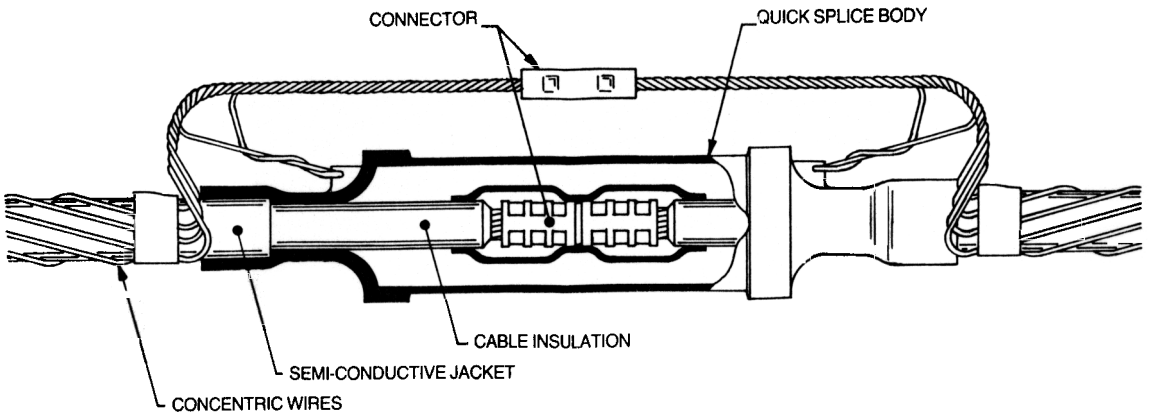

CAUTION: *Check insulation diameter. It must be between .637 (16,2) and .900 (22,9) inches (mm).*

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 and the Connector and Dimension Tables.

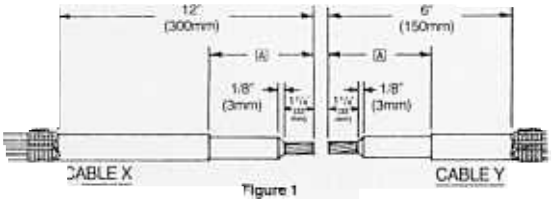

Figure 1

4. Clean cable using standard practice:
   a. Do not use solvent or abrasive on cable semi-con jacket.
   b. If abrasive must be used, do not reduce cable diameter below that specified for splice.

B. Installation

a. Lubricate insulation of both cables and semi-con jacket of Cable X, with silicone grease furnished.
2. Install splice body onto Cable X, leaving conductor exposed for connector (Figure 2).

   Tip: Lubricate bore with silicone grease to aid application.

Figure 2

3. Install connector, using CI connector (or equivalent) crimped per table. Remove excess contact aid and file sharp connector flashing if present.
4. Slide splice body into final position over connector, using bumps formed on splice ends as guides for centering (Figure 3).

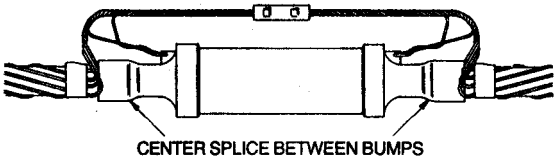

Figure 3

C. Grounding Splice (Figure 3)

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 splice 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.

CONNECTOR AND DIMENSION TABLE

CONDUCTOR SIZE (AWG)		CONNECTOR DESIGNATION	DIMENSION A INSULATION LEVEL	
STRANDED	SOLID		100% (.175")	133% (.220")
—	#2	CI-22		
#2	#1	CI-21	3⅛" (92 mm)	3⅝" (95 mm)
#1	1/0	CI-21		
1/0	—	CI-1 0		
2/0†	—	20008		—

TRANSITION CONNECTOR AND DIMENSION TABLE

CONDUCTOR SIZES (AWG) FROM CABLE X ...		...TO CABLE Y		CONNECTOR DESIGNATION	DIMENSION A INSULATION LEVEL
STRANDED	SOLID	STRANDED	SOLID		100% (.175") and 133% (.220")
#4	#2	#1	1/0	CI-T-1	
#2	#1	#1	1/0	CI-T-2	
#4	#2	1/0	—	CI-T-3	3⅛" (89 mm)
#2	#1	1/0	—	CI-T-4	
#2	#1	#4	#2	CI-T-5	

CRIMPING TOOL TABLE

CABLE SIZE	MFG.	MECHANICAL TOOL	MECHANICAL DIE (Crimps Per End)	HYDRAULIC TOOL	HYDRAULIC DIE (Crimps Per End)
2 AWG TO 2/0	BURNDY	MD6	BG (3)	Y-35, Y-39, Y-45*	U25 ART (1) U243 (1)
	KEARNEY	0-52, 0-51	5/8-1 (3)	12,20 & 40 TON	5/8-1 (3)
	T & B	TBM-8	OLIVE (2)**	TBM-15	50 (1)**
	ANDERSON	—	—	VC6	UNIVERSAL (1)

* Usable with U-Die Adapter PT 851
** Excess Flash Must Be Filed Off To Round Out Connector
† .175" Insulation Thickness Only

TECHNICAL DATA

VOLTAGE RATING 15 KV

FOR CABLES RATED 90°C COND. TEMP.

AL OR CU. COND.

PASSES TESTS REQUIRED IN IEEE STANDARD 404-1977 FOR POWER CABLE JOINTS

ISSUE	DATE	REV.	CH.
3	13 JUNE 83		
NOT TO SCALE		CH.	Rym
DR.	J.F. KRENIK	APP.	W.F.V

2047T25

Electro-Products Division/3M
St. Paul, MN 55101 Made in U.S.A.

3M QUICK-SPLICE II

Inline Splicing Kit

5411

For use on Concentric Neutral (URD) Cable

Conductor Size

#2-2/0 AWG (0.175" Insulation Thickness)
#2-1/0 AWG (0.220" Insulation Thickness)

Insulation O.D.

.637" (16,2mm) to .900" (22,9mm)