

**BELL SYSTEM PRACTICES**  
**Outside Plant Construction**  
**and Maintenance**

**SECTION G50.714.2**  
**Issue 1, January, 1958**  
**AT&T Co Standard**

## **B PLASTIC SPLICE CLOSURE**

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### **1. GENERAL**

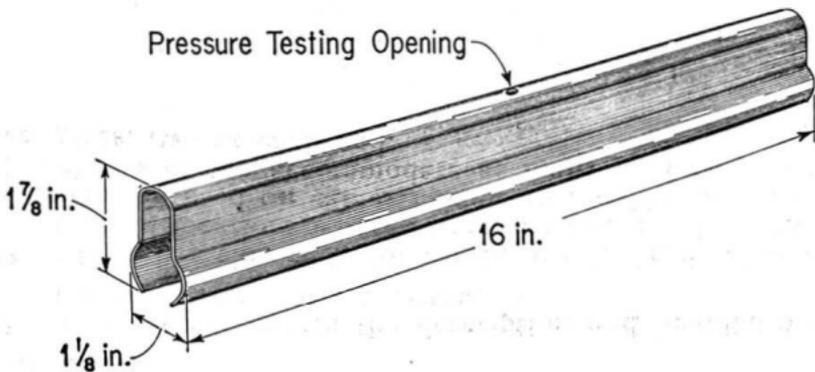
1.01 This section covers the description and installation of the B Plastic Splice Closure.

1.02 The splice closure is for use in buried distribution systems at locations where service wires are spliced to the cable. It can be used on cables having an outside diameter up to 1.5 inches and can accommodate as many as four two-pair service wires, two at each end.

## 2. DESCRIPTION

2.01 The splice closure has an over-all length of 16 inches and is made of extruded polyethylene. An opening is provided in the closure for pressure testing completed splices. The B Splice Closure is illustrated below.

### B PLASTIC SPLICE CLOSURE

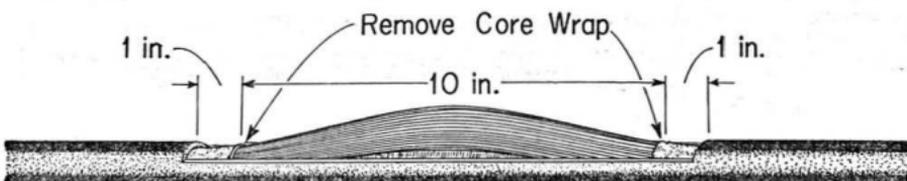
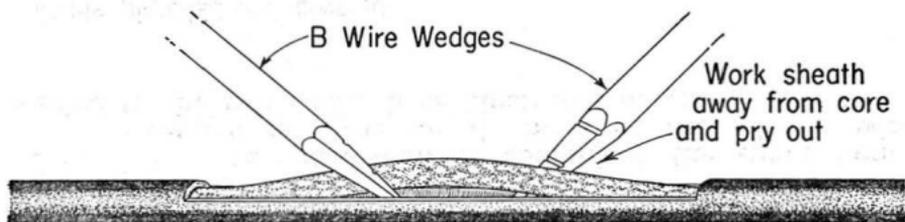
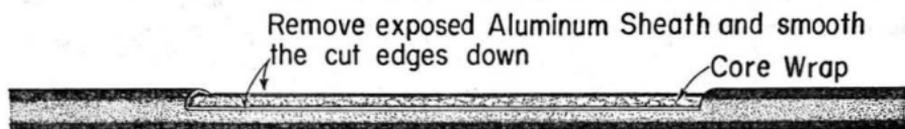
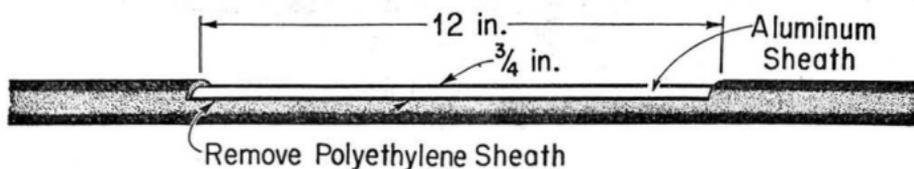


2.02 B Sealing Tape and D Vinyl Tape which are used in making the splice closure must be ordered separately.

### 3. SHEATH PREPARATION

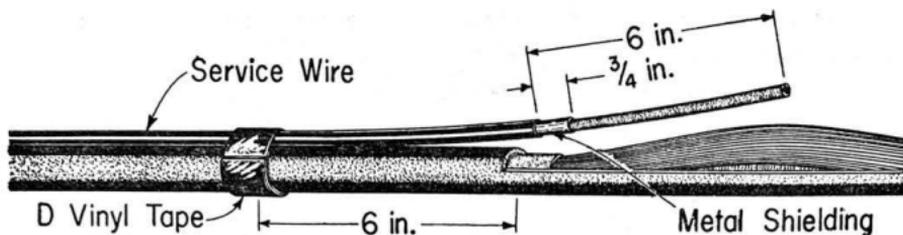
3.01 Mark the location of the sheath opening. Then **thoroughly clean** 8 inches on each side of the center of the opening with a carding brush.

