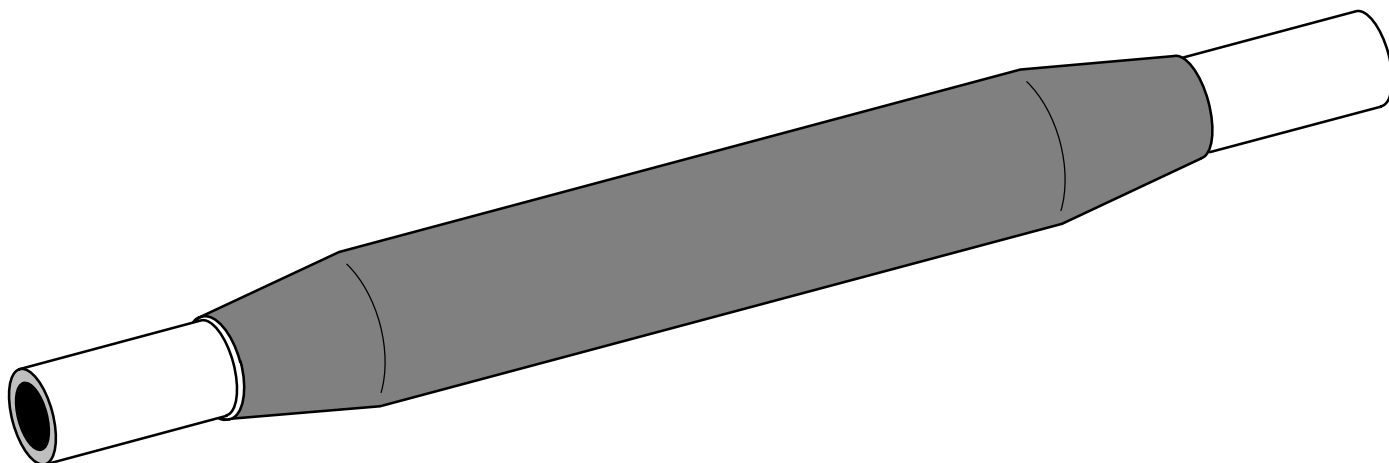


Scotchcast®



Select the kit according to the outer diameter of the cable

Kit Reference	Outer Cable Diameter		Cross Section mm ²	A	L ₁	L ₂	L ₃	L ₄	L ₅
	min	max							
91-AV 120	18	26	4 x 4 to 4 x 6	240	180	140	100	60	-
91-AV 130	25	30	4 x 10 to 4 x 16	330	270	200	130	60	-
91-AV 140	29	34	4 x 25	330	270	200	130	60	-
91-AV 120	18	26	5 x 4 to 5 x 6	240	190	155	120	85	50
91-AV 130	25	30	5 x 10 to 5 x 16	330	280	220	165	110	50
91-AV 140	29	34	5 x 16 to 5 x 25	330	280	220	165	110	50

3M Deutschland GmbH

Issue:

2

Issue date:

10.09.2010

Please note: This product may only be assembled by trained specialized personnel according to these assembly instructions. The preceding specifications are the result of in-depth research. They correspond to the state of our experience. A test by you will convince you of the excellent properties of the 3M products. Verify yourself whether these products are suitable for your purposes. All questions regarding a warranty liability are governed by our terms of sale, unless legal provisions provide differently.

AABBCC62622

1. Issue date: 10.01.08

Language: English

1. Change date: 10.09.10

Drawn: R. Wessel

2. Change date:

Checked: M. Petry

3. Change date:

4. Change date:

Scotchcast®
Flexible Joint and Repair Kit

91-A V 120 (EP)

up to

91-A V 140 (EP)

