

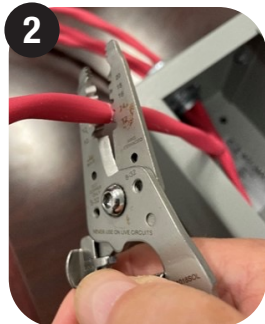


Bill of Materials	Processing at Assembly
6 - Each Ideal Steel Crimp Sleeves Part # 30-410 (SW Supply)	Add to Package
6 - Each 1/2" X 10" Quartz Epoxy Tape Article #1509A7D2 (SW Supply) Layer A Insulating tape	Trim, Cut to Width, and Package
6 - Each 1/2" X 10" Wacker Si Rubber Wacker# 512/70 Ceramifiable Silicone (SW Supply) Layer B Insulating Tape	Mill Roll, Trim, Cut to Width, and Package
2 Each MOPP Sheets for Both Sides of Si Rubber to Prevent Sticking	Protector for Wacker Rubber on Both Sides
1 - Wiegmann# HS441NK-N1 or Larger Wire Way - Customer Supplied	
1 - Ideal Crimp Tool - Customer Supply	
1 - Each Corrugated Box # 66534701/Mailer	Insert Contents, Seal, and Label
1 - Each Instructions	Print, Fold, and Insert
1 - Each 4" X 5" Label	Print and Place on Package

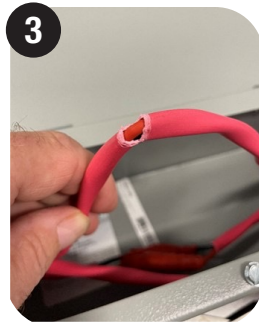
INSTRUCTIONS



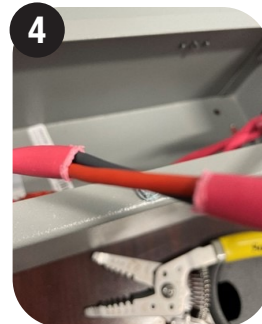
1 Identify the 2 cables to be spliced



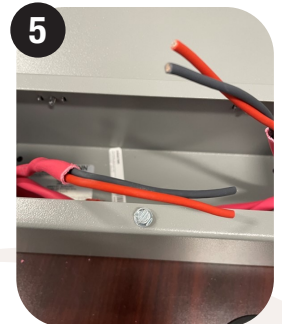
2 Using cable strippers simply score the jacket on its outer surface at least 3" from the cable end



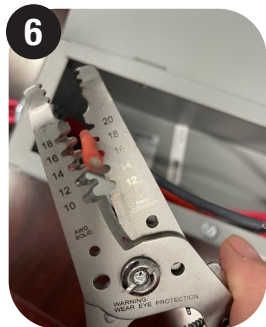
3 Bend cable end holding onto the opposite side of the score creating a break in the jacket



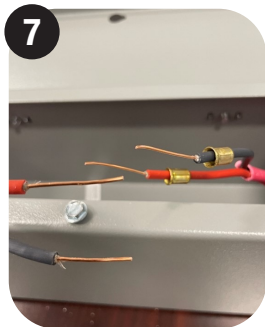
4 Continue this process until the circumference is separated



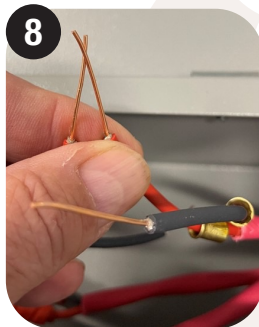
5 Once the jacket is separated pull it off from the cable end to expose the red and black conductors



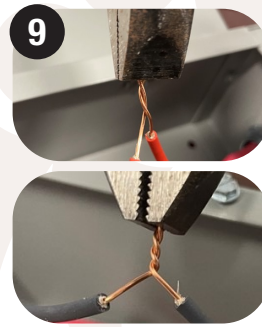
6 Using the same cable strippers, strip the end insulation and tape 1/2" - 3/4" from the conductors leaving bare copper exposed



