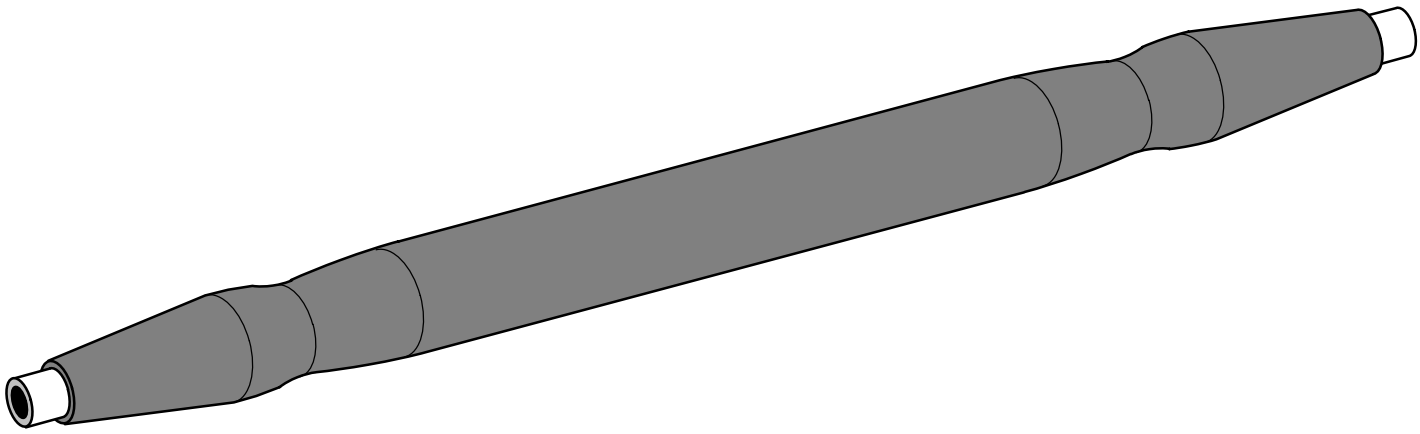
3M QS 2000



Kit no	Diameter over Cable Jacket max. (mm)	Diameter over Insulation E (mm)	Cross Section (mm^2)	Diameter over Connector (mm)	Connector Length max. (mm)
94–AP631–1	56	28.4 – 42.0	120 – 400	23.3 – 42.0	170

3M Laboratories (Europe)
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3M QS 2000

INLINE SPLICE

Type

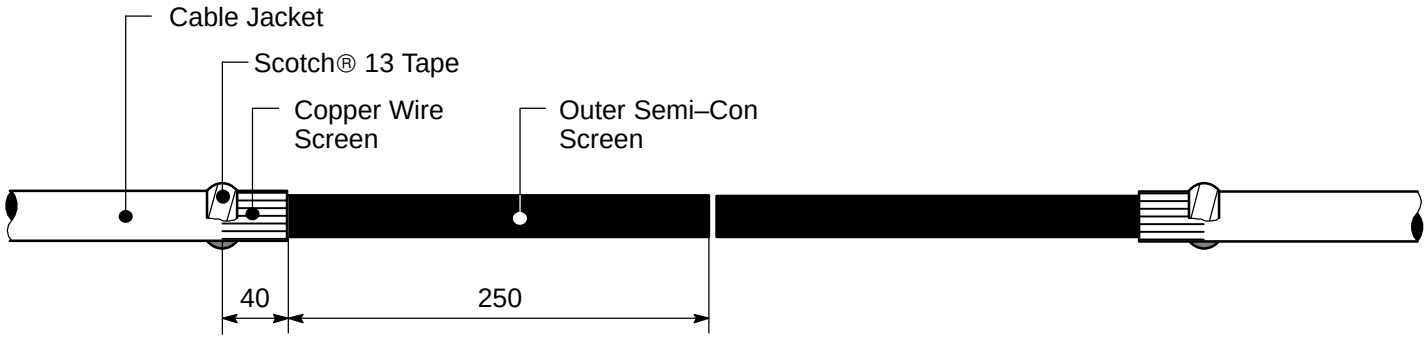
94–AP631–1

with Cold Shrink Rejacketing for polymeric single core cables with copper wire screen acc to VDE 0276–620 (IEC 60502) up to 36 kV

