

CABLE SPLICING—GENERAL

WIPING STRAIGHT JOINTS

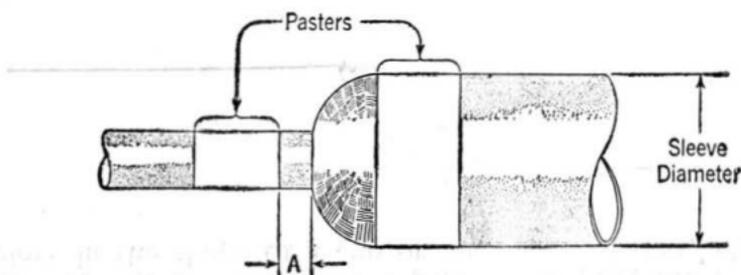
Contents	Page
1. General	1
2. Pastes	1
3. Wiping	2
4. Duct Splice	4

1. GENERAL

1.01 This section outlines the method of wiping straight joints.

2. PASTES

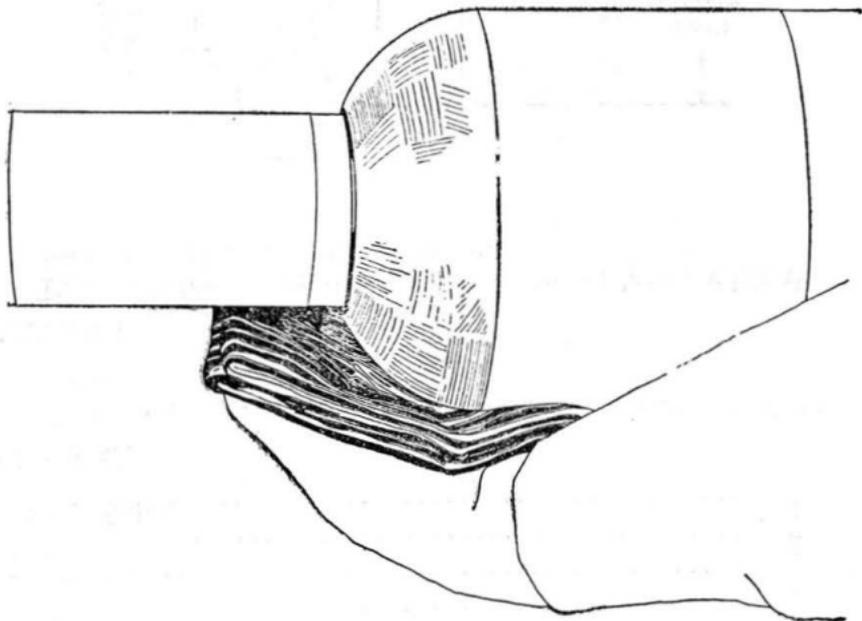
2.01 Place pastes around the cable in accordance with the following illustration and table.



Sleeve Diameter (inches)	Distance A (inches)
$\frac{3}{4}$ to $1\frac{1}{4}$	$\frac{1}{4}$
2 to 4	$\frac{3}{8}$
$4\frac{1}{2}$ to $6\frac{1}{2}$	$\frac{1}{2}$

3. WIPING

3.01 In wiping a straight joint hold a catch cloth a little distance below the joint and start pouring solder slowly over the sheath and sleeve. Move the ladle continuously with a circular motion so that the solder will not fall on one spot and melt a hole in the sheath or sleeve. After one or two ladles of solder have been poured on the joint, raise the catch cloth so that the side edges touch the pasters, keeping the center of the cloth in the shape of a cup or pocket, as shown below.

