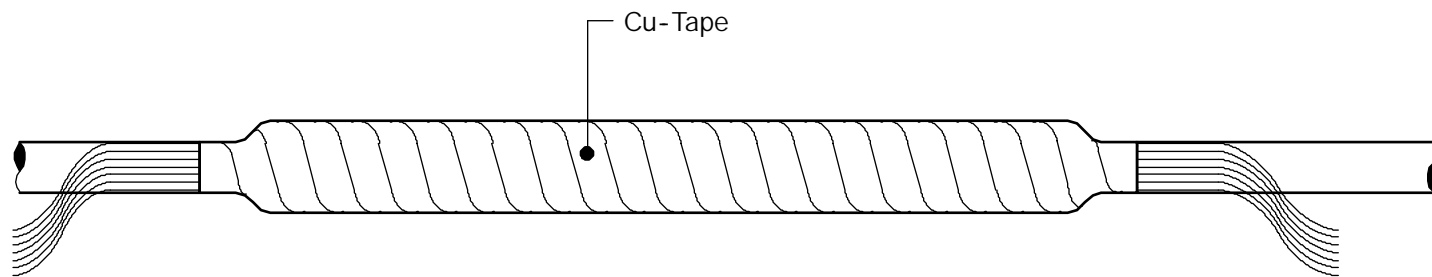
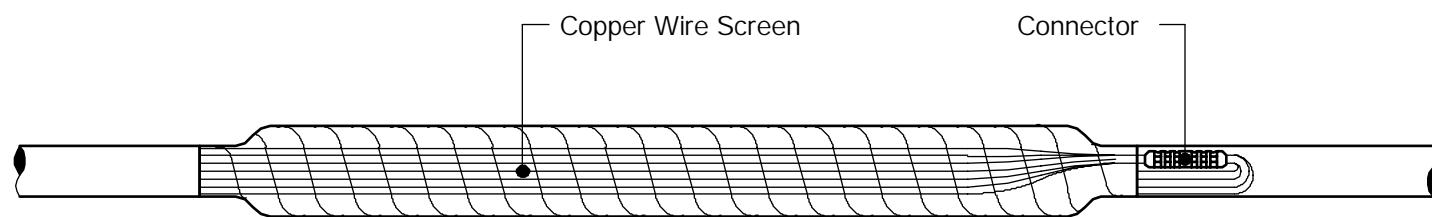


6



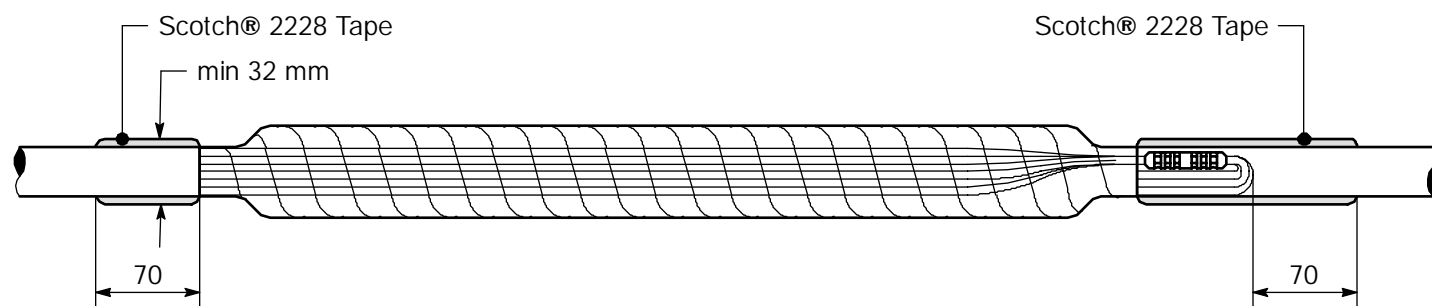
6.1 Apply one half-lapped layer of Cu-tape over the connection.

