

**BELL SYSTEM PRACTICES**  
**Outside Plant Construction**  
**and Maintenance**

**SECTION G31.121.3**  
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**AT&T Co Standard**

## **OPEN WIRE**

### **PRESSED SLEEVE JOINTS**

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#### **1. GENERAL**

1.01 This section describes the method of making pressed sleeve joints in copper, copper-steel and steel line wire, in river crossing wire, and in river crossing strand, using S Sleeves and Sleeve Pressers.

#### **2. MAKING PRESSED JOINTS**

2.01 Clean the ends of the wire or strand which will enter the sleeve. Remove all corrosion with standard abrasive cloth. Any oil or grease on the wire must be removed.

2.02 On badly rusted or pitted river crossing wire, or river crossing strand, gauge the diameter of the cleaned section for minimum size, as follows:

(a) **River Crossing Wire**—Use the bore of a 134 S Steel Sleeve as a gauge. If the cleaned end of the wire will enter the large bore, the wire is too small to make a satisfactory joint, and should be replaced rather than spliced.

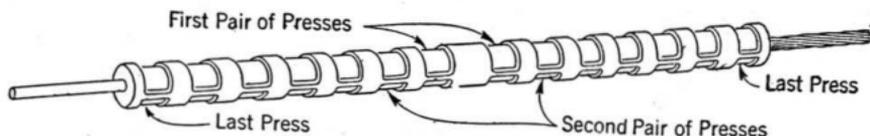
(b) **River Crossing Strand**—If the cleaned end of the strand will enter the 165 end of a 207 x 165 Combination S Steel Sleeve, the strand is too small to make a satisfactory joint, and should be replaced rather than spliced.

2.03 Standard sleeves have a dent at the midpoint beyond which the wire or strand can not pass. Cut the ends of the wire or strand at the desired point. Make sure that the wire or strand is straight and remove any burrs on the cut end before pushing the wire or strand in the sleeve. Push the cleaned end of the wire or strand into the sleeve until it reaches the stop at the center. To hold the sleeve on the wire until it has been

pressed, dent the sleeve with the cutting edges of side cutting pliers at a point about one-quarter inch from the outer end of the sleeve.

2.04 Press each end of the sleeve. The type of sleeve presser to be used and the number of presses required for each size of sleeve are shown in the table of Pressed Sleeve Joints in Section G31.121.1.

2.05 Make the first pair of presses as shown on the following illustration :



Make the required number of presses on each half of the sleeve. The presses should be evenly spaced. In making each press, the handles of the sleeve presser should be closed until the stops on the handles come in contact. **As the outer end of the sleeve is approached, space the presses so that a press of full width can be made close to the end of the sleeve, thus sealing the end of the sleeve against moisture.**