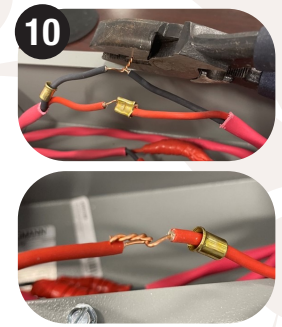
7 Place the Ideal Crimp bushing on the 2 conductors with the bell toward each conductor's cut end



8 Take the 2 conductors to be spliced and form a right hand crossover near the end of the bare copper (Approximately 1/8")



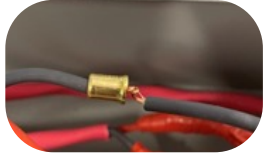
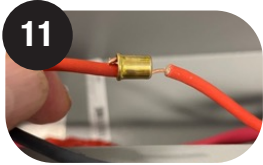
9 Grab the bare copper ends with Ideal lineman pliers and twist clockwise until you have approximately 1/4" of untwisted bare copper on one conductor



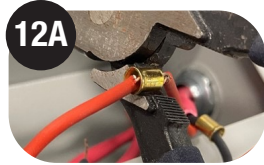
10 Trim twisted conductors to approximately 1/4" of twisted bare copper and bend over the 1/4" of bare lead conductor



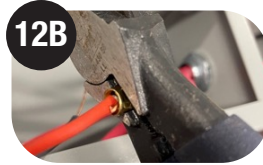
INSTRUCTIONS CONT.



Slide the bell end of the crimp bushing over the spliced conductors



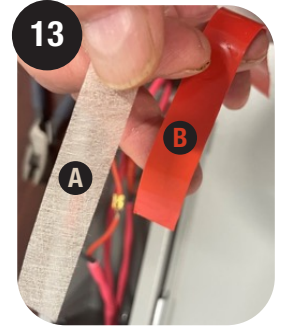
Crimp the bushing twice for secure termination



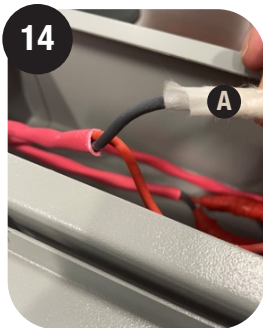
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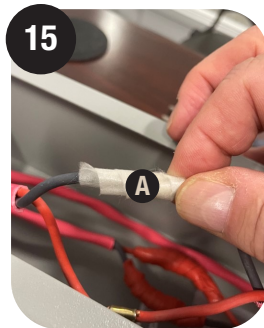
Crimp



Now place tape A (Quartz fiber tape) over the end of the insulation on one end



Begin helically applying tape A over the spliced connection with 50% overlap as shown



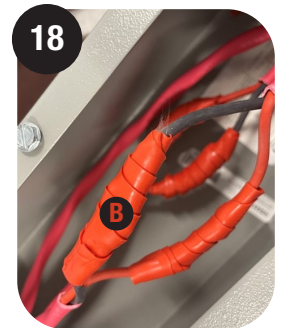
When you get to the opposite end of the splice with a full wrap over that conductor insulation simply tear and discard the excess



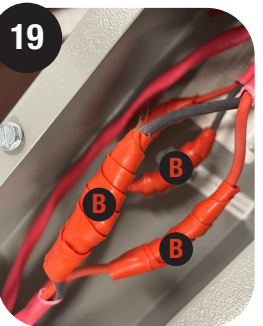
Be sure to hold onto the tape A unsecured end as you begin to apply tape B (Silicone Rubber Tape) in the reverse direction over the splice with 50% overlap as well



Make certain that tape B covers tape A



When this is completed wrap the splice with your hand applying light pressure to secure the assembly



Repeat these steps for each of the spliced conductors

For more information, please contact
CableTechSupport@Southwire.com