

Splice Closure System for Telephone Network

TELECOM OUTSIDE PLANT



XAGA 550 Kit Contents

- Heat-shrinkable sleeve
- Metal canister (2 half shells)
- Self adhering aluminium closing strips
- Channels with underclip
- Branch-off kit
- Abrasive strip
- Desiccant (silica gel)
- Aluminium cable foil
- Cleaning tissue
- Shield continuity wire
- Installation procedure

Notes for branched joints

The standard XAGA 550 kit is designed for maximum two cables branched in one end only. Branched joints for more than two cables require the use of one additional branch off kit (BOKT-5S or 5M or 5L) per added cable.

Safety Rules

- Check manhole for presence of gas and follow locally prescribed precautions.
- When working with open flame, use standard safety equipment such as gloves, safety glasses etc... as required by local practices.

Selection chart

(dimensions: mm)

Raychem description	Max. bundle diameter	Min. cable diameter	Nominal joint Opening (L)	Max. usable length inside metal canister
XAGA 550- 43/ 8-200	43	8	200	250
XAGA 550- 43/ 8-350	43	8	350	400
XAGA 550- 43/ 8-500	43	8	500	550
XAGA 550- 75/15-250	75	15	250	300
XAGA 550- 75/15-500	75	15	500	550
XAGA 550- 75/15-650	75	15	650	700
XAGA 550- 92/25-300	92	25	300	350
XAGA 550- 92/25-500	92	25	500	550
XAGA 550- 92/25-650	92	25	650	700
XAGA 550-122/30-300	122	30	300	350
XAGA 550-122/30-500	122	30	500	550
XAGA 550-122/30-650	122	30	650	700
XAGA 550-160/42-500	160	42	500	550
XAGA 550-160/42-720	160	42	720	770
XAGA 550-200/50-500	200	50	500	550
XAGA 550-200/50-720	200	50	720	770

Recommended torches

Propane torch e.g. Raychem torch:

FH-T001-0005

Nozzles:

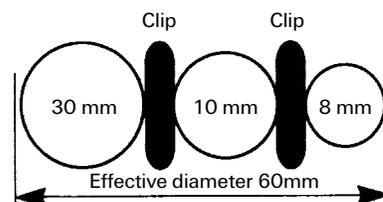
FH-T001-0020: for sizes up to 75/15.

FH-T001-0030: for larger sizes.

XAGA 550 will accommodate a maximum of 3 cables at each end.

For joints with 2 or 3 cables in one end the overall diameter must be determined.

Example for three cables



Add 6 mm for every small clip or 8 mm for every medium clip or 10 mm for every large Clip.

In each case the total diameter must not exceed the max. joint diameter of the kit.