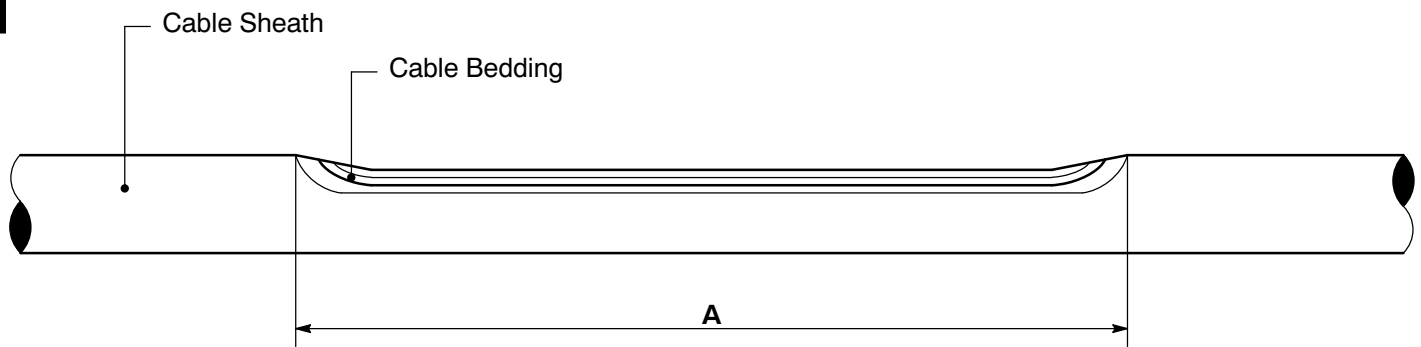
Suitable for Polymeric
and Trailing Cables 0.6/1 kV

3M Electrical Products

XE-0091-1971-2

Cable Sheath Repair

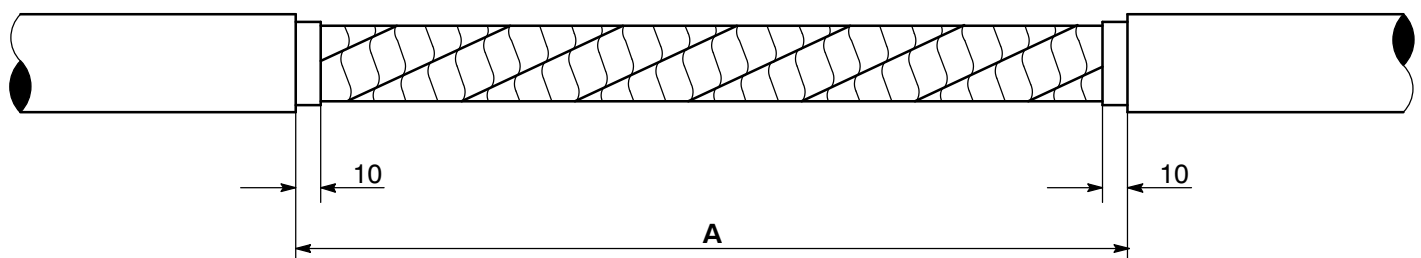
1



Suitable for cable sheath repair only, if the primary insulation or conductor is damaged, follow instructions for complete joint by cutting the cable.

- 1.1 Prepare cable according to the diagram, to required length. Dimension **A** is the maximum repair length.
- 1.2 Remove loose particles of outer sheath or bedding. Bevel the edges of the outer sheath as shown, to create a smooth edge.

