

## CABLE SPLICING—GENERAL

### WIPING “Y” JOINTS

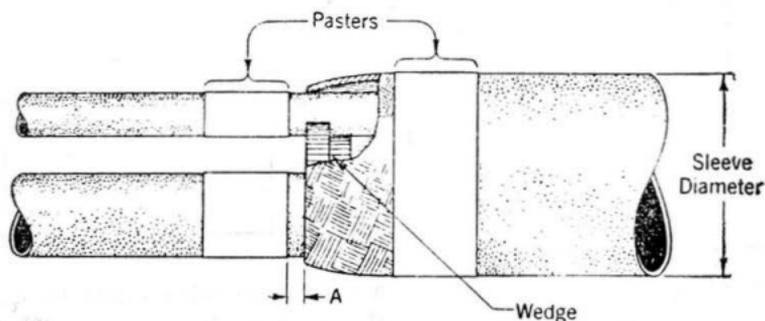
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#### 1. GENERAL

1.01 This section outlines the method of wiping “Y” joints.

#### 2. PASTERS

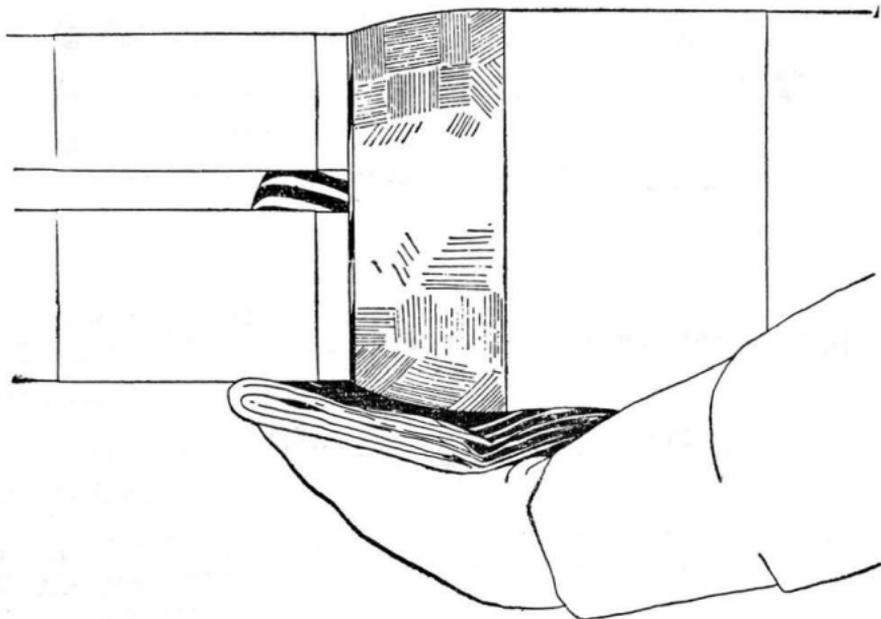
2.01 Place pasters around the cable in accordance with the following illustration and table.



SLEEVE DIAMETER (Inches)	DISTANCE A (Inches)
$\frac{3}{4}$ to $1\frac{3}{4}$	$\frac{1}{4}$
2 to 4	$\frac{3}{8}$
$4\frac{1}{2}$ to $6\frac{1}{2}$	$\frac{1}{2}$

### 3. WIPING

3.01 In wiping a "Y" joint hold a catch cloth a little distance below the joint and start dripping solder slowly over the sheath and sleeve. Move the ladle continuously with a circular motion so that the solder will not fall on one spot and melt a hole in the sheath or sleeve. After one or two ladles of solder have been poured on the joint, raise the catch cloth so that the side edges touch the pasters, keeping the center of the cloth in the shape of a cup or pocket as shown below.