3.02 Complete the sheath preparation as outlined below.



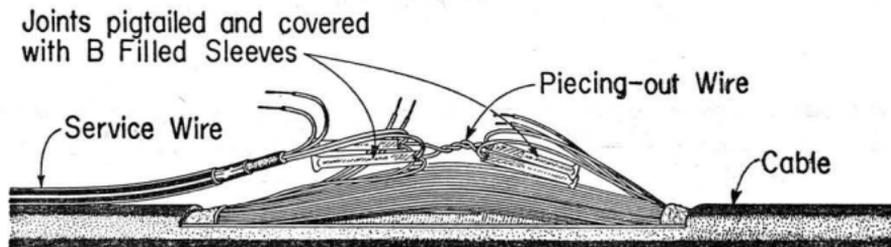
#### 4. SERVICE WIRE PREPARATION

4.01 Remove 6 inches of outer sheath. If the wire is shielded remove all but approximately 3/4 inch of the exposed metal shield. Then position the service wire to the cable with D Vinyl Tape.

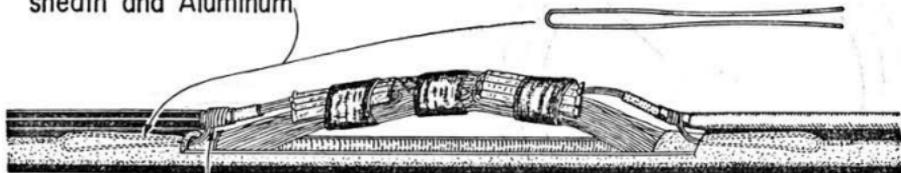


#### 5. SPLICING

5.01 The wire work shall be completed, the splice bundle wrapped and the metal shield of the service wires bonded to the cable sheath as illustrated below.

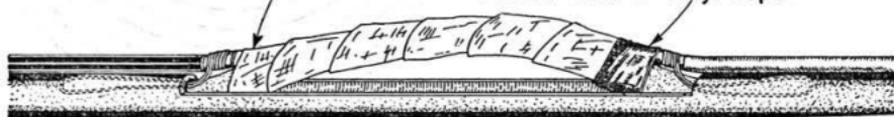


Bend a length of Copper Lashing Wire as shown. Insert at least 3 in. of the loop between the plastic sheath and Aluminum.



Wrap the loose end of the Lashing Wire over the exposed shield of each service wire

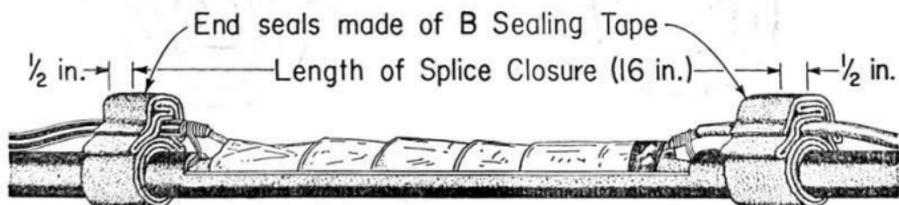
Spiral wrap with one half-lapped layer of B Polyethylene Tape  
Overlap core wrap at each end  
Secure with D Vinyl Tape



5.02 H Splice Sleeve may be used instead of piecing out wire. The use of these sleeves is covered in another section of these Practices. The splice shall then be completed as illustrated in Paragraph 5.01.

## 6. PLACING B SEALING TAPE

6.01 Wrap B Sealing Tape around and between the cable and service wires at each end of the splice opening. The sealing tape should be so positioned that it will extend about 1/2 inch beyond the end of the B Splice Closure as illustrated below.



6.02 In general, one layer of tape between service wires, two layers between service wires and cable, and two layers between cable and splice closure will be satisfactory. Suggested tape build-ups for different size cables and combinations are illustrated below.