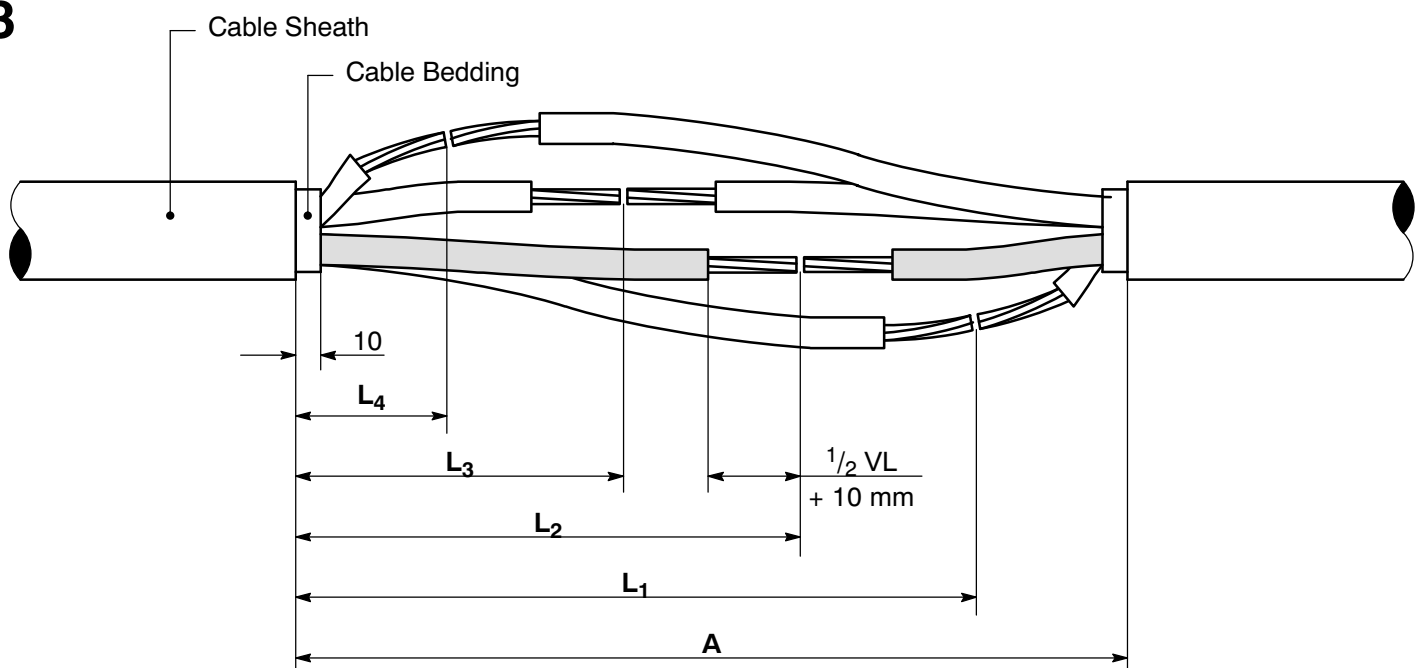
2



- 2.1 For cable sheath damage around the circumference of the cable, remove the sheath completely as shown. Leave 10 mm of bedding layer each side.