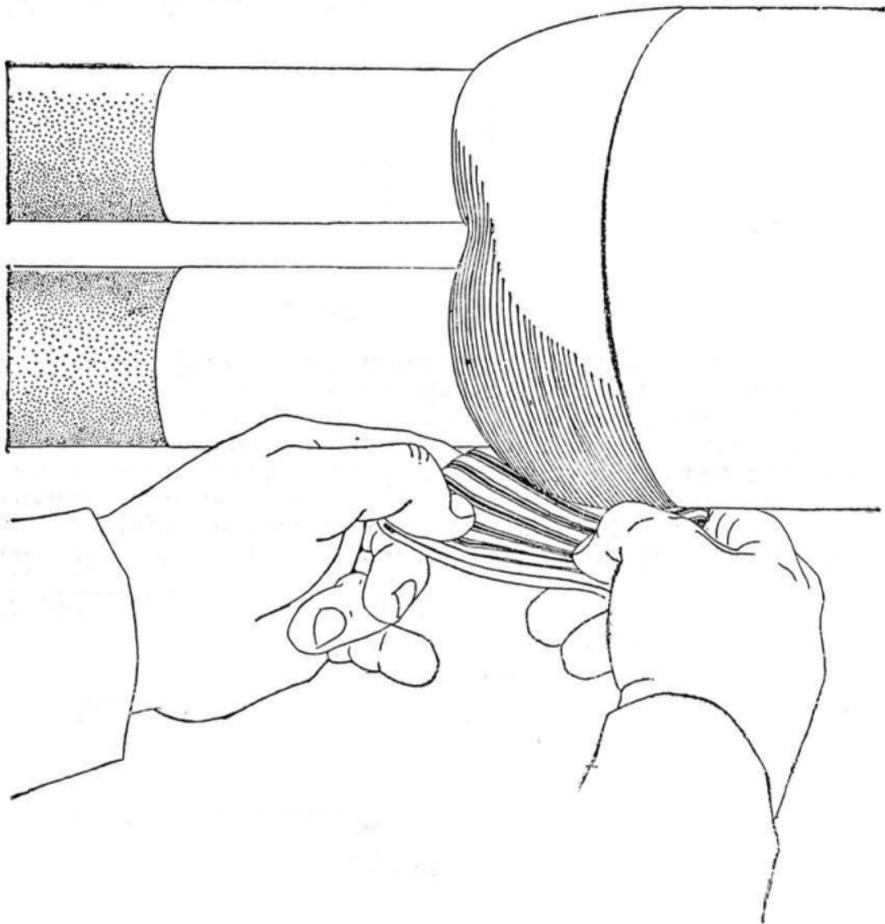


3.02 Solder should not be poured between the cables until the joint is well heated, or otherwise the solder may freeze in the crotch and block it for some time. Continue pouring solder over the top and sides, collecting the drippings in the catch cloth and bringing them to the top of the joint, thus helping to distribute the heat uniformly around the joint. When the joint is well heated, work some solder back and forth in the crotch with the catch cloth. Make sure that all parts of the joint are well heated and that the solder runs freely off all surfaces. Wipe off excess solder with the catch cloth, clean out the crotch with a crotch cloth or piece of textile insulated wire, and inspect the surfaces to make sure that they are properly tinned.

3.03 The joint may cool slightly during the inspection of the tinned surfaces. If so, pour one or two ladles of solder over it to insure that all parts are well heated. When

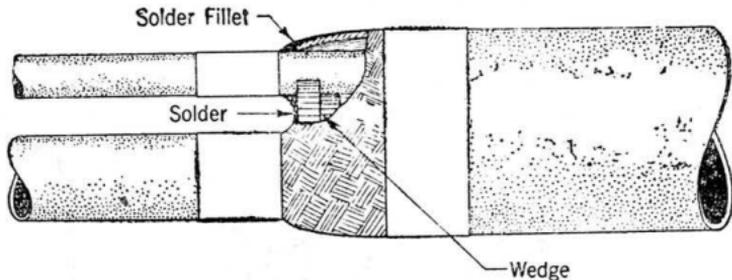
ready to wipe the joint, retain sufficient solder in the catch cloth to form the joint, and place the ladle in the pan or trough. If the solder is quite hot, it may be desirable to mix some of the drippings from the pan or trough with some solder from the pot for the last ladle of solder that is poured over the joint. Pack solder in the crotch with a crotch cloth or the edge of a wiping cloth. Using the catch cloth and a finishing cloth, bring the solder in the catch cloth to the top of the joint and distribute it over and around the top, sides and bottom, packing and shaping the joint roughly.

3.04 In finishing a "Y" joint the cloth is held as illustrated below.



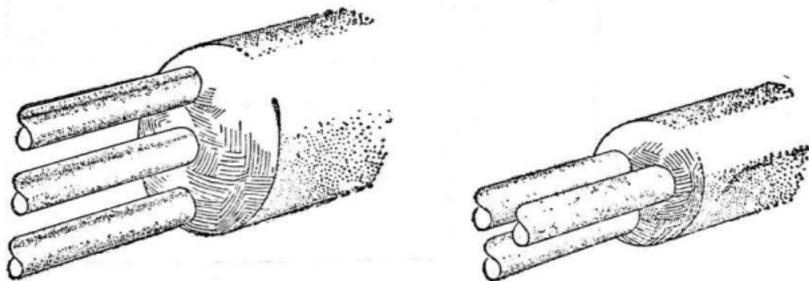
3.05 The cloth should be carried around the joint in contact with the sleeve and cable sheath so as to remove most of the solder from the sleeve and all except a fillet of

solder at the junction of the sleeve and sheath as illustrated below. Clean out the crotch with a crotch cloth, or cut it out with a piece of textile insulated wire.



#### 4. THREE-WAY "Y" JOINTS

4.01 If three cables enter a splice at one end, it is possible to make a disc joint or a three-way "Y" joint. If a three-way joint is to be made, standard wedges or a special wedge should be used, depending on whether the cables are in line or in a triangular bunch. The line arrangement can be used if the cables are clamped on a wall whereas the bunch arrangement is generally used if the cables are suspended from strand. The following illustration shows the two arrangements.



4.02 In underground locations it may be found desirable under some conditions to make two staggered "Y" joints rather than a three-way joint. This is done by using a short piece of lead sleeving for wiping in two of the cables and then wiping the third cable and the small lead sleeve into the large lead sleeve as shown below.

