

**A. Prepare Cables According to Standard Procedures Figure 1.**

1. Allow sufficient concentric neutral wire length to jumper across splice. Main illustration.
2. Gently fold neutral wires back over cable, avoiding sharp bends.
3. Continue cable preparation according to Figure 1.

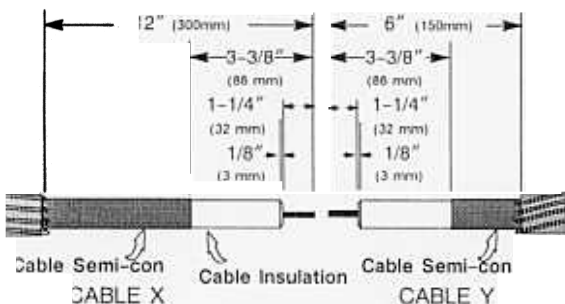


Figure 1

4. Clean cable using standard practice:
  - a. Do not use solvent or abrasive on cable semi-con insulation shield.

**B. Installation**

1. Place Porta-Pencil over conductor strands of Cable X. Large end should butt against cable insulation end. Figure 2.



Figure 2

2. Lubricate Porta-Pencil, cable insulation, splice bore and semi-con of Cable X, with silicone grease furnished.

3. Install splice body onto Cable X.

4. Remove Porta-Pencil, leaving conductor exposed for connector.

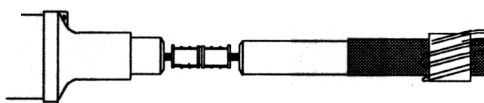


Figure 3

5. Install connector, using CI connector (or equivalent) crimped per table. NOTE: Do not crimp inside knurl region. Remove excess contact aid and file sharp connector flashing if present. Figure 3.
6. Slide splice body into final position over connector, using bumps formed on splice ends as guides for centering. Figure 4.

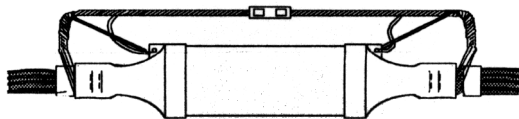


Figure 4

**C. Grounding Splice**

1. Position Cable X concentric neutral wires back along cable, taping down at edge of splice.
2. Attach one concentric strand from each cable through its respective grounding eye and back to concentric neutral wires.
3. Twist remaining conductors together, including grounding eye strand, and jumper across splice using an inline compression connector.

SPLICE SELECTION TABLE		CRIMPING TOOL TABLE				TECHNICAL DATA
Splice Body W/Connector	Cable Conductor Size	MFG.	MECHANICAL		HYDRAULIC	
			TOOL	DIE (Crimps Per End)	TOOL	DIE (Crimps Per End)
5411A-CI-1	#1 Str & 1/0 Solid	BURNDY	MD6	BG (3), W-BG (2)	Y-35, Y-39, Y-45 *	U25 ART (1)
		KEARNEY	0-52, 0-51	5/8 (3)	WH-1, WH-2	5/8 (3)
5411A-CI-1/0	1/0 Stranded	T&B	TBM-8	OLIVE (2) **	TBM-15	50 (1) **
5411A-20006	2/0 Stranded	ANDERSON	-	-	VC6	UNIVERSAL (1)

\* - Usable with U - Die Adapter PT 651  
 \*\* - Excess Flash Must Be Filed Off to Round Out Connector

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 Seller's and manufacturer's only obligation shall be to replace such quantity of the product proven to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential, arising out of the use of or the inability to use the product. Before using, user shall determine the suitability of the product for the intended use, and user assumes all risk and liability whatsoever in connection therewith.  
 Statements or recommendations not contained herein shall have no force or effect unless in an agreement signed by officers of seller and manufacturer.

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NOT TO SCALE		CH. DCR	
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3M Electrical Products Division Austin, Texas 78769-2963 Made in U.S.A.			

**3M Quick Splice II Molded Rubber Splicing Kit 5411A**  
 For Concentric Neutral (URD) Cable  
 Primary insulation O.D. Range: .775-.90 inches (19.7-22.9 mm)  
 Conductor Size - #1 Str and 1/0 solid (220 mills only)  
 1/0 Str AWG (220 mills only)  
 2/0 Str AWG (175 mills only)  
 15 kV Class