7



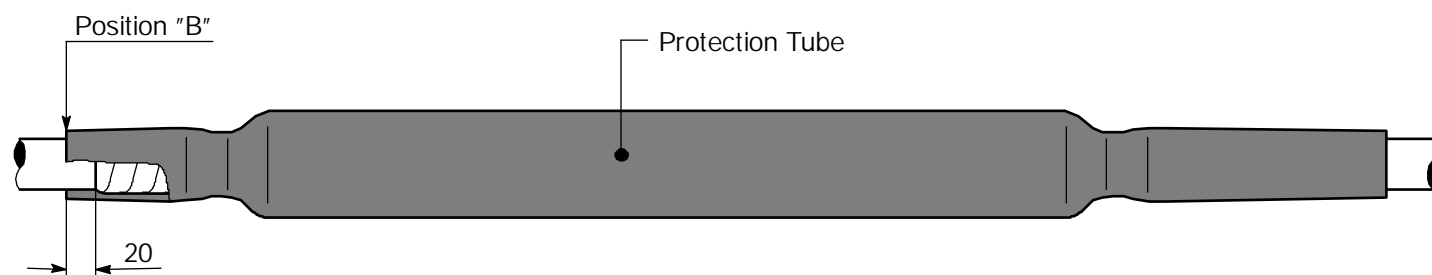
7.1 Bring back the copper wire screen onto the connection and connect them. Place the connector on the cable jacket.

8



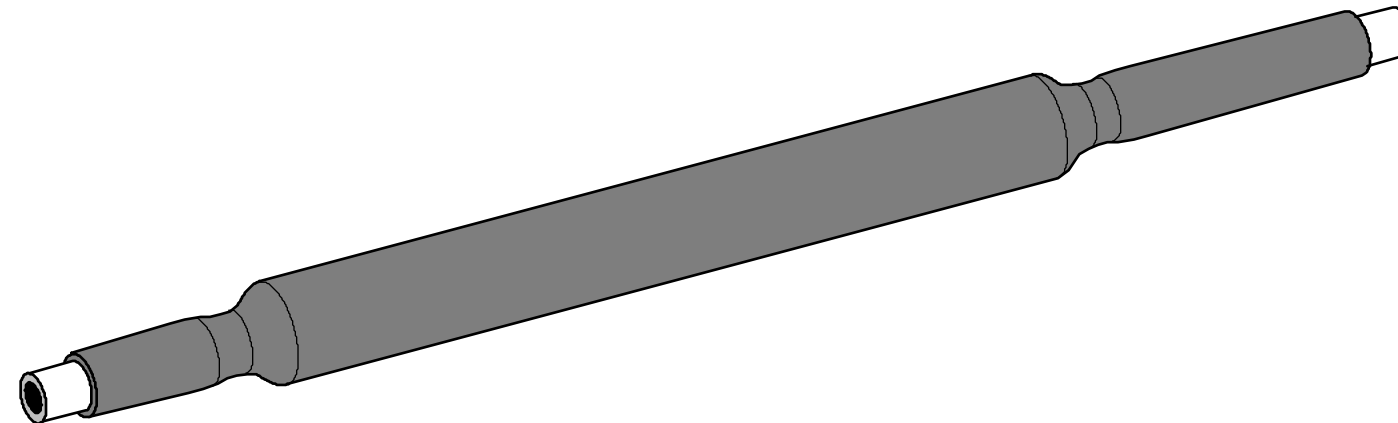
8.1 Apply a seal with Scotch® 2228 tape onto the cable jacket acc to given dimension. Include the connector.

