

BELL SYSTEM PRACTICES
Outside Plant Construction
and Maintenance

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CABLE SPLICING—GENERAL
PREPARATION OF LEAD SLEEVES

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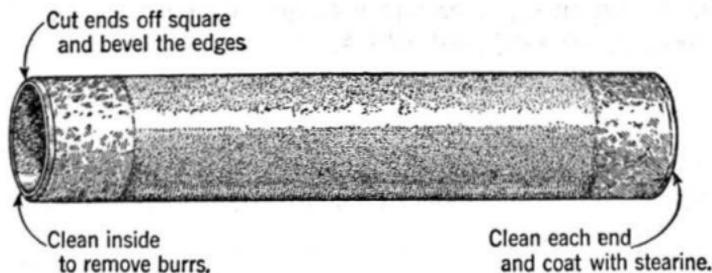
1. GENERAL

1.01 Lead sleeves should be cylindrical and free from defects. All kinks, dents or flat spots should be dressed out. If cut locally from a length of lead sleeving, the ends should be cut square.

1.02 Use a non-split sleeve whenever practicable in order to avoid a soldered seam.

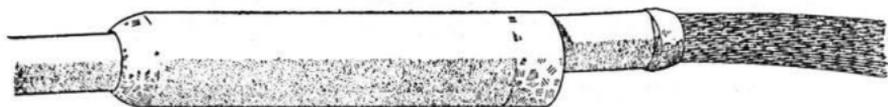
2. NON-SPLIT SLEEVE

2.01 Clean and coat the ends of the sleeve with stearine as indicated in the following sketch. The cleaned area should be sufficient to extend under the cable pasters to be placed in wiping the joints.



2.02 Slip the cleaned sleeve over the end of the cable and slide it along to a point where it will not interfere with the splicing operations. If there is sufficient space it is advisable to partially beat in one end of the sleeve before slipping it over

the cable. The beat-in should approximate the final shape of the wiped joint.



2.03 If the sleeve is not to be wiped for some time after preparation the cleaned surfaces may be protected by a muslin wrapping.

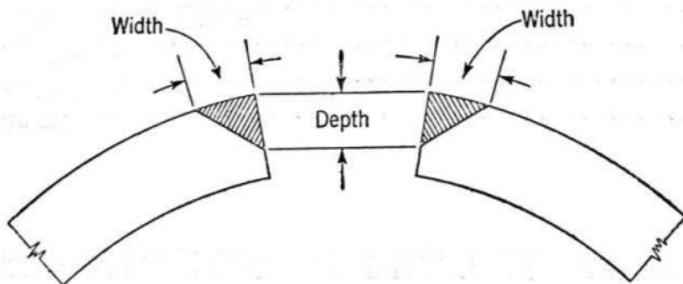
3. SPLIT SLEEVE

3.01 Where the cable ends are not free or if there is not enough space to place a sleeve without interfering with the splicing operations, it is necessary to use a split sleeve.

3.02 Clean and coat the sleeve with stearine as specified in Paragraph 2.01. If either or both ends are to be closed with a straight joint, the sleeve at one end should be partially beaten in before the sleeve is split.

3.03 Split the sleeve with a cable saw, taking care that the saw cut is straight and extends squarely through the sleeve wall. Sleeves made from lead-tin or lead-antimony have ridges extending along the outer surfaces, and one of these may be used as a guide line for a saw cut. Pure lead sleeves have no ridges and should be marked with a straight edge before cutting.

3.04 Open the split sleeve slightly and bevel the edges as illustrated below.



Sleeve Diameter
(Inches)

Bevel Width
(Inches)

Bevel Depth

2-3/4 and smaller

1/8

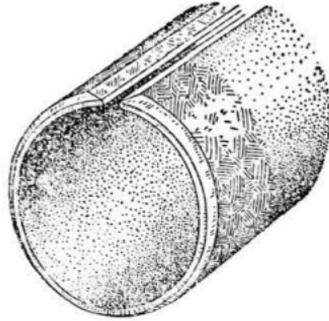
2/3 wall thickness

3 and larger

3/16

2/3 wall thickness

3.05 Coat the beveled edges with stearine.



4. KNUCKLE JOINT SLEEVE

4.01 Prepare the sleeve for a knuckle joint as indicated below:

