BELL SYSTEM PRACTICES
Outside Plant Construction and Maintenance

SECTION G50.705.5
Issue 1, October, 1956
AT&T Co Standard

SUPERSEDED TYPE OF SPLICE AND TERMINAL CASE INSTALLATION

Contents **Page**

1. GENERAL

1.01 This section describes the installation of the superseded 1A Splice Case and TA and TB Cable Terminals on aerial alpeth, stalpeth or lead sheath cable. This section replaces Section G52.623.1.

1.02 The installation of the standard splice cases and T Type Cable Terminals is covered in another section of the Practices.

2. ASSEMBLY OF THE SPLICE OR TERMINAL CASE

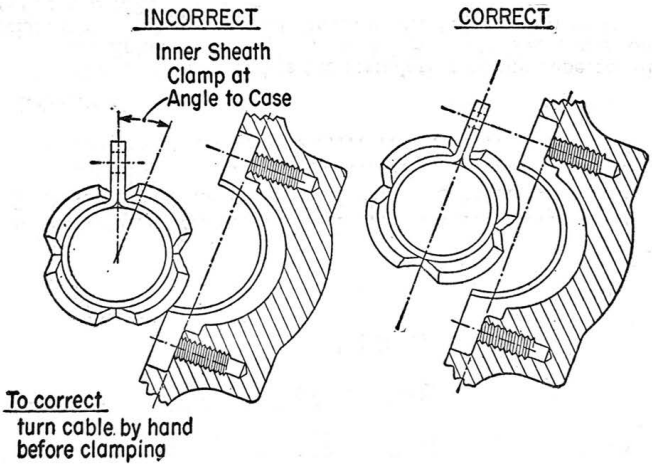
2.01 The preparation of the cable sheath is covered in another section of the Practices.

2.02 The assembly of the superseded 1A Splice Case or the TA or TB Cable Terminal is the same as for the standard types as covered in another section of the Practices, except as described below.

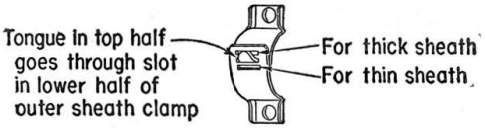
2.03 Follow the standard method covered in Section G50.705.6, up to and including Paragraph 2.09. Then proceed as follows.

2.04 Swing the splice or terminal case down into position before clamping the sheath. As the clamps that fasten the sheath to the splice or terminal case must transfer any forces acting on the sheath to the castings, the clamping must be done with care.

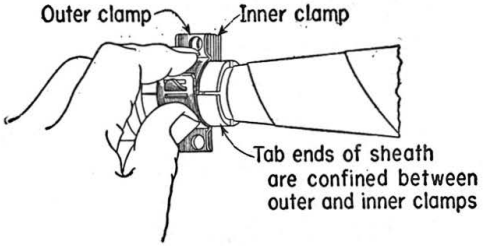
2.05 Loosen the strand lug and tilt the case to a convenient position for fastening the outer sheath clamps, center the case so that the holes in the case line up with the holes in the lugs on the clamps and tighten the strand lug. Then turn the cable by hand until the case and the inner sheath clamps are parallel.



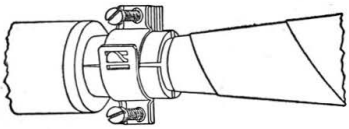
2.06 **On alpeth or stalpeth cable** the outer sheath clamp is made in two pieces so that the tongue of one fits through a slot in the other, as shown. The slots permit clamping sheaths of various thicknesses.



2.07 Hold the outer sheath clamp in position over the cable sheath so that the tabs are confined between it and the terminal or splice case grooves at the back and the inner sheath clamp.



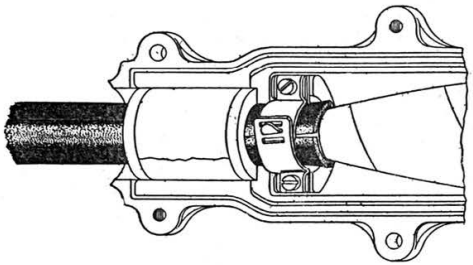
2.08 Insert a machine screw through the top hole in the outer clamp, the lugs on the inner sheath clamp and engage the screw in the hole in the casting. Insert another screw through the bottom hole in the outer clamp and engage it in the lower hole in the casting.



2.09 Tighten the upper screw to draw the ears of the outer and inner clamps into solid contact with the casting. This is important as this assembly is a link in the electrical bond across the splice.

