5 mm) minimum specified for the splice.

2.5 Apply red compound on cable insulation, making certain to fill in edge of cable semi-cons.

Do not use silicone grease.

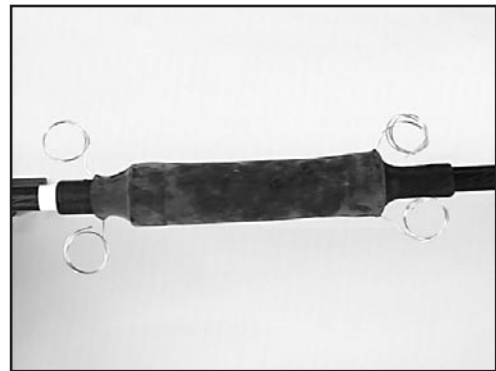
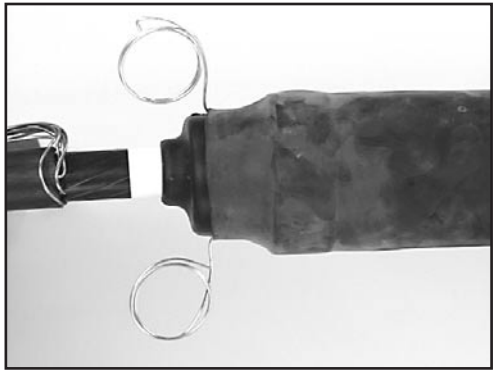


Compound filled at edge of semi-cons



Greased areas as noted

- 2.5 Position the splice body over connector area, aligning its end at the center of the tape marker. Slowly start to remove the splice core by pulling and unwinding the loose end counterclockwise, allowing only 1/4" (6 mm) of the splice to shrink onto the tape marker. Carefully slide the body off of the tape by pulling and twisting until the entire tape marker is exposed. Continue removing core to complete the splice body installation.



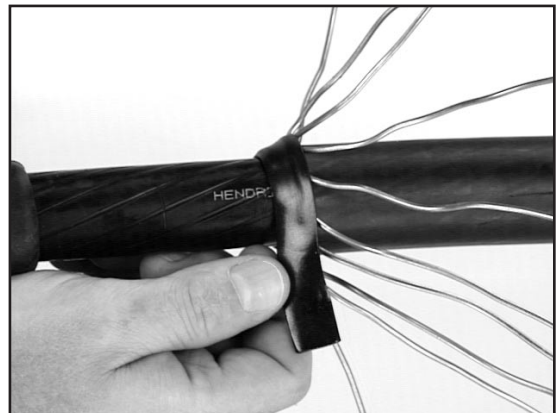
Note: The splice ends must overlap onto the semi-conducting layer of each cable, 1/2" (13 mm) minimum.

Note: While removing core, hold only onto the shrunk portion of the splice to maintain its alignment with the tape marker.

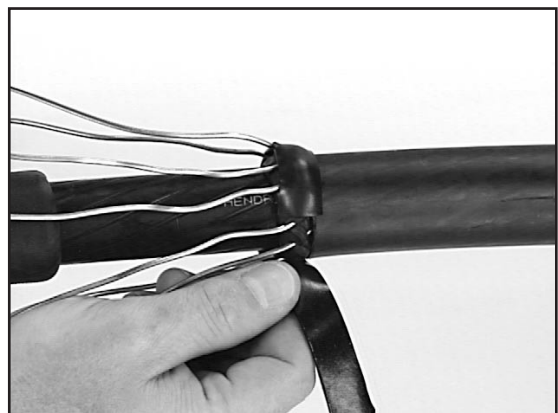
Note: Do not push the splice body towards the tape marker, as this may cause the end to roll under. If the end does roll under, DO NOT use sharp edged tools to pull it out as this could cut and damage the splice.

3.0 Optional - Sealing Jacket on JCN Cables

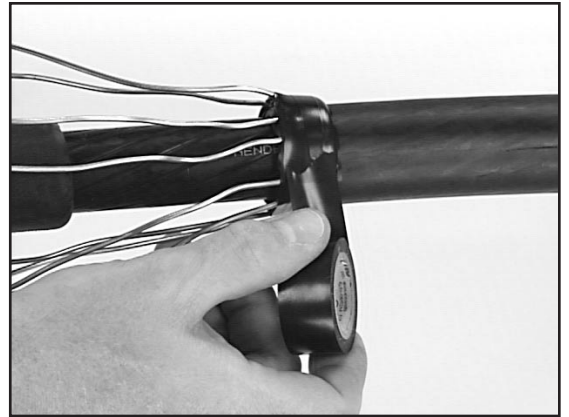
- 3.1 Wrap a mastic sealing strip against the neutral wires at the end of cable jacket.



- 3.2 Fold neutral wires over splice body and wrap another mastic sealing strip over the cable jacket end and the first mastic sealing strip.