9



9.1 Slide the protection tube over the connection to position "B" and shrink over the connection.

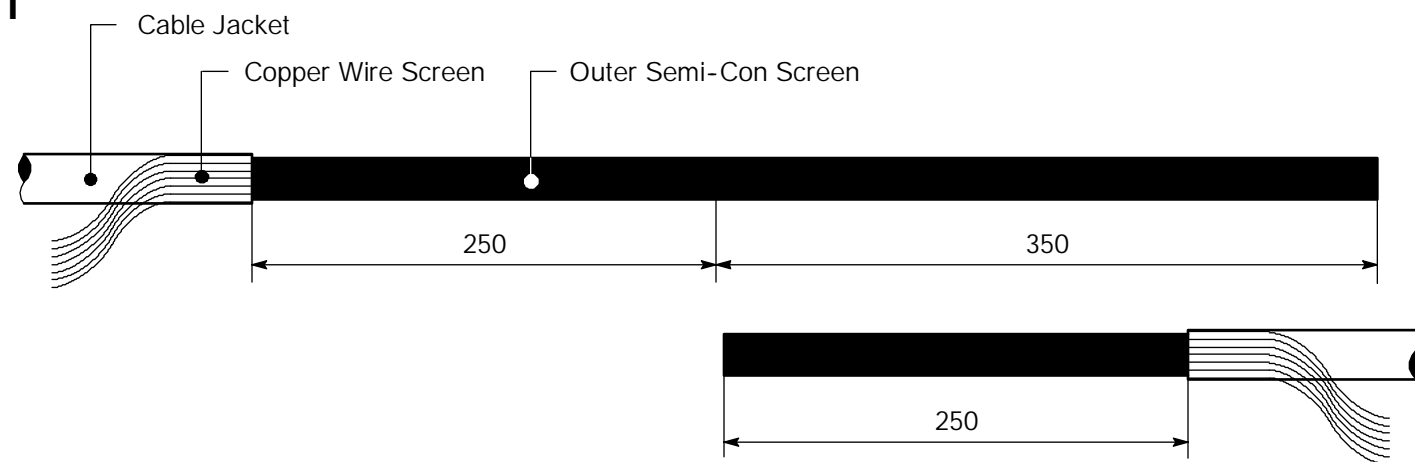
# 3M Cold Shrink



Kit no	Diameter over Cable Jacket max. (mm)	Diameter over Insulation E (mm)	Cross Section (mm <sup>2</sup> )	Diameter over Connector (mm)	Connector Length max. (mm)
QSG 150 AP-1	43	18,8 - 30,0	50 - 150	14,0 - 30,0	170
QSG 300 AP-1	51	21,2 - 34,5	95 - 300	18,0 - 34,5	170

3M Laboratories (Europe) Branch of 3M Deutschland GmbH		ISSUE: 3	ISSUE DATE: 20.04.2001
ALL STATEMENTS, TECHNICAL INFORMATION AND RECOMMENDATIONS CONTAINED HEREIN ARE BASED ON TESTS WE BELIEVE TO BE RELIABLE HOWEVER, SINCE THE CONDITION OF USE AND THE APPLICATION ARE BEYOND OUR CONTROL THE PURCHASER IS RESPONSIBLE FOR THE PERFORMANCE OF THE SPLICES AND TERMINATIONS MADE IN CONNECTION WITH THE USE OF DATA OR SUGGESTIONS HEREIN.		<b>3M QSG - AP Serie</b> INLINE SPLICE Type <b>QSG 150 AP-1</b> <b>QSG 300 AP-1</b> with Cold Shrink Rejacketing for polymeric single core cables with copper wire screen acc to VDE 0273 (IEC 502-1) 12/20 kV	
		ID- 0213- 2453- 1	
		DES. ENG.: W. Röhling	1. ISSUE DATE: 17.02.98
		MOD. ENG.: A. Kis	1. CHANGE DATE: 25.05.99
		DRAWN: M. Hubrich	2. CHANGE DATE: 20.04.01
CHECKED: W. Röhling		3. CHANGE DATE:	
RELEASED: A. Koch-Binzer		4. CHANGE DATE:	
<b>3M ELECTRICAL PRODUCTS</b>		<b>XE 0091-2453-0</b>	

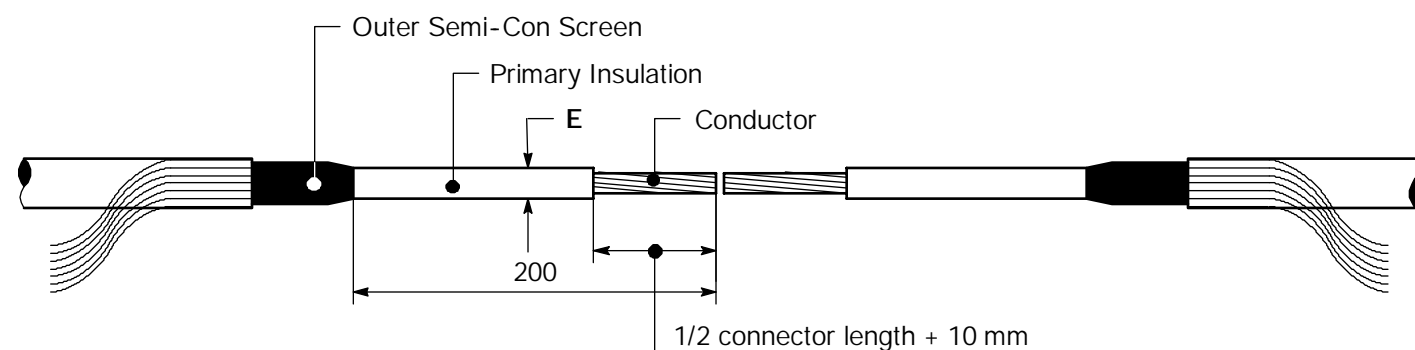
1



- 1.1 Remove the cable jacket acc to given dimensions. Ensure overlapping for 350 mm for one cable.
- 1.2 Bend back copper wire screen. Collect wires together.
- 1.3 Cut the cable at point 250 mm.