Branching Kit BOKT

Raychem part number

BOKT 5S-43/8-75/15 for

XAGA 550-43/8-XXX

and XAGA 550-75/15-XXX

BOKT 5M-92/25-122/30

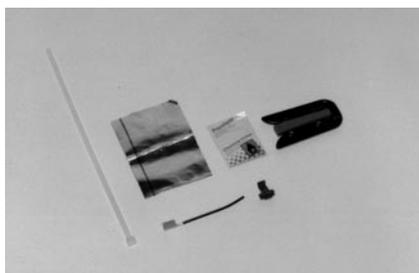
for XAGA 550-92/25-XXX and

XAGA 550-122/30-XXX

BOKT 5L-160/42-200/50

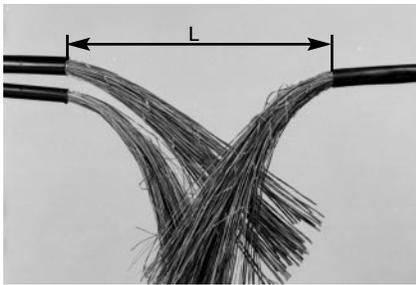
for XAGA 550-160/42-XXX and

XAGA 550-200/50-XXX

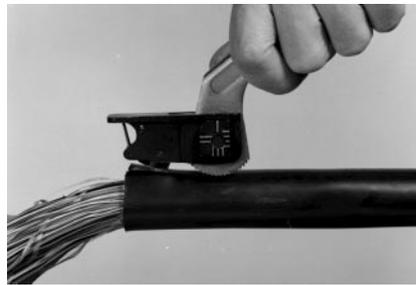


BOKT Kit Content

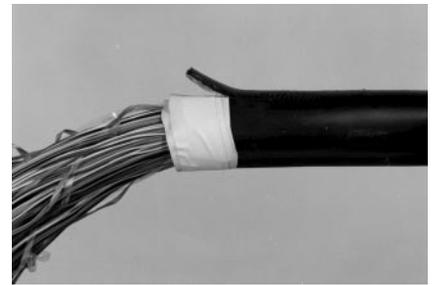
- Branch off clip
- Shield continuity clip + connector
- Cleaning tissue
- Alu foil
- Tie wrap



1 Following local jointing technique and instructions, select appropriate size of XAGA 550. Remove cable sheath for length L.



2 In order to install the shield continuity assembly on each cable use cable sheath slitter to cut cable jacket over a length of 20 mm and a width of 10 mm.



3 Put cotton or PVC tape (not included in standard kit) underneath the cable jacket strip. Complete joint.



4 Take the desiccant out of the aluminium bags and place within the joint.



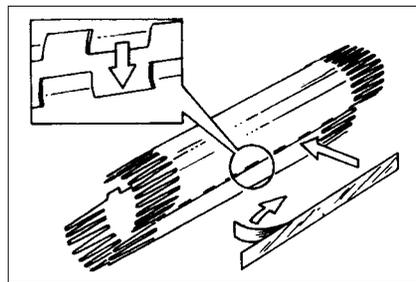
5 Install shield continuity clip with standard pair of pliers.



6 For joints with three or more cables install continuity wire on shield continuity wire assembly using crimp connector.



7 Wrap joint with insulating heat resistant tape (paper insulating tape, cotton tape or equivalent - not included in standard kit). Taped length should not exceed the maximum useable length inside metal canister (see selection chart).



For all sizes: assemble the two half shells symmetrical to form a hinged canister and secure one of the seams with self adhering aluminium tape.



8 Centre and fit metal canister over the joint, and secure canister with tape. Seal canister seam with self adhering strip. Smooth the strip with a blunt tool.



9 Using heat resistant tape (not included in standard kit), tape the crowns, starting from the canister body (10 mm), down to the cables with a 50% overlap. Tape maximum 5 mm onto the cable(s).



10 Remove solvent impregnated tissue from its package and clean the cables for a distance of about 200 mm.

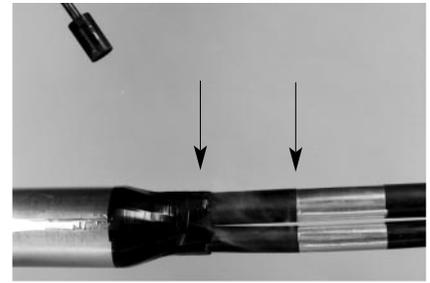


11 Abrade the cables circumferentially over the cleaned length.

12 Use measuring strip (at bottom of installation instruction) from the end of canister and mark bondline length on each cable.



13 Apply the aluminium foil to the cables, positioning the blue line at the mark of the bondlength and smooth the aluminium foil.



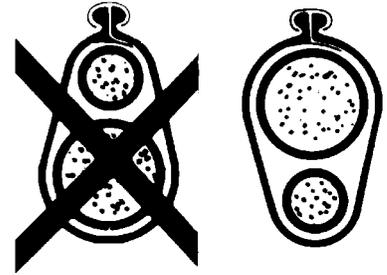
14 Flame brush the PE cable areas between the arrows for about 10 seconds per cable. If lead sheathed cables preheat the cable up to 60°C (hot to the touch).



15 Wrap the sleeve around the canister. Press the underclip over the rails at the centre of the sleeve.



16 Pull flexible channels over the sleeve rails until they butt on top of the underclip. Center the sleeve between the two blue lines of the aluminium foil.



