BELL SYSTEM PRACTICES
Outside Plant Construction and Maintenance

SECTION G50.677.8
Issue 2, February, 1952
AT&T Co Standard

CABLE SPLICING — GENERAL
WIPING PLATE JOINTS

Contents **Page**

1. GENERAL

1.01 This section replaces Issue 1 and outlines the method of making a lead sleeve closure using precast end plates.

1.02 This section has been revised to show the use of external solder fillets between the cable sheath and the plate. This helps to avoid sheath cracks at the junction between the sheath and the plate.

1.03 With the plate type of wipe the cable and stub sheaths enter the splice through lead end plates to which the cables and sleeve are joined with small fillets of solder. The sleeve is joined directly to the end plates and does not touch the cable or stub sheaths. When necessary, the sleeve can be unwiped from the plate and rewiped without disturbing the sheath of the main cable or stubs.

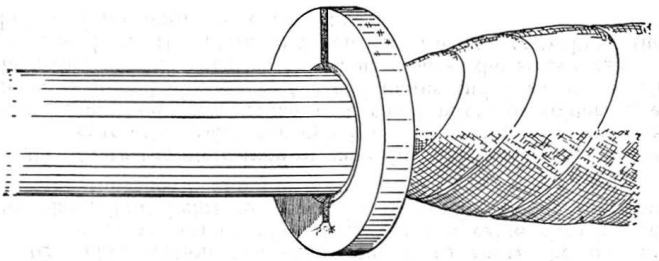
2. PLACING PLATES ON CABLES

2.01 Clean about two inches of the sheath at the location where the plates will be placed and coat the cleaned surface with stearine.

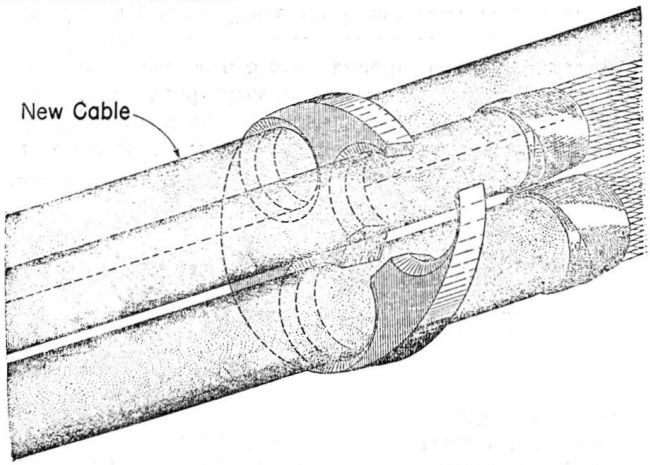
2.02 Locate the plates on the sheath so that the distance between the outside faces of the two plates is 1/4 inch more than the length of the lead sleeve. Tack the inside face

of plates to the top of main cable with solder, except where the B Sleeve Support is to be used.

2.03 When a split end plate is used on existing work, place the plate on the cable with the bevel formed by the chipping knife in the cutting operation facing outward from the splice. Then form the plate around the cable with a cable dresser as illustrated.



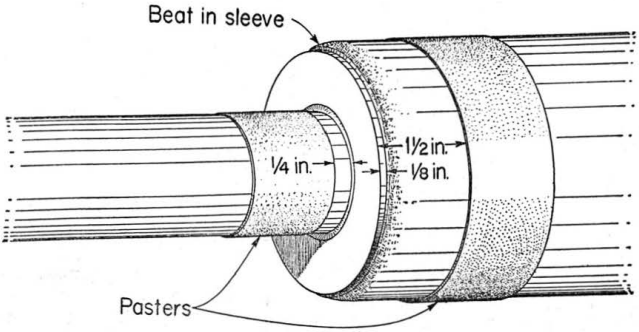
If a new cable is being added to the splice, place it in the closed hole in the plate and then place the existing cables in the holes which have been opened as shown, and form the plate around the cables.



3. PLACING LEAD SLEEVE

3.01 Slip the sleeve in place over the end plates leaving 1/8 inch of each plate exposed. Beat the sleeve in tightly to ensure that there are no openings between the sleeve and the end plate.

3.02 Place pasters on the cable 1/4 inch from the end plate, and on the sleeve about 1-1/2 inches from the outside face of each end plate as illustrated.



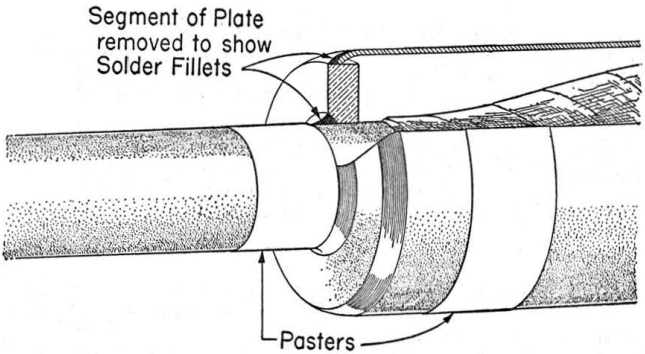
4. SUPPORTING LEAD SLEEVE—LEPETH SHEATH CABLE

4.01 On lepeth sheath cable the sleeve must be supported with the B Splice Support in such a manner that the weight of the sleeve and end plates is removed from the cable sheath in the wiping area, as described in Section G50.675.5.

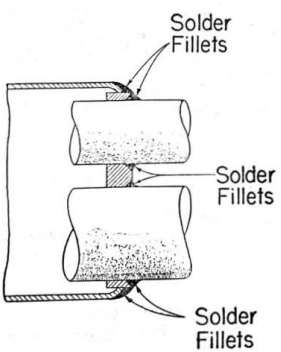
5. WIPING

5.01 Before wiping the first joint, pour a small quantity of solder over the joint at the opposite end of the sleeve to anchor the sleeve to the end plate and sheath. Then wipe the joints in the usual manner, making sure that the solder is packed into the bevel around the cable.

5.02 At a straight joint clean the excess solder from the face of the plate, as illustrated, leaving a rounded external fillet of solder between the end plate and the cable sheath that extends to the edge of the cable paster.



5.03 At a Y-joint the rounded fillets should extend on the sheath to the edge of the cable pasters, as far around the circumference of the cable sheath as practicable. The crotch string may be used to clean the excess solder from the face of the plate. To form the fillet the crotch string should be pulled away from the surface of the plate as the string approaches the sheath.



CROSS SECTION OF
FINISHED WIPE

5.04 Wipe excess solder from sleeve and edge of plate.

6. OPENING LEAD SLEEVE FOR REUSE

6.01 The joints between the end plates and the sheath should not be disturbed. It is desirable to place two or three layers of pasters around the cables, butted against the end plates, before unwiping. The joints between the sleeve and the end plates should be unwiped and the sleeve pried loose with a screwdriver or other suitable tool in the usual manner. The sleeve can then be slipped back to expose the splice and the paster removed from the cable sheath. On completion of the work the sleeve should be recentered on the end plates and beat in and wiped as outlined in Parts 3 and 5.