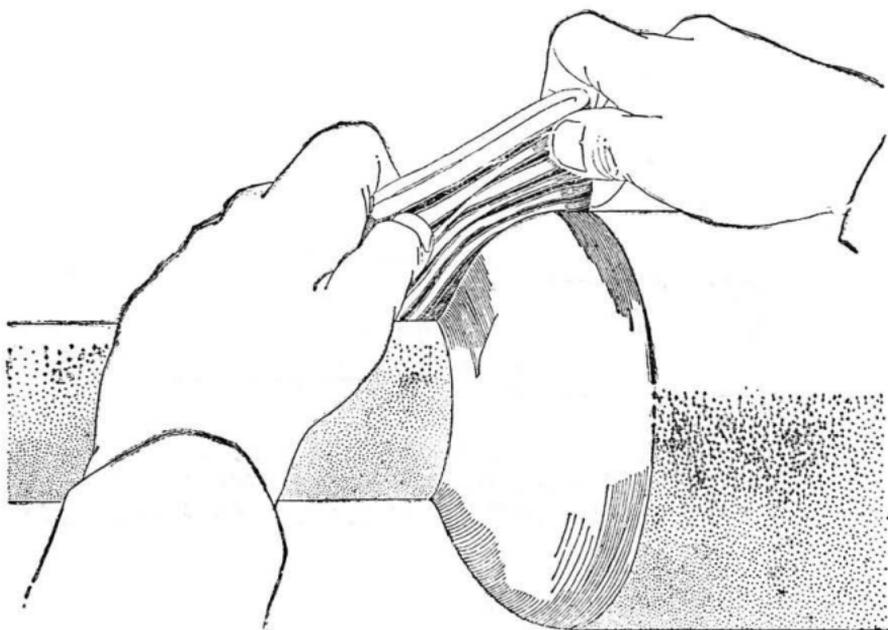


3.02 Continue pouring solder, distributing it over the top and sides of the joint. Bring the solder that collects in the catch cloth to the top of the joint, thus helping to distribute the heat uniformly around the joint. At first the solder clings to the lead surfaces but as the pouring continues, the lead becomes heated and tinned. Make sure that all parts of the joint are well heated and that the solder runs freely off all surfaces. Wipe off excess solder with the catch cloth and inspect the surfaces to make sure that they are properly tinned.

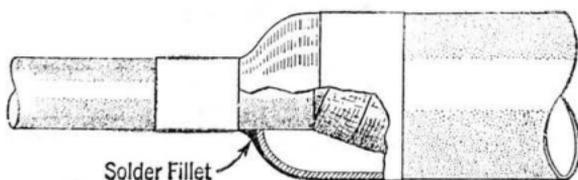
3.03 The joint may cool slightly during the inspection of the tinned surfaces. If so, pour one or two ladles of solder over it to insure that all parts are well heated. When ready to wipe the joint, retain sufficient solder in the catch cloth to

form the joint and place the ladle in the trough or pan. If the solder is quite hot, it may be desirable to mix some of the drippings from the pan or trough with some solder from the pot for the last ladle of solder that is poured over the joint. Using the catch cloth and a finishing cloth, bring the solder in the catch cloth to the top of the joint and distribute it over and around the top, sides and bottom, packing and shaping the joint roughly.

3.04 In finishing a straight joint the cloth is held as illustrated below.



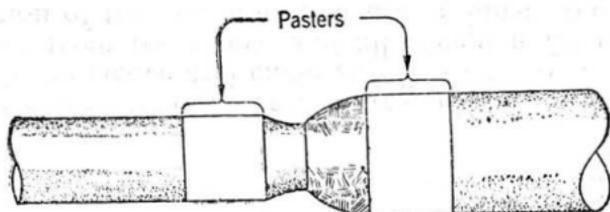
3.05 The cloth should be carried around the joint in contact with the sleeve and cable sheath so as to remove most of the solder from the sleeve and all except a fillet of solder at the junction of the sleeve and sheath as illustrated below.



4. DUCT SPLICE

4.01 A duct splice differs from the ordinary straight splice in that the sleeve diameter is generally limited to a maximum of 2-3/4 inches and the wiped joints should be strong enough to permit pulling the cable in or out of the duct.

4.02 Place pasters around the cable adjacent to the rings as shown below.



4.03 The solder should be packed firmly into the ring between the pasters and the finished joint should be as flat as possible, as shown below.