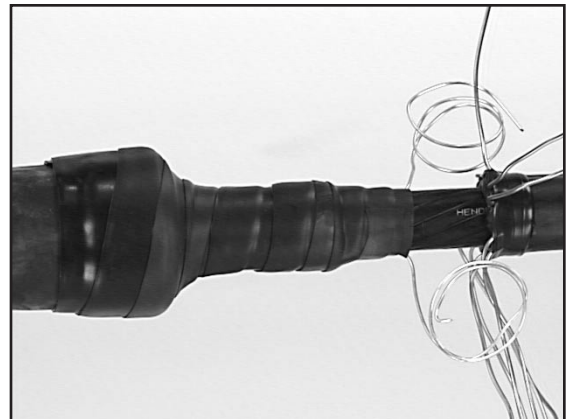
- 3.3 Cover mastic seals at each cable jacket with two wraps of vinyl tape.



4.0 Optional - Additional Protection for Splice Body

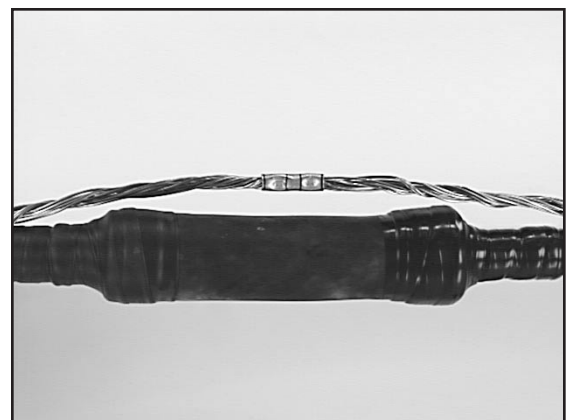
- 4.1 To further enhance protection of splice body from physical damage cover the splice body end seals with Scotch™ 2228 Rubber Mastic Tape (not supplied with kit).

Beginning 2" (25 mm) on splice wire cover tube apply one half-lapped layer onto the cable semi-con.



5.0 Connect Neutral Wires

- 5.1 Connect neutral wires and splice wires together using an appropriate "C", "H" or butt type connector.
- 5.2 Splice is complete.



Crimping Tool - Die Sets (number of crimps/end)

3M™ Connector Number	Conductor Size (kcmil)	Burdny			Thomas & Betts Corp.			Square D Co. Anderson Div.	
		Y34A	Y35, Y39 Y45*, Y46*	Y1000**	TBM 8	TBM 12	TBM 15	VC6-3** VC6-FT**	VC8C**
10011 (Cu)	350	A31R (2)	U31RT (2)	—	Red (3)	—	71H (3)	(2)	—
20011 (Al/Cu)	350	—	U31ART (2)	(1)	—	87H (3)	87H (3)	(2)	—
11011 (Cu)	350	A31R (3)	U31RT (3)	—	Red (4)	—	71H (4)	(3)	—
CI-350 (Al/Cu)	350	—	U31ART (2)	—	—	87H (2)	87H (2)	(3)	—
20012 (Al/Cu)	400	—	U32ART (4)	(1)	—	94H (4)	94H (4)	(2)	(2)
10014 (Cu)	500	A34R (2)	U34RT (2)	—	Brown (3)	—	87H (3)	(2)	—
20014 (Al/Cu)	500	—	U34ART (4)	(1)	—	106H (3)	106H (4)	(2)	(2)
11014 (Cu)	500	A34R (4)	U34RT (3)	—	Brown (4)	—	87H (4)	(3)	—
CI-500 (Al/Cu)	500	—	U34ART (3)	—	—	—	106H (3)	(3)	—
20016 (Al/Cu)	600	—	U36ART (4)	(1)	—	—	115H (3)	(3)	(3)
10019 (Cu)	750	—	U39RT (3)	—	—	—	106H (3)	—	—
20019 (Al/Cu)	750	—	U39ART (4)	—	—	—	125H (5)	(3)	(3)
11019 (Cu)	750	—	U39RT (5)	—	—	—	106H (4)	—	—
CI-750 (Al/Cu)	750	—	U39ART (3)	—	—	—	125H (3)	(3)	—
10024 (Cu)	1000	—	S44RT, P44RT (4)	—	—	—	125H (3)	—	—
20024 (Al/Cu)	1000	—	S44ART, P44ART (4)	—	—	—	140H (4)	—	—
11024 (Cu)	1000	—	S44RT, P44RT (4)	—	—	—	125H (4)	—	—

*Y45 and Y46 accept all Y35 dies ("U Series"). For Y45, use PT6515 adapter. For Y46, use PUADP adapter.

**Anderson VC6-3, VC6-FT, VC8C and Burdny Y1000 require no die set.

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Note: The core material being removed from the Splice Body and Jacket Tubes are mixed polymers and can be recycled with other waste.



Important Notice

Before using this product, you must evaluate it and determine if it is suitable for your intended application. You assume all risks and liability associated with such use.

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