

CABLE SPLICING—GENERAL

SOLDERING SEAM ON SPLIT LEAD SLEEVE

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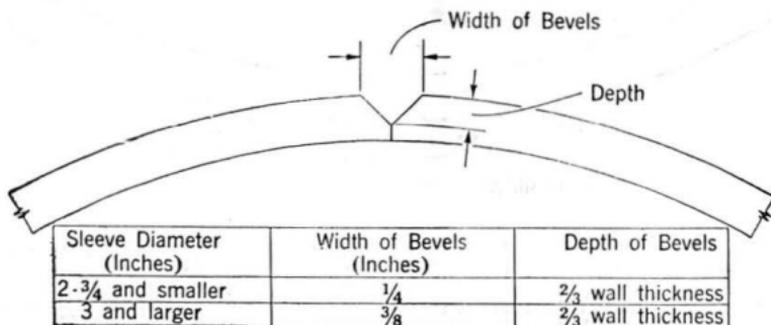
1. GENERAL

1.01 This section provides instructions for soldering the seam on split lead sleeves.

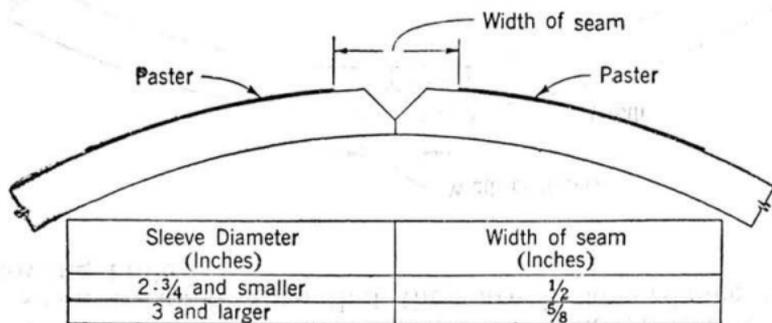
1.02 The seam may be soldered either before or after the joints have been wiped at the ends of the lead sleeve. If the seam is soldered before the joints are wiped, it will generally be necessary to resolder the seam near the ends of the sleeve after wiping the joints.

2. WIDTH OF SEAM

2.01 Check the width and depth of the bevels along the seam to make sure that they are in accordance with the following table:



2.02 Make sure that the bevelled surfaces are clean and straight. Clean the adjacent surface along the sleeve and place cable pasters parallel to the seam so that the width of the seam will be in accordance with the following table. The pasters should be strips approximately one inch wide.

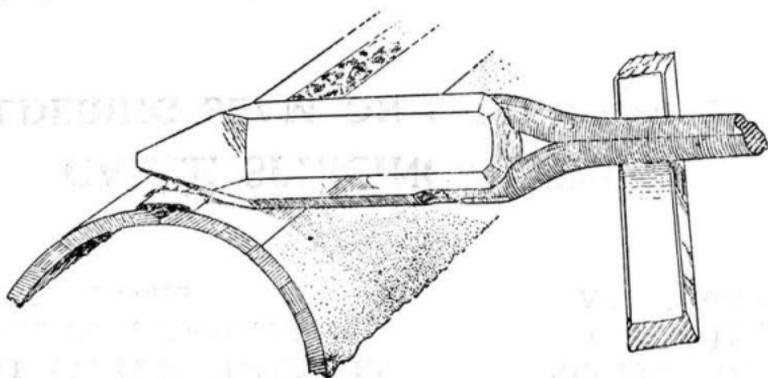


2.03 Coat the bevelled surfaces and the surface between the pasters with stearine.

3. METHOD OF SOLDERING

3.01 Tin the entire seam, using seam solder (or 50-50 solder if available) and a well heated copper that has been thoroughly cleaned and tinned. Any spots which do not take the solder readily should be cleaned with the shave hook, coated with stearine, and carefully tinned.

3.02 In running a seam the soldering copper should be rested lightly on the paster with the end tilted upward slightly, as illustrated below, and the advancing edge of the copper should be raised a little above the sleeve surface. A bar of solder will be found helpful in steadying the movement of the copper.



3.03 In order to obtain adequate strength, it is necessary to build up the seam above the surface of the lead sleeve. This can not be done properly if the soldering copper is cold, nor if the seam is finished with the flat side of the copper. It is, therefore, essential to use a freshly heated soldering copper in finishing the seam. A liberal application of stearine will also be found helpful in building up the thickness of the seam. If a well raised seam is not obtained on the first attempt, additional solder should be applied, the seam should be given another application of stearine and finished with a freshly heated copper.