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Unless otherwise specified dimensions are in millimeters.
Inches dimensions are in between brackets.

**INSTALLATION PROCEDURE FOR
MULTI-WIRE BUTT SPLICE
SOLDERLSLEEVE DEVICES – SERIES SGRP-SGRS –
INSTALLED WITH HOT AIR GUN**

SUMMARY

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1.0 Product Selection According To Application

Consult the Specification Control Drawing (SCD).

2.0 Application Equipment**2.1 Hot Air Gun CV-1981**

Model	Set-up	Temperature*	Reflector
CV- 1981 110V or 220V 1460W	8.5 vent open	440±10°C	PR-25D

*Temperature controlled with the reflector AD-1999 and a numerical thermometer.

Installation time in seconds (Averages calculated from samples terminated with the heating parameters defined above)					
Product Size	Copper Cross Section		Product Size	Copper Cross Section	
	minimum (See SCD)	maximum (See SCD)		minimum (See SCD)	maximum (See SCD)
SGRP-1	11s	15s	SGRS-1	11s	15s
SGRP-2	15s	21s	SGRS-2	15s	21s
SGRP-3	25s	51s	SGRS-3	25s	45s
SGRP-4	36s	88s	SGRS-4	46s	75s

2.2 Hot Air Gun "STEINEL HL-1802-E"

Model	Set-up	Temperature*	Reflector
HL-1802-E 110V or 220V 2000W	11 Air flow 3	440±10°C	074616 (Steinel)

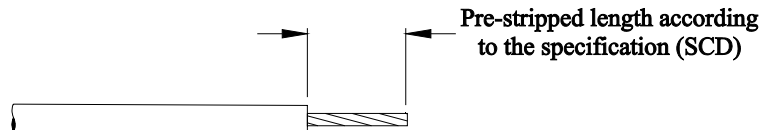
* Temperature controlled with a numerical thermometer and the sensor is placed in the middle of the reflector.

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Installation time in seconds (Averages calculated from samples terminated with the heating parameters defined above)					
Product Size	Copper Cross Section		Product Size	Copper Cross Section	
	minimum (See SCD)	maximum (See SCD)		minimum (See SCD)	maximum (See SCD)
SGRP-1	12s	15s	SGRS-1	13s	16s
SGRP-2	16s	22s	SGRS-2	17s	23s
SGRP-3	28s	56s	SGRS-3	28s	50s
SGRP-4	37s	92s	SGRS-4	48s	88s

3.0 Wires Preparation

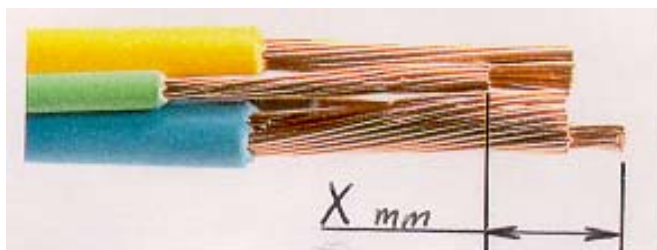
- 3.1 Pre-strip the end of each wire to be connected. The pre-stripped length is left in place, and will be removed at the assembly step, in order to prevent oxidation and wire strand damage during storage and transportation.
- 3.2 The pre-stripped length is given on the technical product specification (SCD)
- 3.3 Inspection
The jacket must be cut precisely, the strands must not be damaged or cut.
Check presence of pre-cut strip at the wire end.



4.0 Installation Procedure

- 4-1 Remove the pre-stripped length of the wires to be connected
- 4-2 Align the stripped ends visually.
The maximum acceptable misalignment of the wire ends is indicated below:

	SGRP-1 SGRS-1	SGRP-2 SGRS-2	SGRP-3 SGRS-3	SGRP-4 SGRS-4
Maximum gap: X (mm)	3	5	6	7



- 4-3 Slightly twist all the conductors together in order to prevent foldback of the strands

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during the Soldersleeve device insertion.
Turn right as indicated below.

