BELL SYSTEM PRACTICES
Outside Plant Construction and Maintenance

SECTION G50.636.3
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AT&T Co Standard

CABLE SPLICING—GENERAL
SOLDERED SLEEVE JOINTS—13-GAUGE CONDUCTORS

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1. GENERAL

1.01 Joints between 13-gauge conductors should be made by means of tinned copper sleeves. Joints between 13-gauge and smaller gauge conductors should be twisted and soldered.

2. SIZES OF SOLDERED SLEEVES

2.01 Tinned copper sleeves are available in the following sizes for use on 13-gauge conductors:

Designation of Sleeve	Type of Joint
13-S	Straight
13-D	Butt
13-D	Bridge

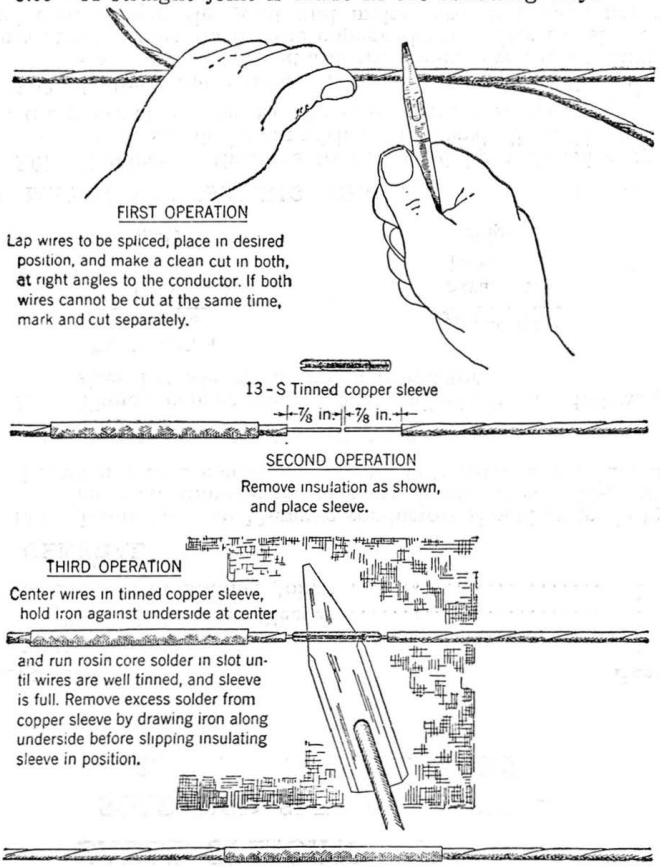
3. METHOD OF MAKING JOINTS

3.01 Conductors that are to be joined by a tinned copper sleeve should be cut with the diagonal pliers. The notch in the pliers should be used to remove the insulation.

3.02 Untwist the conductors sufficiently so that the cotton sleeve can be placed and the conductors can be aligned in a straight position for the copper sleeve. After the sleeve is soldered inspect the joint and make sure that there are no sharp projections.

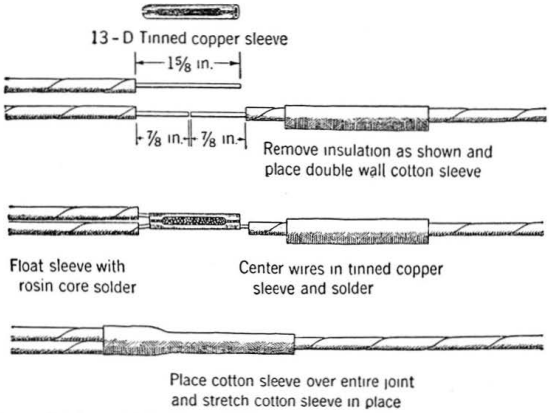
Straight Joint

3.03 A straight joint is made in the following way:



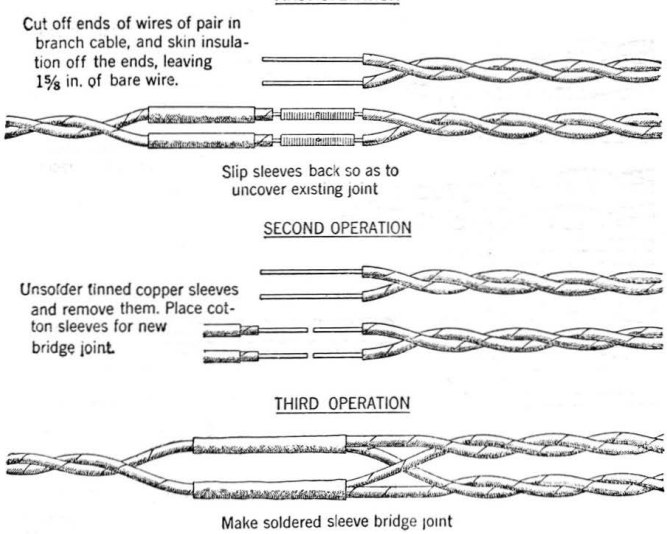
Bridge Joint—New Splice

3.04 When both the main cable and the branch cable are to be spliced at the same time the joint is made in the following way:



Bridge Joint—Existing Splice

3.05 Where there is an existing splice in the main cable the branch cable should be bridged as shown below:



Butt Joint

3.06 Butt joints are made as follows: