

CABLE END CAPS PERMANENT CABLE END SEALS

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1. GENERAL

1.01 This section describes a method of placing a permanent-type seal on the ends of lead- or polyethylene-sheathed cables. The heat-shrinkable caps used in this method provide a positive pressure and watertight seal.

1.02 Complete instructions for placing heat-shrink material may be found in Section 627-395-330, Thermofit* Sleeve — Description and Use.

1.03 The Raygun Torch Light shall be used in locations where the use of an open flame is prohibited.

2. PRECAUTIONS

2.01 Safety goggles and protective leather gloves must be worn when using the open flame torch or Raygun and when cleaning cable sheaths.

2.02 Remove the valve core from the valve-type caps before applying heat.

2.03 Use extreme caution when handling the heating equipment. Secure loose fitting clothing and direct heat source away from the worker at all times.

2.04 During the shrinking process, keep the torch approximately 12 inches from the cap at all

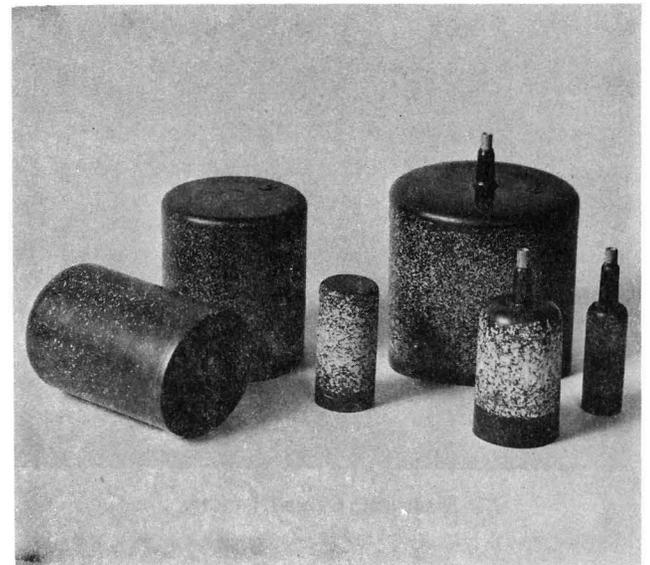
times. Keep the torch moving. Do not concentrate heat. Do not touch the cap with the torch as this may cause the material to split.

2.05 Allow no sharp points to protrude from the cut cable ends.

3. DESCRIPTION

3.01 The caps are made of a durable crosslinked polyolefin material that shrinks when heat is applied. The inner adhesive provides the seal when activated during the heating process.

3.02 Two types of caps are available, Flat (FEC) or Valved (VEC), as shown in Fig. 1.



Flat and Valved Heat-Shrink End Caps
Fig. 1

*Registered trademark of the Raychem Corporation

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3.03 The caps are available in six sizes as shown in Table A.

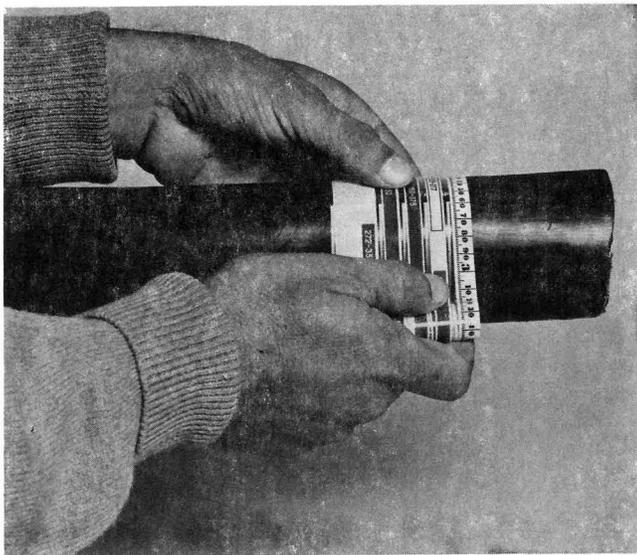
TABLE A

CABLE DIAMETER (INCHES)	FLAT END CAP (FEC) PART NUMBER	VALVED END CAP (VEC) PART NUMBER	"X" (INCHES) SEE PARA. 4.03
.4 - .8	FEC 1	VEC 1	2.0
.8 - 1.1	FEC 2	VEC 2	2.5
1.1 - 1.7	FEC 3	VEC 3	2.5
1.7 - 2.6	FEC 4	VEC 4	3.5
2.6 - 3.2	FEC 5	VEC 5	3.5
2.6 - 4.1	FEC 6	VEC 6	3.5

4. INSTALLATION

4.01 Cut the cable squarely and cleanly. Allow no sharp edges or points to protrude.

4.02 To ensure that the right cap is used, measure the cable diameter as shown in Fig. 2 and check Table A.



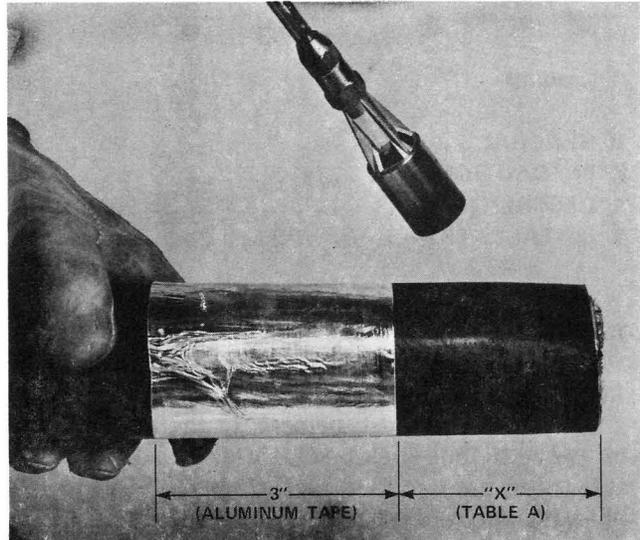
Measuring Cable Diameter
Fig. 2

4.03 Clean and scuff the cable with a B Carding Brush. Do not brush horizontally. See Table A, column "X" (Inches), for length of cable to clean.

4.04 When a cap is placed on a polyethylene sheath cable, the sheath must be protected with a 3-inch minimum wrap of B Aluminum Tape.

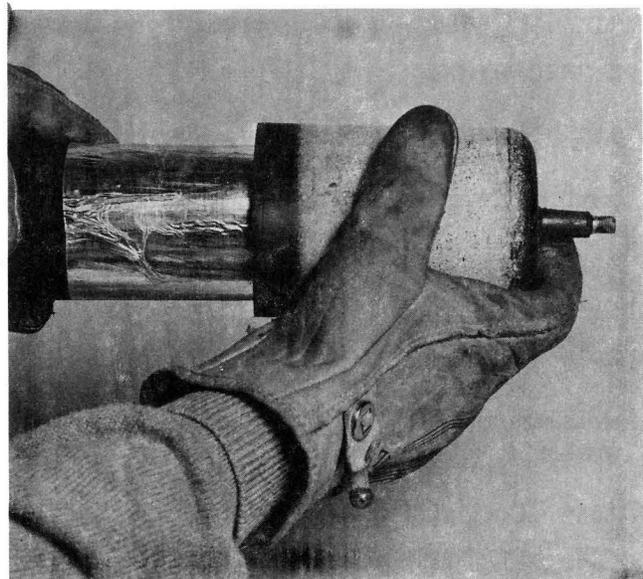
Start the tape at the edge of the "X" measurement as shown in Fig. 3.

4.05 Brush the cable with the tip of the torch flame until it is warm to the touch. (See Fig. 3.) Use the FH 2605 Propane Torch or AD-1455 Acetylene Tip as listed in Section 627-395-330.



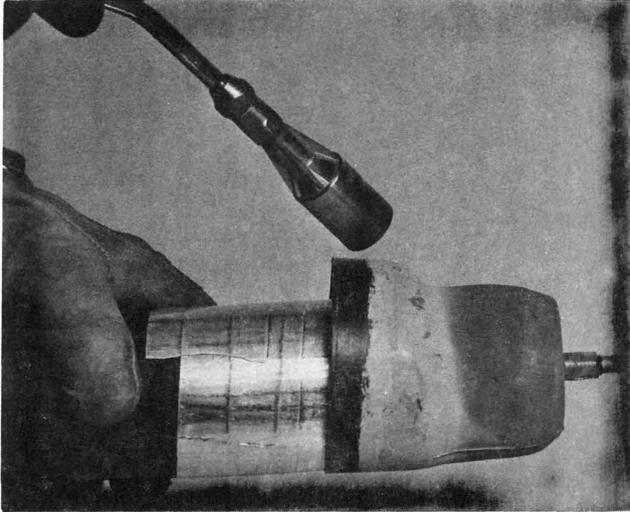
Aluminum Tape Protection and Preheating Operation
Fig. 3

4.06 Remove the small paper label that indicates size range from the cap. Place the cap, as far as it will go, onto the cable as shown in Fig. 4. Remember to remove the valve core.



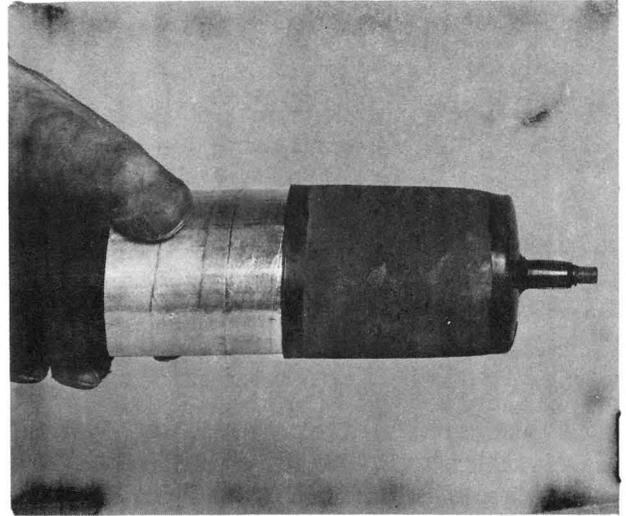
Placing Cable Cap
Fig. 4

4.07 Apply the heat uniformly around the cap's circumference. Heat until the heat-sensitive paint changes from blue to a yellowish-brown and the adhesive runs from the end of the cap. (See Fig. 5.)



Applying Heat to the Cap
Fig. 5

4.08 Allow the cap to cool to the touch before handling or applying pressure. If a valve cap is used, install the valve core. Fig. 6 shows the completed job.



VEC Cap Installed
Fig. 6