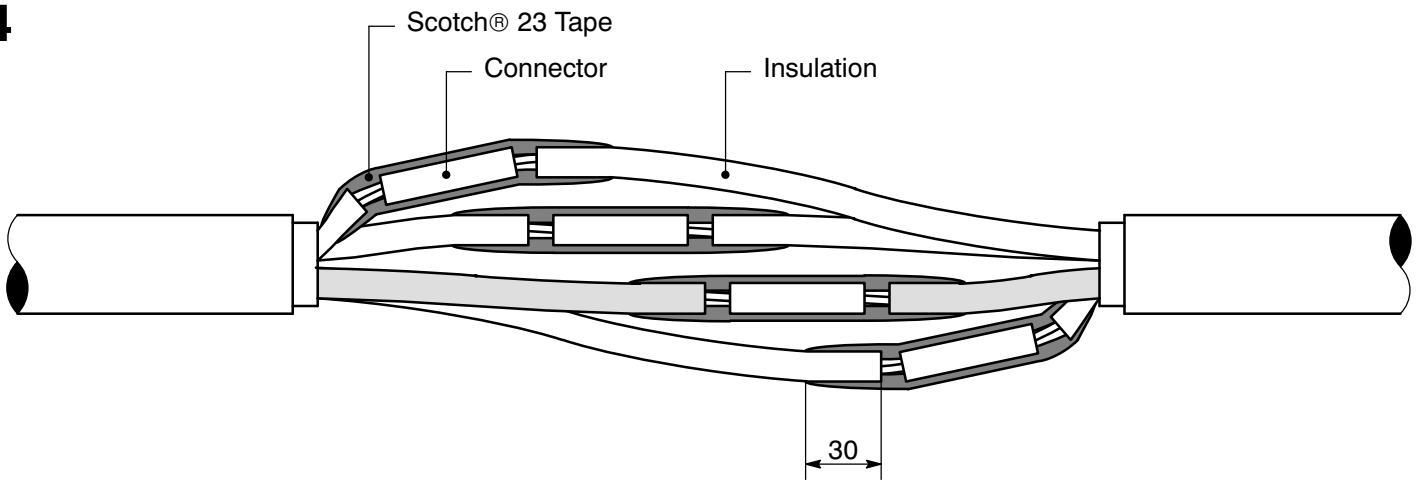
Cable Joint

3



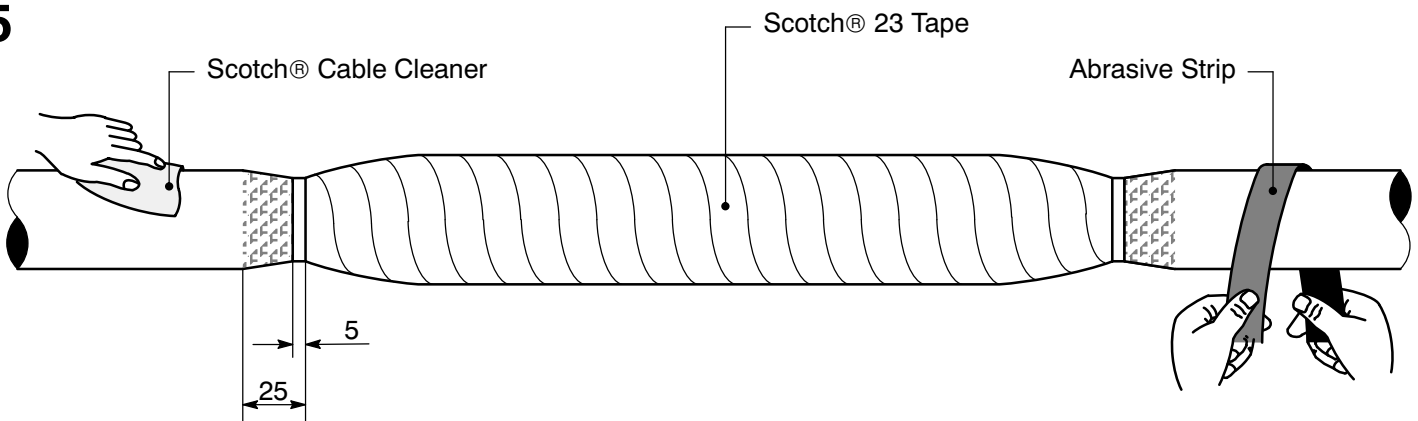
- 3.1 Arrange cores as shown to enable connector installation. Prepare cable according to diagram.
- 3.2 Leave 10 mm of bedding layer each side of the joint.
- 3.3 Cut cores according to dimensions L_1 , L_2 , etc.
- 3.4 Remove primary insulation to $\frac{1}{2}$ the connector length plus 10 mm.

4



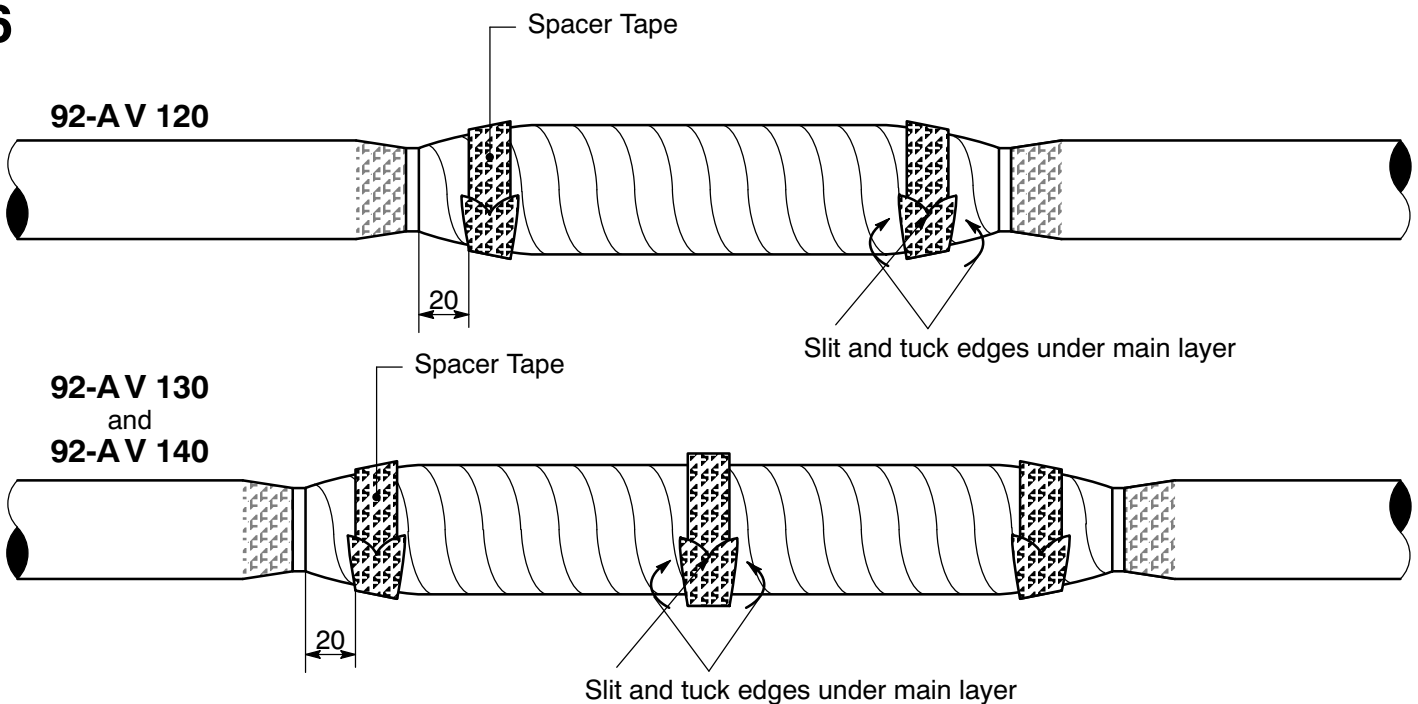
- 4.1 Install connector and remove any sharp edges.
- 4.2 Apply three half lapped layers of Scotch® 23 tape, stretched to approx 100%. Cover the connector, and 30 mm each side onto the insulation as shown.

