

Electrical Penetration Test Sample  
Splice Procedure

I. PURPOSE

The purpose of this procedure is to prepare the three test samples types of electrical penetration/cable splice systems.

II. REFERENCE

The electrical penetration Test Specification is attached.

III. PREREQUISITES

None

IV. PRECAUTIONS AND LIMITATIONS

SIGN OFF/DATE

1. Insure Q.C. is notified for those steps requiring Q.C. signoffs.
2. Use care when handling the assemblies to avoid the cracking of the pigtailed.

\_\_\_\_\_/\_\_\_\_\_  
\_\_\_\_\_/\_\_\_\_\_

V. EQUIPMENT CHECKLIST

1. 3-7/C #10 Conax subassemblies, No. 2325-7780-13
2. 3-12/C #12 Conax subassemblies, No. 2325-7780-03
3. 3-16/C #14 Conax subassemblies, No. 2325-7780-15
4. 30 ft. W 35 7/C #10 Cable
5. 30 ft. W 42 12/C #12 Cable
6. 60 ft. W 63 3 pair ST with drain wire #14 Cable
7. See GSEE 0510 splice specification for material for test samples 1 and 2. Sizes are based on items 1 through 6 above.
  - a. Amp Solistrand Butt Splices
  - b. Crimping Tool
  - c. Amp Special Tubing
  - d. GE Irrathane Tape, 1" wide

- e. Dow Corning 732 RTV
- f. Pentube VII B Tubing
- 8. Dow Corning 3145 Clear RTV as required
- 9. Dow Corning 1204 Prime Coat as required
- 10. 1.1.1 Trichoroethane or equivalent as required
- 11. Raychem Heat Shrink Tubing
  - 370 ft spool            WCSF-115-XN coated
  - 4 each                    WCSF-650-9N coated
  - 40 each                   WCSF-200-6N coated

VI. PROCEDURE

SIGN OFF/DATE

1. Notify QC at the start of work. \_\_\_\_\_ /
2. Using the attached GSEE 0510 splice each of the 3 types of penetration subassemblies to the cable according to the following Table 1:

Table 1

<u>Penetration</u>	<u>Cable</u>	<u>Span Leads</u>
7/C #10	W 35	None
12/C #12	W 42	None
16/C #14	W 63	2*

\*One drain wire on each cable will not be connected (two cables are required) each spare drain wire should be sleeved with heat shrink tubing.

All cable samples are to be 10 ft. long. GSEE 0510 is provided as Appendix 1 to this procedure. \_\_\_\_\_ /

3. Q.C. is to inspect the completed splice. \_\_\_\_\_ /
4. On the three test samples coated with RTV, repeat steps 1-3 on the uncoated pigtail. \_\_\_\_\_ /
5. Clean the samples completed in step 4 using trichlorethane or equivalent from the exposed teflon lead wire to 4 inches of cable jacket beyond the splice. \_\_\_\_\_ /
6. Using Dow Corning 1204 Prime Coat, prime the seal, penetration lead wires, splice outer jacket, and 4" of the cable jacket. \_\_\_\_\_ /
7. Using Dow Corning 3145 Clear RTV, apply an 1/8" thick coat to the lead wires, the splice jacket and 4 inches of cable jacket beyond the splice. \_\_\_\_\_ /
8. Q.C. is to inspect the splices made up in step 4, 5, 6, and 7. \_\_\_\_\_ /
9. Using the fabrication procedure contained in Appendix 2, fabricate the 3 remaining test splice systems using the configuration of Table 1 in step 2. \_\_\_\_\_ /
10. Q.C. is to inspect splices as constructed in step 9. \_\_\_\_\_ /

Remarks: \_\_\_\_\_  
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Completed by: \_\_\_\_\_ Date \_\_\_\_\_

Appendix 1