

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

**SECTION G73.159.1**  
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# **PRESSURE TESTING**

## **B PLUG COMPOUND**

### **GENERAL**

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#### **1. GENERAL**

1.01 This section describes B Plug Compound, a resinous material used only for plugging all sizes of cable having polyethylene insulated conductors (PIC). Information is included concerning precautions to be taken in using this material.

1.02 B Plug Compound is always poured into a sleeve to provide a plug. A pressure gun is not used with this material.

1.03 Plugs can be made in a horizontal or vertical section of cable. The methods of making plugs with B Plug Compound are covered in a separate section.

#### **2. DESCRIPTION**

2.01 B Plug Compound is a resin mixture used in the plugging of PIC cables. It is available in packages of 100 and 300 grams. Each package contains a can of resin mixture (labeled Part I), a collapsible metal tube of hardener mixture (labeled Part II) and two wooden blades for stirring the compound.

2.02 This compound does not saturate the polyethylene insulation and as a result does not produce any noticeable change in insulation resistance of the plugged cable. It shrinks as it hardens, forming a compression seal on the conductor insulation.

2.03 **B Plug Compound contains chemicals to which some individuals are allergic, thereby causing a skin reaction similar to that caused by creosote. This material must be handled carefully to minimize contact with the skin.** Precautions in handling and using B Plug Compound are the same as de-

scribed in Section G73.157.1 for handling C Plug Resin and C Plug Activator.

### 3. MIXING REQUIREMENTS

3.01 The compound starts to set up in about 15 minutes at 70°F. Faster set up occurs at higher temperatures and slower set up at lower temperatures. Accordingly the mixing should be done immediately before using.

3.02 Plugs should preferably be made at temperatures above 45°F. Where the plugs must be made at lower temperatures the compound should be kept moderately warm before mixing. Storage in a heated building is recommended during cold weather.

3.03 **Opening Can (Part I):** Place the can on a flat surface and remove the friction cap carefully to avoid spilling. Use a 4-inch regular screwdriver or its equivalent as a pry. Form a pouring lip on the can by crushing the top rim against the side with the jaws of Side Cutting Pliers. Do this before emptying Part II into the can.

3.04 **Handling Tube (Part II):** Hold the tube vertically and break off the tip with Splicer's Scissors or a pair of pliers. Invert the tube and squeeze the contents into the opened can; start at the folded end of the tube and press progressively toward the tip.

3.05 Stir (do not whip) the mixture in the can thoroughly with the wooden blade for at least one minute.

3.06 Details covering the pouring of the plug are included in another section.

### 4. PLUGGING CABLES UNDER PRESSURE

4.01 It is advisable to wait about 12 hours before applying pressure to cables plugged with B Plug Compound. Pressure should never be applied in less than 3 hours after plugging.

4.02 When it is necessary to plug a cable that is under pressure, the cable should be vented on each side of the plug. This can be done by opening valves or making temporary openings in lead sleeves located within about 150 feet of the plug.

4.03 When it is undesirable to allow a large drop in cable pressure (such as at submarine crossings, etc), a temporary bypass can be constructed around the plug or a nitrogen cylinder can be used beyond the temporary openings to maintain pressure in the cable requiring protection.