5



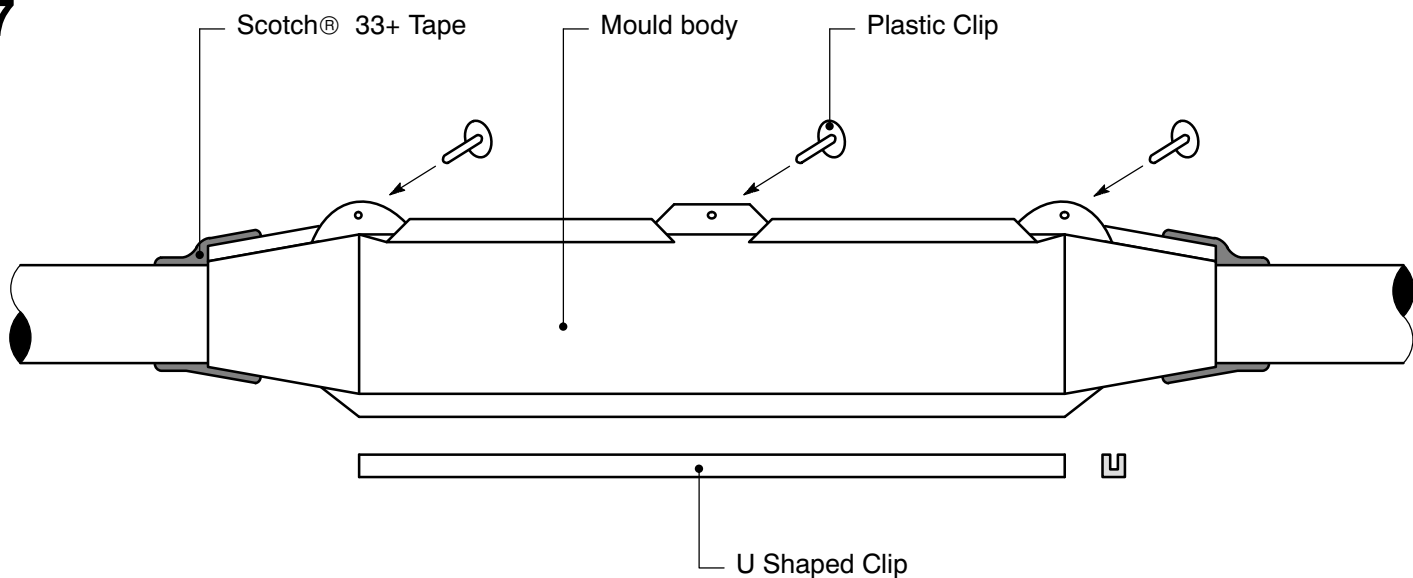
- 5.1 Pencil and smooth the edges of the outer sheath.
- 5.2 Adjust the cable to ensure the joint is straight.
- 5.3 Apply two half lapped layers of Scotch® 23 tape to cover the joint, 5 mm on to the bedding layer each side of the joint.
- 5.4 Clean and abraid the cable sheath each side of the joint in the area to be covered by the mould.