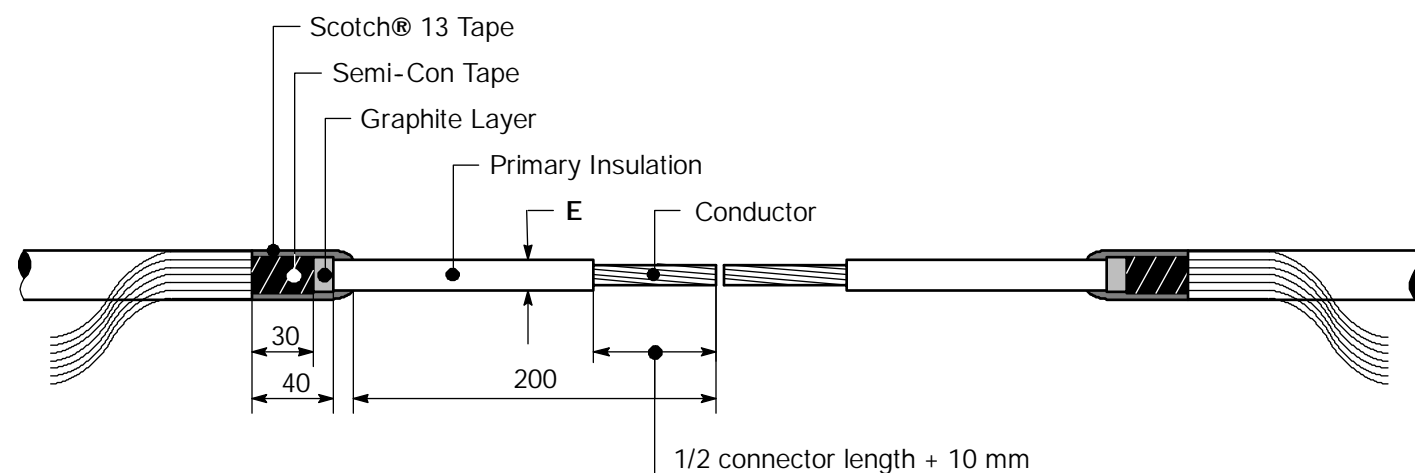
2

### Cable with extruded Semi-Conductive Screen



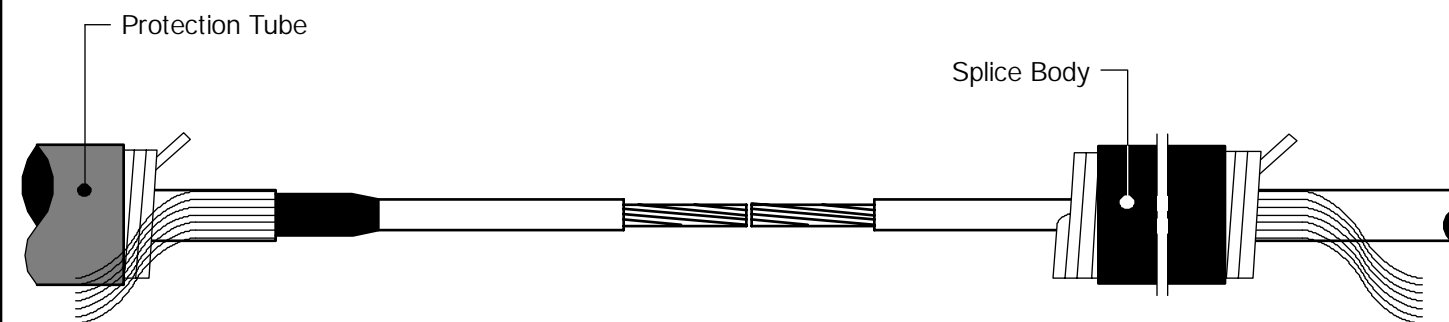
- 2.1 Remove cotton tapes.
- 2.2 Remove semi-conductive screen acc to given dimensions.
- 2.3 Remove primary insulation for 1/2 connector length + 10 mm.