3M ELECTRICAL PRODUCTS

XE 0091–2371–4

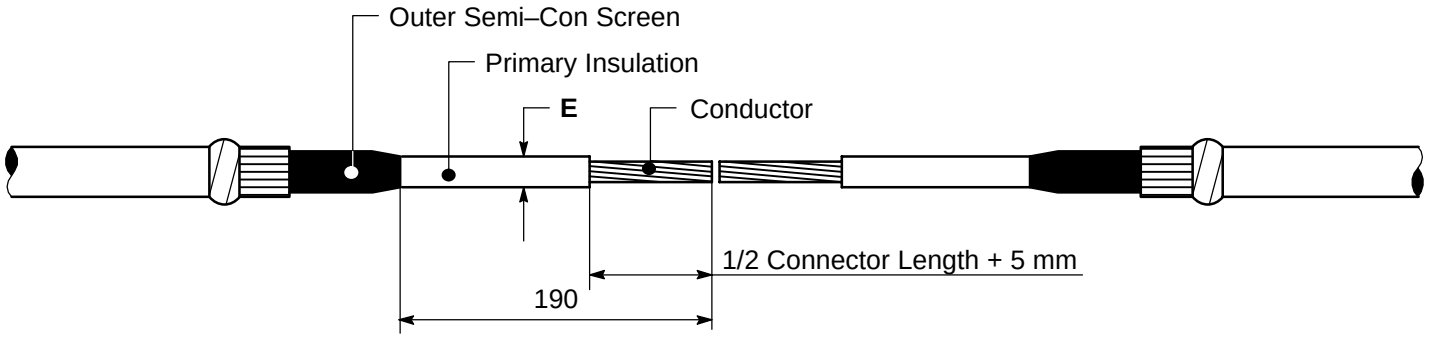
1



1.1 Remove cable jacket for 250 mm. Clean cable jacket for approx 150 mm.
1.2 Bend the copper wire screen back onto the cable jacket, cut the wires for 40 mm and fix them with two layers of Scotch® 13 tape.

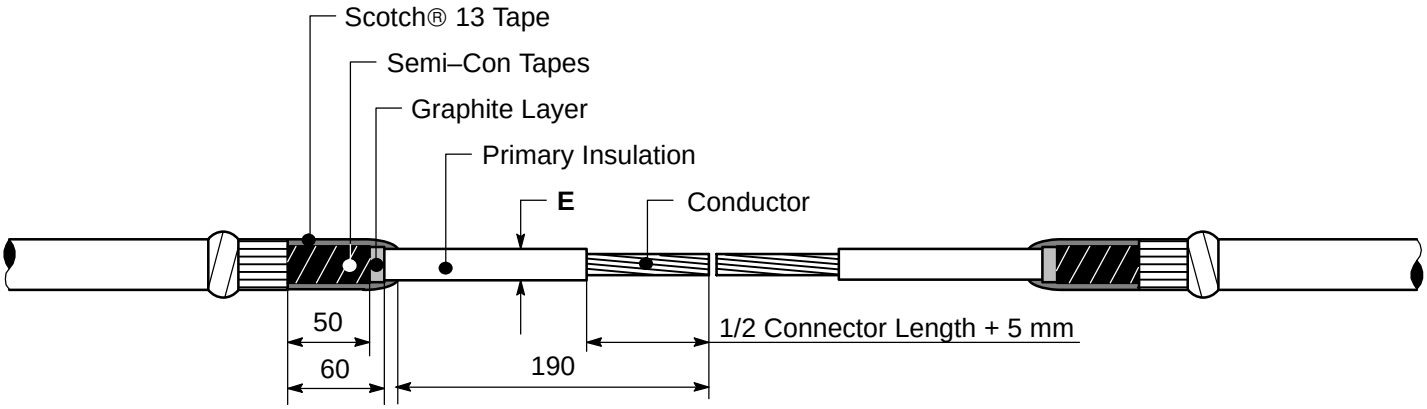
2

Cable with extruded Semi–Conductive Screen



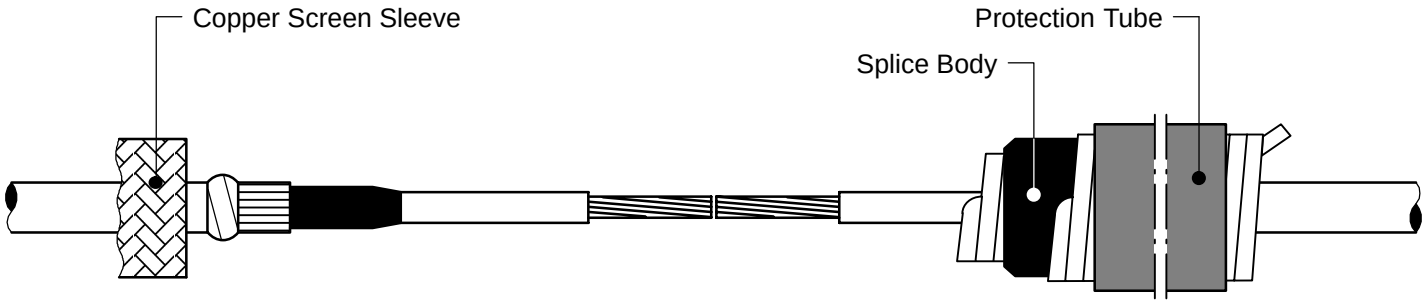
2.1 Remove cotton tapes.
2.2 Remove outer semi–con acc to given dimension.
2.3 Remove primary insulation for 1/2 connector length + 5 mm.