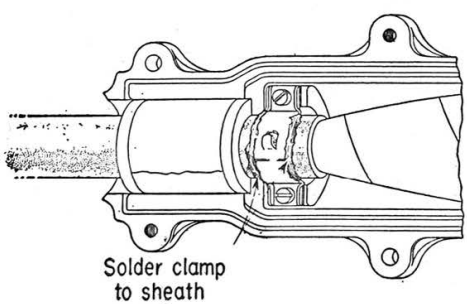
2.10 Then tighten the lower screw with the screwdriver to bind the sheath securely to the casting. When the proper slot in the clamp has been used and the sheath is gripped

securely, the head of the lower screw will not interfere with the closing of the case, although in this position the lower lug may not be in contact with the casting. In clamping thin sheath the lower lug may contact the casting.



2.11 **On lead sheath cable** the inner sheath clamp is not used. Swing the splice case or terminal case down into position before clamping the sheath. Fasten the slotted portion of the two-piece outer sheath clamp in position and then bend it inwards and shape it to bring it in contact with the lead sheath. Then fasten the tongued portion in position and form it so as to bring it in contact with the slotted portion. Do not engage the tongue and the slot.

2.12 Solder the clamp and the sheath together, as shown, with a heated soldering copper using stearine core solder. DO NOT use an open flame such as the soldering torch.



The remainder of the assembly is the same as Paragraph 2.11 through to Paragraph 2.20 of Section G50.705.6, except that Paragraph 2.16 of that section does not apply.

3. FLASH TESTING

3.01 Each terminal and splice case has a pressure testing plug for use in flash testing.

3.02 Flash testing is done in the usual manner, after closing and sealing the terminal or splice case, using the flash testing material approved for use with the type of cable sheath involved.

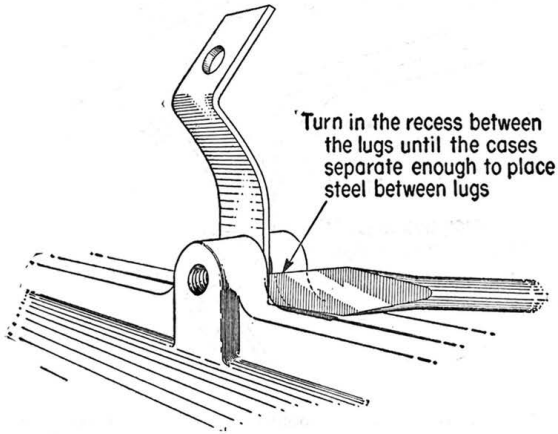
4. OPENING AND REASSEMBLY

4.01 Superseded 1A Splice Cases and TA or TB Cable Terminals may be opened as follows:

4.02 Two flat pieces of steel about 1/16-inch thick and about 1-inch across are used in opening the case; flattened cable clamps or steel washers are suitable.

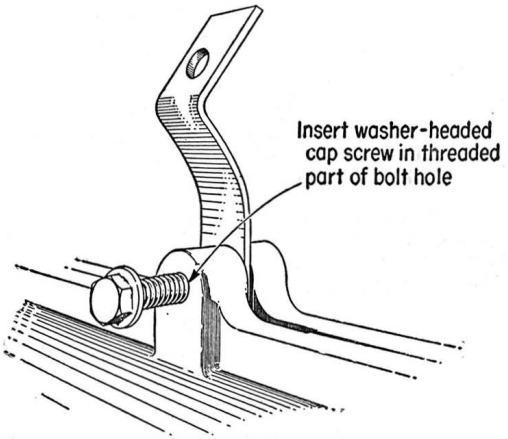
4.03 Remove the side bolts from the housing. The bolts are made of corrosion resistant steel and should start easily. However, if they do not start easily be careful not to shear off the heads. Then remove the bolts holding the compression collar and the bolts holding the strand lug of the case to be removed.

4.04 Separate the two cases at the middle of the top by turning a screwdriver blade in the recess between one of the bolt lugs, as shown, and slip one of the metal pieces in between the lugs so as to block the hole.



4.05 Repeat this procedure for the bottom of the case with the other piece of metal.

4.06 Then insert one of the washer headed bolts in the threaded portion of each blocked hole and turn them down until they contact the pieces of metal as shown.



4.07 Then, with the ratchet wrench, separate the two cases by turning the bolts clockwise to provide a powerful jacking action.

4.08 Remove the loose case. Remove enough of the cord from the sealing grooves of both cases to permit new cords to be placed. It is not necessary to remove all the cord. Discard the sealing cord removed. The sealing tape in the end seals may be left if most of it adheres in one solid piece around the cable.

4.09 Place a temporary bond across the splice as covered in the section of Practices dealing with temporary bonds. Then the sheath clamps are unfastened to obtain working space at the splice.

4.10 Complete the work on the splice and wrap it.

4.11 In building up the end seals, keep in mind that the equivalent of a new seal is desired. Add new sealing tape until the desired size is reached. It may be necessary to pull off the outer polyethylene washer before shaping the old tape.

4.12 Be sure that all four polyethylene washers are in place before refastening the sheath clamps to the casting and completing the closure.