FIG. 1



FIG. 2

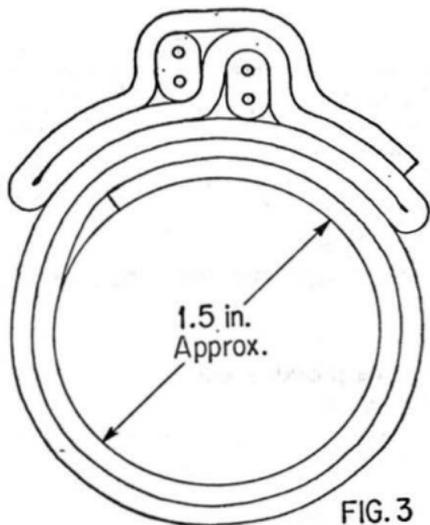


FIG. 3

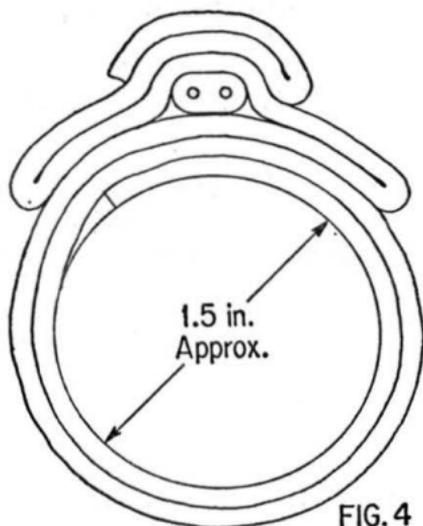


FIG. 4

- 6.03 Mold the tape by hand to form a compact mass approximately the same shape as the splice closure.
- 6.04 Place strips of B Sealing Tape on the splice case, lengthwise between the end seals as illustrated below.

Use B Sealing Tape lengthwise to build up a cross-section similar to the splice closure

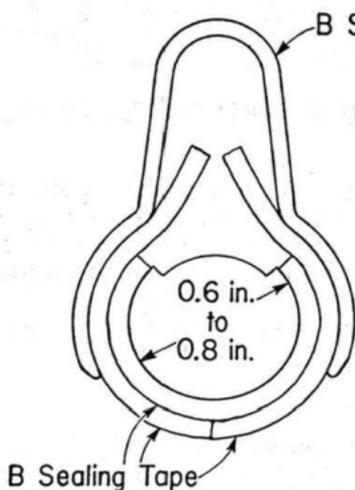


FIG. 5

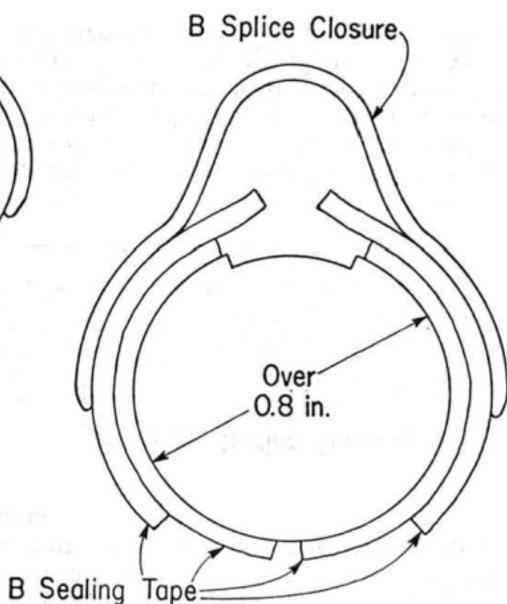
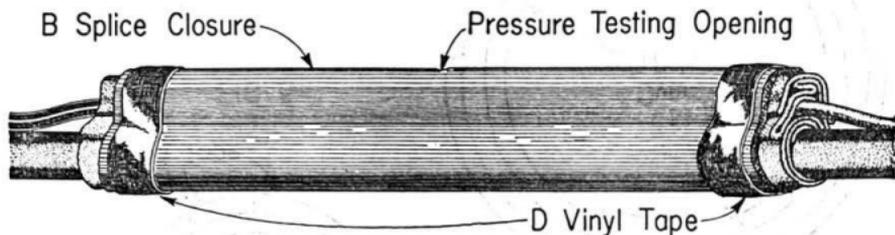


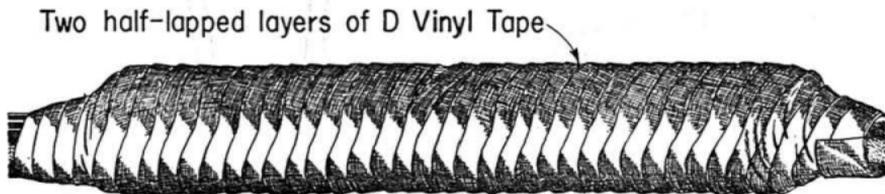
FIG. 6

## 7. INSTALLING SPLICE CLOSURE

7.01 Assemble the plastic splice closure over the splice so that it fits evenly against the sealing tape surfaces as illustrated below. Press the ends of the closure firmly against the sealing tape surfaces and wrap tightly with bands of three turns of D Vinyl Tape. The vinyl tape should not extend beyond the end of the splice closure.



7.02 Cover the splice closure with two half-lapped layers of D Vinyl Tape extending about 3 inches beyond the wrapped seals at each end. The tape should be stretched to provide pressure between the splice closure and the sealing tape. The last two turns of tape should not be stretched. Leave the opening in the top of the closure exposed for pressure testing.



## 8. PRESSURE TESTING

8.01 Flash test the splice closure by applying gas pressure through the opening in the top. Leaks can be sealed by applying finger pressure, reshaping the sealing compound under the tape.

8.02 In some instances bubbles of air trapped between the vinyl tape and the splice case may appear. These can be eliminated by wiping the area with finger pressure.

8.03 On completion of the flash test seal the hole with a plug of B Sealing Tape and cover with three turns of D Vinyl Tape.