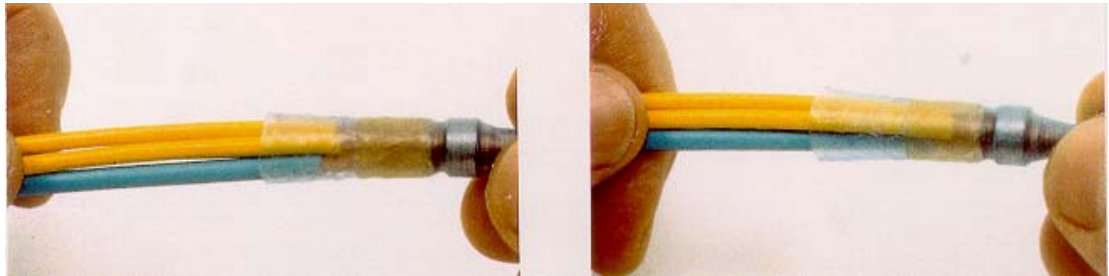
Correct



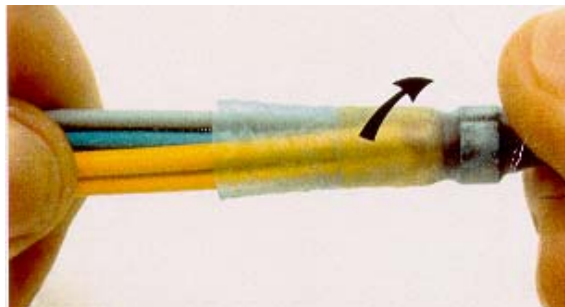
Incorrect



- 4-4 Slide and slightly rotate the Soldersleeve Device onto the conductors, until the conductors meet the front end of the copper coil.



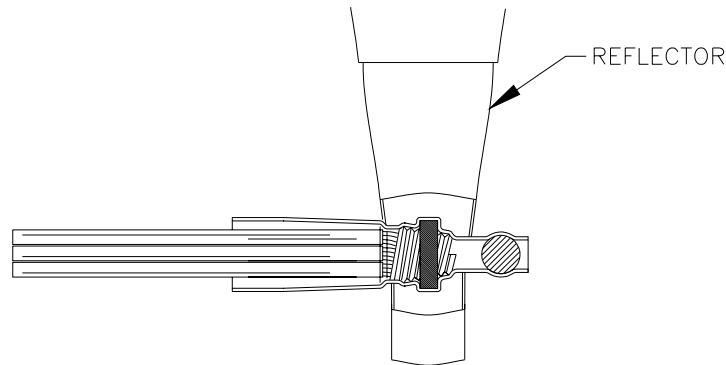
Push firmly and screw the device in a clockwise direction as indicated below with approximately one full turn.



- 4-5 Equip the hot air gun with the reflector and then allow it to warm up until the operating temperature is reached (See paragraph 2)

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Position the device assembly so that the solder preform is located in the middle of the reflector.



- 4-6 Direct the heat to the solder preform until the sleeve shrinks, and the solder preform melts and flows into the turns of the conical copper coil
After the solder ring has completely disappeared, continue heating for 6 seconds.

NOTE: See the installation time indicated in paragraph 2.

- 4-7 Allow the assembly to cool down before handling.

5.0 Inspection

5-1 Correct Positioning

- The conductors must be aligned as indicated in 4-2.
- The Soldersleeve device must cover totally all the stripped lengths.

5-2 Correct Heating

- The solder preform must be completely melted and have flowed through the helical coil
- The solder must be visible among the strands of the conductor, at the end of the copper coil.
- Visible remnant of the solder preform indicates an underheated termination.
- A discolored dark brown sleeve and wire insulation melted indicate an overheated termination.

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- The tubing must be completely recovered in the termination area.
- It is acceptable to have the tubing slightly flared at the end where the conductor insulation is exposed, in order to prevent damage to the jacket.

5-3 Assembly Integrity

- The Soldersleeve device must not be split or cut.
- There must be no wire strands poking through the sleeve.
- The tubing and the wire insulation should not exhibit signs of mechanical damage or overheating such as cuts, melting, charring.
- A slight browning of the sleeve is acceptable during the installation process since this does not affect the product performance.

6-0 Repair (If Necessary)

6-1 Repair of an Underheated Termination.

Reheat the underheated termination to obtain proper solder flow (See paragraph 4).

6-2 Repair of an Overheated Termination.

Cut the wires at the sleeve limit and install a new device in accordance with the paragraphs 3 and 4.