6



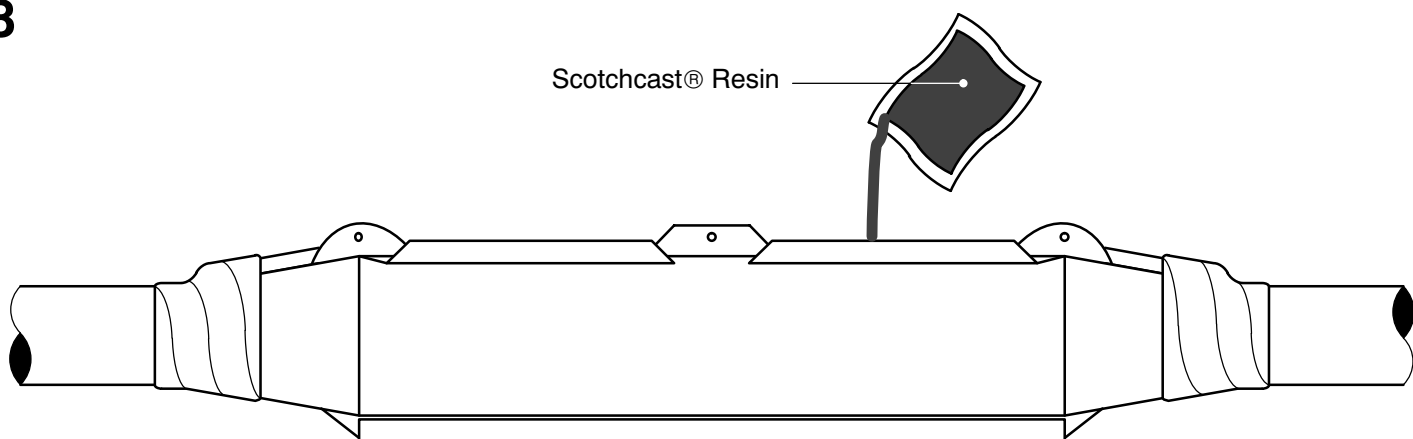
- 6.1 Apply spacer tape as shown, to enable centralisation of the mould.

7



- 7.1 Trim the mould to suit the outer diameter of the cable.
 7.2 Install the mould centrally around the splice, and fix in place with the clips.
 7.3 Seal the mould edges onto the cable sheath with Scotch 33+ tape.

8

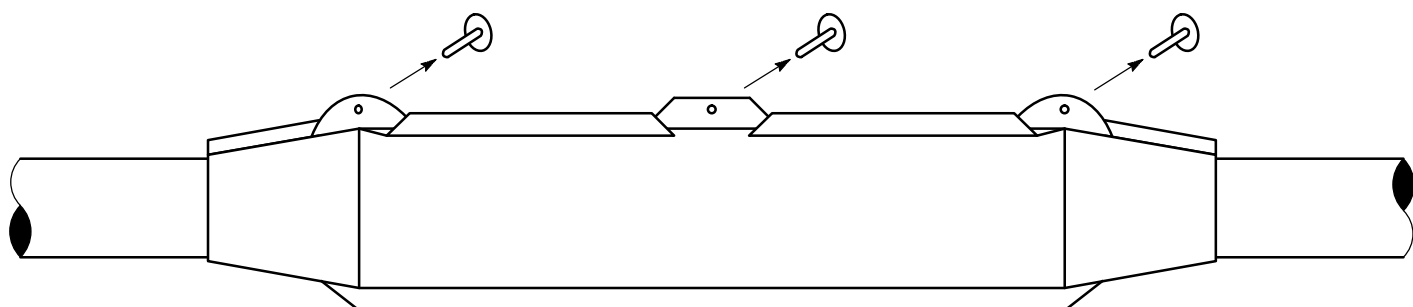


Attention: Fast Curing resin - mix for maximum of 2 minutes!

- 8.1 Mix the resin according to the instructions on the resin pack.
 8.2 Pour the resin into the mould as shown.

9

Ambient Temperature	Demould time Scotchcast® 2131
30°C	4 hours
20°C	5 hours
10°C	7 hours
5°C	11 hours



- 9.1 After resin is cured, remove the 33+ tape.
 9.2 Remove all clips.
 9.3 Remove the mould body, towards the centre of the joint.
 9.4 Trim excess cured resin from joint edges.