Cable with Graphite Layer and Semi–Conductive Tapes



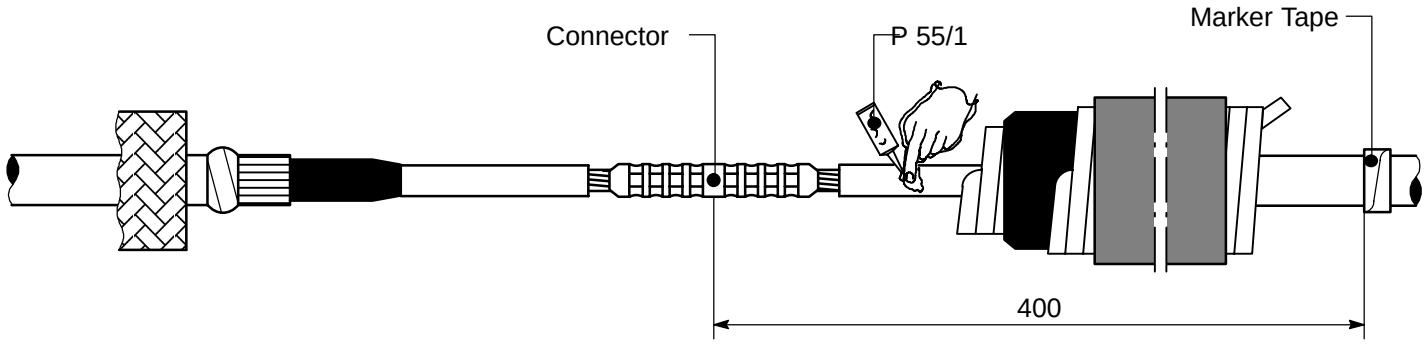
2.1 Remove semi–con tapes leaving 50 mm in front of the cable jacket.
2.2 Remove graphite layer leaving 60 mm in front of the cable jacket.
2.3 Apply one half–lapped layer of Scotch® 13 tape from the semi–con tapes onto the primary insulation acc to given dimension and back again.
2.4 Remove primary insulation for 1/2 connector length + 5 mm.

3



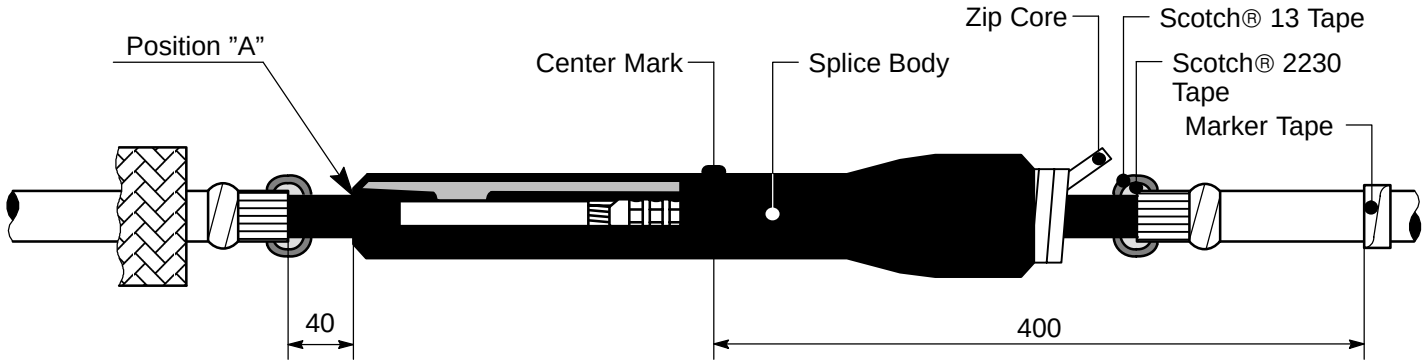
3.1 Position the splice body, protection tube and copper screen sleeve on the cable ends. Use polybag as protection.

