

## **CABLE SPLICING — GENERAL**

### **MANUFACTURING DEFECTS**

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#### **1. GENERAL**

1.01 This section describes the factory method of marking cable to indicate the presence of manufacturing defects or irregularities inside the cable and the method of tagging the defective conductors. It is reissued to include the use of flexible rubber tubing in place of metal bead markers and linen tags and a new method of removing pulling eyes.

#### **2. MARKING CABLE**

2.01 Both ends of a cable length containing manufacturing defects or irregularities are painted red at the factory to indicate the presence of identifying markings inside the ends.

2.02 The placing forces may cut a cable end to make a core hitch or may cut a long length into two or more short lengths. If the cable involved in such operations has red painted ends, it is required that the placing forces paint the cut ends with green paint or attach a suitable tag to indicate that it may be necessary to identify the manufacturing defects by testing. The markings at the opposite end of the cable length will facilitate such testing, if this is one of the ends painted red.

### 3. MARKING PAIRS

- 3.01 Defective or irregular pairs are marked at both ends of the cable by means of colored flexible rubber tubes.
- 3.02 The rubber tubes are placed over the two wires of each defective small-gauge pair or over one wire of any 16-gauge pair and then slipped along the pair into the core.
- 3.03 The various defects are shown by color code of the tubes as follows:

COLOR OF TUBE	NATURE OF TROUBLE
Black	Short Circuited Pair
Yellow	Break in conductor
White	Conductor of a pair crossed with a conductor of another pair. The numerals associate the crossed conductors in sets.
Green	Pair appears at only one end
Red	Pair with wrong gauge conductors
Blue	Replacement pair (misplaced) to compensate for a pair appearing at only one end or for a pair with wrong gauge conductors. Will have correct color but will not be in proper location.
Pink	High capacitance unbalance between pairs.

### 4. MARKING QUADDED CONDUCTORS

- 4.01 Defective or irregular quads are marked at both ends of the cable by means of colored rubber tubes.
- 4.02 The colored rubber tubes are placed on each defective 19-gauge pair or one wire of any 16-gauge pair involved.
- 4.03 The various defects are shown by the color code of the tubes as follows:

COLOR OF TUBE	NATURE OF TROUBLE
Tan	High Phantom to Side Capacitance Unbalance
Tan	High Side to Side Capacitance Unbalance
Pink	High Phantom to Phantom Capacitance Unbalance
Pink	High Capacitance Unbalance 19 Gauge Phantom to 16 Gauge Pair.

## 5. STUBS ON LOADING COIL CASES

5.01 A colored rubber tube on any unit whether pair, quad or combination of pairs and quads, indicates that the conductors, so marked are unused either because they are extra or defective. If a large number of conductors in the stub cable are unused, they will be bunched and marked with a linen tag. In this event, the end of the cable will be sealed with a lead sleeve.

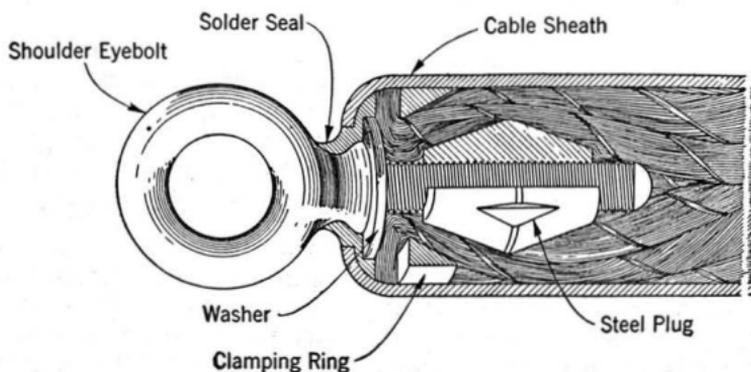
## 6. LOCATING DEFECTIVE CONDUCTORS IN CABLE ENDS

6.01 **Plain Sealed Ends:** Ring the sheath 6 to 8 inches from the end and remove this section of the sheath carefully so as not to disturb the rubber tubes. Then spread the conductors carefully to pick out those which are defective. If the end is capped with a lead sleeve, chip it off carefully so as not to disturb the underlying conductors. Then pick out the defective conductors as outlined above.

### 6.02 Pulling Eye Ends

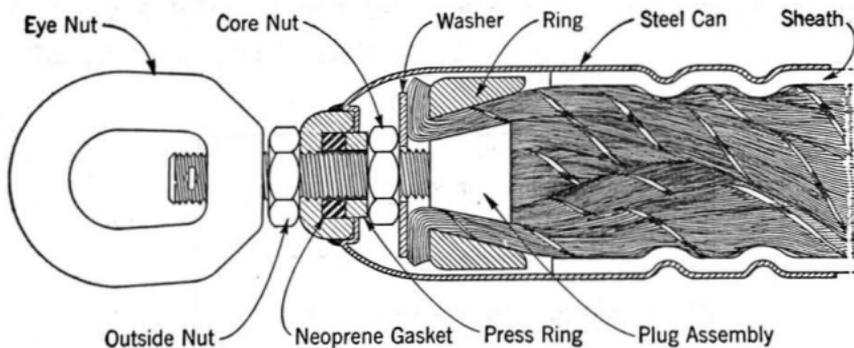
(1) If the cable is sealed with the wedge type pulling eye, illustrated on the following page, cut off the cable 6 inches from the end. Remove 6 to 8 inches of the cable sheath. Then spread the conductors carefully to locate the rubber tubes.

### WEDGE TYPE PULLING EYE



(2) If the cable is sealed with the can type pulling eye, illustrated below, cut off the eye directly behind the end of the steel can. Remove 6 to 8 inches of the cable sheath. Then spread the conductors carefully to expose the rubber tubes.

### CAN TYPE PULLING EYE



## 7. DISPOSITION OF DEFECTIVE CONDUCTORS

7.01 The disposition of defective conductors shall be in accordance with the procedures outlined in the Bell System Practices.