**SHIELDED CABLE INLINE SPLICE**

**PREPARE CABLES (Figure 1)**
1. Thoroughly scrape jacket 3" beyond dimension A to remove all contaminants and make a moisture tight seal.
2. Prepare cable according to standard practice, see Figure 1.
3. CLEAN CABLE USING STANDARD PRACTICE:
   a. Use "Scotch" Brand Cable Prep. Kit 2, DO NOT ALLOW SOLVENT TO TOUCH SEMI-CON.

**APPLY SEMI-COATING TAPE — #13**
1. Fill indent in connector.
2. Wrap two half-lapped layers of 13 Tape over connector, exposed conductor and onto cable insulation for 1/16", HIGHLY ELONGATE 13 TAPE.

**APPLY HIGH VOLTAGE TAPE — #130C**
1. Build up 130C Tape over entire splice, including 1" onto cable jacket, and 1" along ground braid.

**CONNECATOR INSTALLATION**
1. Install connector following manufacturer's direction.
2. APPLY SEMI-COATING TAPE — #13
3. APPLY HIGH VOLTAGE TAPE — #130C
4. APPLY OUTER SEAL
5. APPLY SEMI-COATING TAPE

**ALL INFORMATION WITHIN THIS COLUMN APPLIES TO BOTH THE SHIELDED INLIN AND IEEE SPLICE**

**DIMENSIONS FOR XLP POLY AND EPR INSULATED CABLES**

**VOLTAGE (LEVEL)**

<table>
<thead>
<tr>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 KV</td>
<td>100% (133%)</td>
<td>4-3/4&quot;</td>
<td>3/4&quot;</td>
</tr>
<tr>
<td>15 KV</td>
<td>100% (133%)</td>
<td>6&quot;</td>
<td>3/4&quot;</td>
</tr>
<tr>
<td>15 KV (173%)</td>
<td>7&quot;</td>
<td>1&quot;</td>
<td>1/4&quot;</td>
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</tbody>
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**4. WIRE SHIELD PROCEDURE**
1. Thoroughly scrape jacket 3" beyond dimension A to remove all contaminants.
2. Prepare cable according to standard practice, see Figure 1.
3. CLEAN CABLE USING STANDARD PRACTICE.
4. Use "Scotch" Brand Cable Prep. Kit A-2, DO NOT ALLOW SOLVENT TO TOUCH SEMI-CON.

**APPLY SEMI-COATING TAPE — #13**
1. Wrap one half-lapped layer of 13 Tape over 13 Tape, overlapping 1/2" onto metallic shielding. Solder to metallic shielding.

**APPLY ELECTRICAL SHIELDING TAPE — #24**
1. Wrap one half-lapped layer of 24 Tape over 10 Tape, covering entire area of 24 Tape. Stretch tightly to flatten and confine 24 Tape.

**APPLY GROUND BRAID TAPE — #25**
1. Lay 25 Tape across splice and solder to metallic shielding.

**CONSTRUCT A MOISTURE SEAL**
1. Provide a solder block where braid leaves splice.
2. Wrap two layers of 130C Tape covering the end 2" of the cable jacket.
3. Wrap two half-lapped layers of 130C Tape for 3" around 25 Tape, beginning where 25 Tape is soldered to connector.
4. Lay braid over 130C Tape for 1" then bend braid away.

**APPLY OUTER SEAL**
1. Wrap four half-lapped layers of 130C Tape onto entire splice 2" onto cable jackets. HIGHLY ELONGATE, WRAP WITH TACKY SIDE OUT.
2. Wrap two half-lapped layers of 33 Tape onto splice, including 1" onto cable jacket, and 1" along ground braid.

**3M Systems for Splicing and Terminating.**

**CAUTION**
- TEE SPLICES REQUIRE A HIGH DEGREE OF SKILL TO CONSTRUCT. ON TEE SPLICES BE SURE TO HIGHLY ELONGATE ALL TAPES IN CROUCH AREA.

**PREPARE CABLES (Figure 1)**
1. Thoroughly scrape jacket 3" beyond dimension A to remove all contaminants.
2. Prepare cable according to standard practice, see Figure 1.
3. CLEAN CABLE USING STANDARD PRACTICE.
4. Use "Scotch" Brand Cable Prep. Kit A-2, DO NOT ALLOW SOLVENT TO TOUCH SEMI-CON.

**APPLY SEMI-COATING TAPE — #13**
1. Wrap one half-lapped layer of 13 Tape over splice, extending onto metallic shielding over 1/4", HIGHLY ELONGATE TAPE.

**APPLY ELECTRICAL SHIELDING TAPE — #24**
1. Wrap one half-lapped layer of 24 Tape over 10 Tape, overlapping 1/2" onto metallic shielding. Solder to metallic shielding.

**APPLY GROUND BRAID TAPE — #25**
1. Lay 25 Tape across splice and solder to metallic shielding.

**CONSTRUCTION A MOISTURE SEAL**
1. Provide a solder block where braid leaves splice.
2. Wrap two layers of 130C Tape covering the end 2" of the cable jacket.
3. Wrap two half-lapped layers of 130C Tape for 3" around 25 Tape, beginning where 25 Tape is soldered to connector.
4. Lay braid over 130C Tape for 1" then bend braid away.

**APPLY OUTER SEAL**
1. Wrap four half-lapped layers of 130C Tape onto entire splice 2" onto cable jackets, HIGHLY ELONGATE, WRAP WITH TACKY SIDE OUT.
2. Wrap two half-lapped layers of 33 Tape onto splice, including 1" onto cable jackets, and 1" along ground braid.

**SHAIELD CABLE TEE SPLICE**

**APPLICATION**
1. Wrap one half-lapped layer of 13 Tape, extending onto metallic shielding over 1/4", HIGHLY ELONGATE TAPE.

**APPLY ELECTRICAL SHIELDING TAPE — #24**
1. Wrap one half-lapped layer of 24 Tape over splice, extending onto metallic shielding over 1/4", HIGHLY ELONGATE TAPE.

**APPLY GROUND BRAID TAPE — #25**
1. Lay 25 Tape across splice and solder to metallic shielding.

**CONSTRUCT A MOISTURE SEAL**
1. Provide a solder block where braid leaves splice.
2. Wrap two layers of 130C Tape covering the end 2" of the cable jacket.
3. Wrap two half-lapped layers of 130C Tape for 3" around 25 Tape, beginning where 25 Tape is soldered to connector.
4. Lay braid over 130C Tape for 1" then bend braid away.

**APPLY OUTER SEAL**
1. Wrap four half-lapped layers of 130C Tape onto entire splice 2" onto cable jackets, HIGHLY ELONGATE, WRAP WITH TACKY SIDE OUT.
2. Wrap two half-lapped layers of 33 Tape onto splice, including 1" onto cable jackets, and 1" along ground braid.

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**TECHNICAL DATA:**
- **VOLTAGE RATING — 5 TO 15 KV**
- **DIMENSIONS AND MATERIAL REQUIREMENTS FOR INLINE SPLICES UP TO 60 KV AND TEE SPLICES UP TO 35 KV AVAILABLE ON REQUEST.
- **CONDUCTORS — COPPER OR ALUMINUM**
- **TEMPERATURE — 90°C MAX**
- **130°C EMERGENCY OPERATION**