4



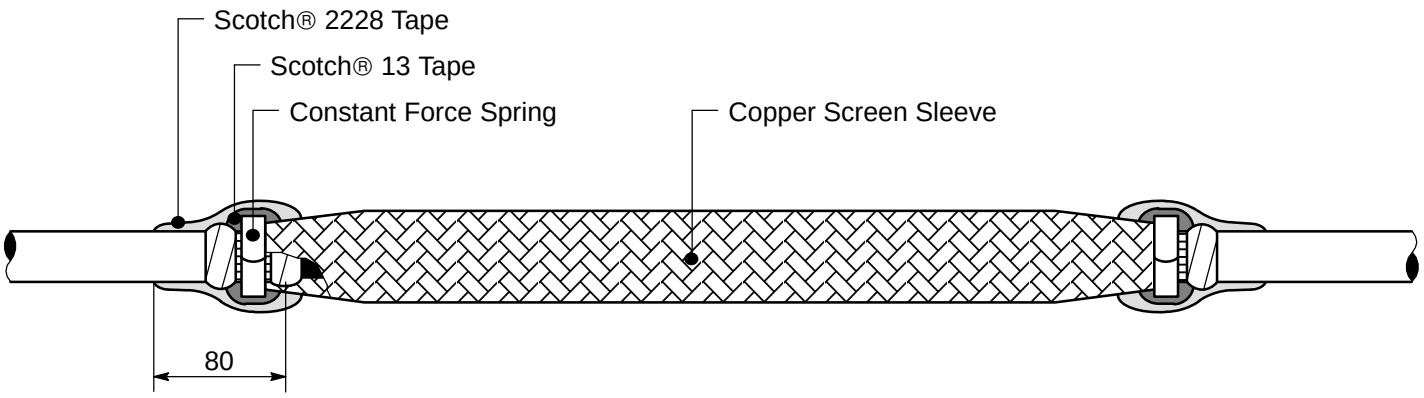
4.1 Crimp the connector, remove the excess grease, smooth and clean the connector.
4.2 Apply a marker tape to the cable jacket by measure 400 mm from center of the connector.
4.3 Check diameter over connector. If less than stated in the selection table, apply Scotch® 13 tape over the connector up to the required diameter.
4.4 Apply a liberal amount of P55/1 over the end of the semi–conductive layer, onto the exposed cable insulation and connector using the plastic glove provided.

5



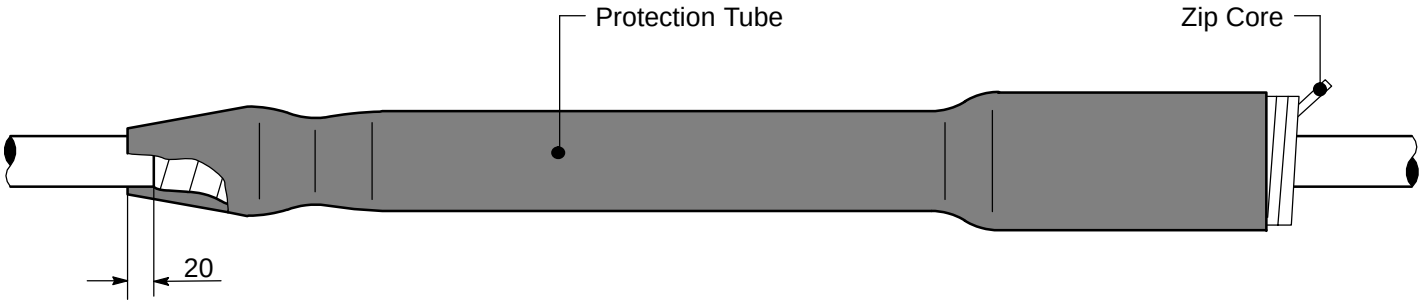
5.1 Slide the splice body over the connection until position ”A”.
5.2 Shrink the splice body into position by pulling out and unwinding the core in counter clockwise direction.
5.3 Ensure the splice body is centered considering the control dimension 400 mm.
5.4 Remove marker tape.
5.5 Apply one layer of Scotch® 2230 tape in front of the cable jacket and 5 mm onto the cable jacket. Overtape the Scotch® 2230 tape with two layers of Scotch® 13 tape.

6



6.1 Slide the copper screen sleeve over the splice body and fix it by means of a constant force spring on the copper wire screen. Cut of the remaining wires of the sleeve.
6.2 Overtape the constant force spring with two layers of Scotch® 13 tape.
6.3 Overtape the Scotch® 13 tape, copper wires and cable jacket with Scotch® 2228 tape acc to given dimensions.

7



7.1 Slide the protection tube over the connection and start to shrink by pulling out and unwinding the zip core in counter clockwise direction. Start to shrink 20 mm in front of the sealing.