### Cable with Graphite Layer and Semi-Conductive Tapes



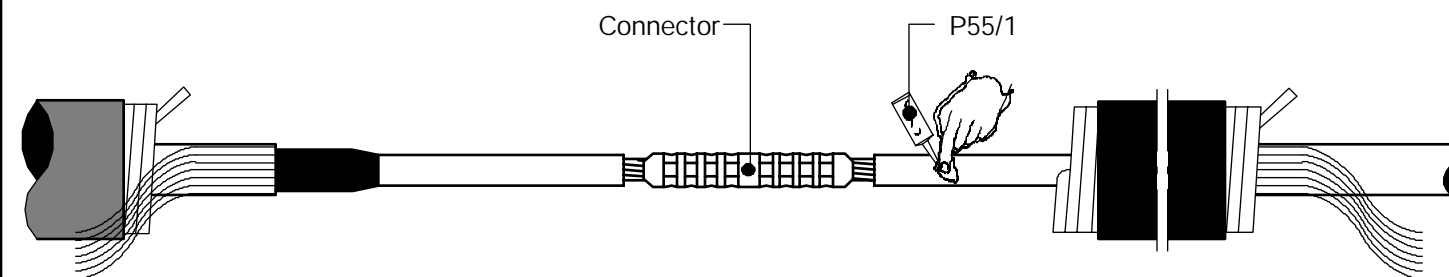
- 2.1 Remove semi-conductive tape leaving 30 mm in front of the cable jacket.
- 2.2 Remove graphite layer leaving 40 mm in front of the cable jacket.
- 2.3 Apply one half-lapped layer of Scotch® 13 tape from the semi-conductive tape onto the primary insulation and back again acc. to given dimensions.
- 2.4 Remove primary insulation for 1/2 connector length + 10 mm.

3



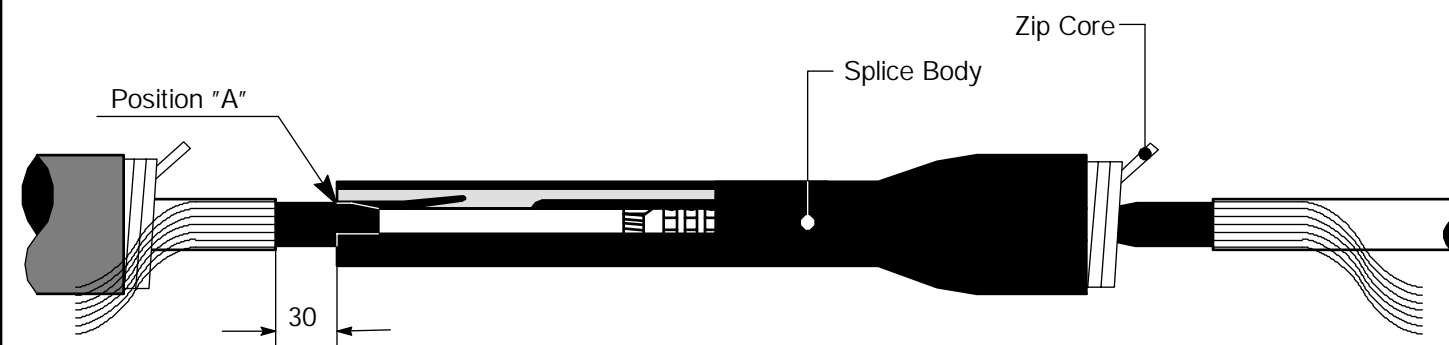
- 3.1 Position the protection tube and the splice body onto the cable ends. Use polybag as protection.

4



- 4.1 Crimp the connector, remove the excess grease, smooth and clean the connector.
- 4.2 Apply P55/1 grease over the end of the semi-conductive layer, onto the primary insulation and connector using the plastic glove provided.

5



- 5.1 Slide the splice body over the connection until position "A".
- 5.2 Shrink the splice body into position by pulling out and unwinding the core in counter clockwise direction.
- 5.3 After shrinking, check the position of the splice body, otherwise make correction by displacement.