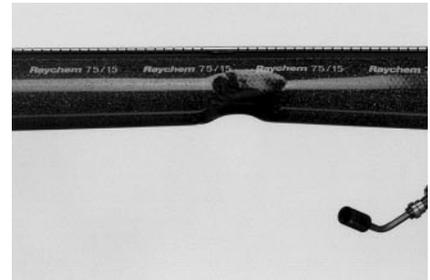
17 In branched configuration the sleeve must be positioned such that the adhesive flap and sleeve rails are over the largest cable (see drawing).



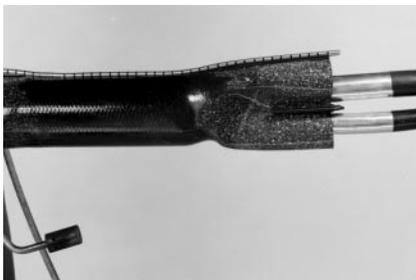
18 Centre the sleeve of the joint. Install the branch-off clip. Ensure that clip is totally inserted. The sleeve must be proportionally wrapped to cable diameter. Note: Select appropriate BOKT-kit as per corresponding XAGA 550 kit.

Notes for heating

- Regulate flame to a total length of 300 mm with a yellow tip of 100 mm.
- During Installation move flame continuously to avoid local overheating.
- Apply heat until the temperature indicating paint has changed colour.



19 Start heating in the centre of the sleeve 180 degrees from the channel area. Continuously heat circumferentially (heating equally on both sides) until arrival at the channel area. The recovery in the channel area should take place towards the end of the installation. Continue heating until the thermo-indicating paint has changed colour from green to black.



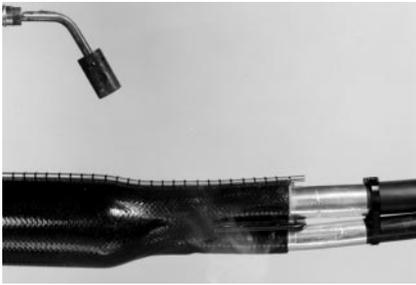
20 Gradually and progressively move towards the end.



21 Press the channel gently down with a blunt tool to give the channel the shape of the canister transition.



22 In branched joints press the branch-off cables, firmly together and secure with tiwrap.



23 Check whether the clip adhesive is seen to flow. If not, apply additional heat all around the clip until the clip adhesive appears at the end.



24 When all T.I. paint has been converted to black of the first half of the closure, two separate lines should be visible in the slots of the channel. If at any point the two white lines are not visible then heat the closure at that point until the white lines appear.



25 Repeat steps 19 through 24 towards the other end of the sleeve.

Allow the completed joint to cool to ambient temperature before moving cable.

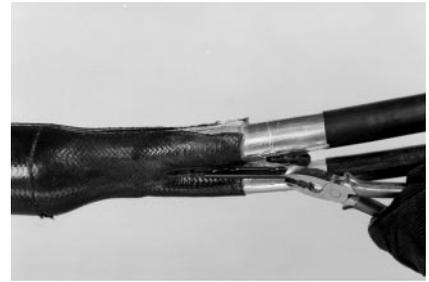
XAGA 550 - re-entry



1 Heat the channel area and remove channel starting at ends cutting towards centre.



2 Reheat gently the sleeve circumferentially at both ends of the splice body and make complete circumferential cuts through the sleeve material onto the inner metal canister.



3 Heat the branch-off clip area and remove the clip with pair of pliers.



4 Remove the sleeve ends with pliers. Reheat slightly if necessary.



5 Remove the aluminium flap of sleeve with a pair of pliers; if necessary reheat.



6 While the adhesive is hot, separate cables with appropriate tool (eg. screwdriver) to facilitate clip insertion when reclosing. Remove tape on the crowns of the canister.



7 Repeat steps 4 through 6 on other side. Locate one of the seams on the canister. Make a cut through the sleeve along the seam and separate the canister.



8 Remove the canister and rework the splice.

Reclosing

Use a new XAGA 550 kit and repeat installation procedure. The remaining adhesive does not have to be removed from the cables, but it has to be cleaned free of grease and dirt.

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