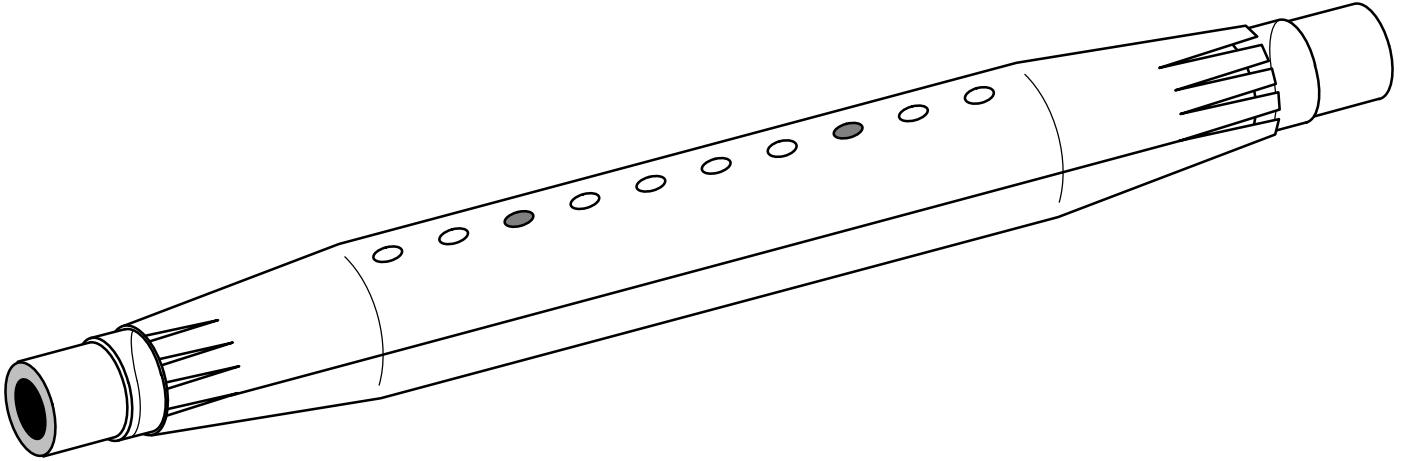


Scotchcast®



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
	min	max						
91-A V 160	40	63	4 x 35 to 4 x 50	360	285	215	145	75
91-A V 170	47	80	4 x 50 to 4 x 120	520	410	310	210	110

3M Deutschland GmbH

Issue:

2

Issue date:

09.09.2010

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.

AABBCC62630

1. Issue date: **10.01.08**

Language: **English**

1. Change date: **09.09.10**

Drawn: **R. Wessel**

2. Change date:

Checked: **M. Petry**

3. Change date:

4. Change date:

Scotchcast®
Flexible Joint and Repair Kit

91-A V 160 (EP)

91-A V 170 (EP)

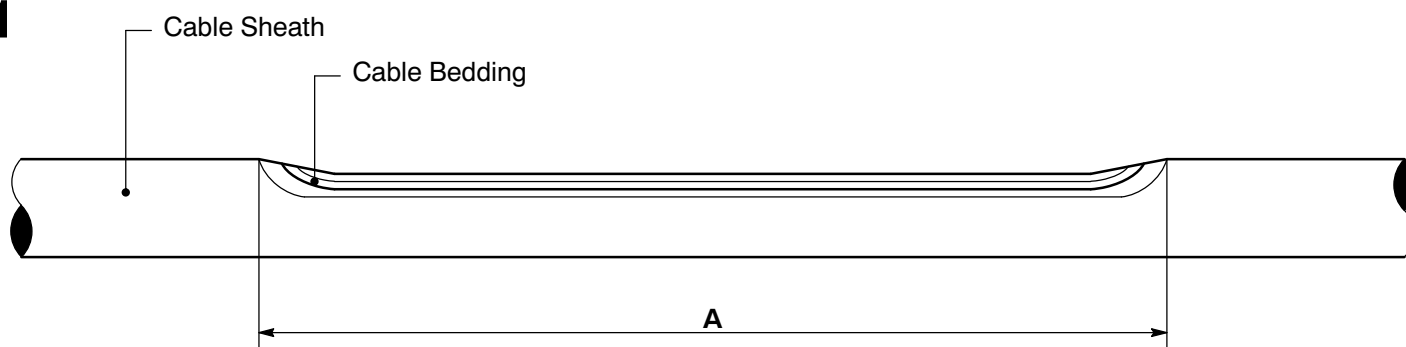
**Suitable for Polymeric
and Trailing Cables 0.6/1 kV**

3M Electrical Products

XE-0091-1972-0

Cable Sheath Repair

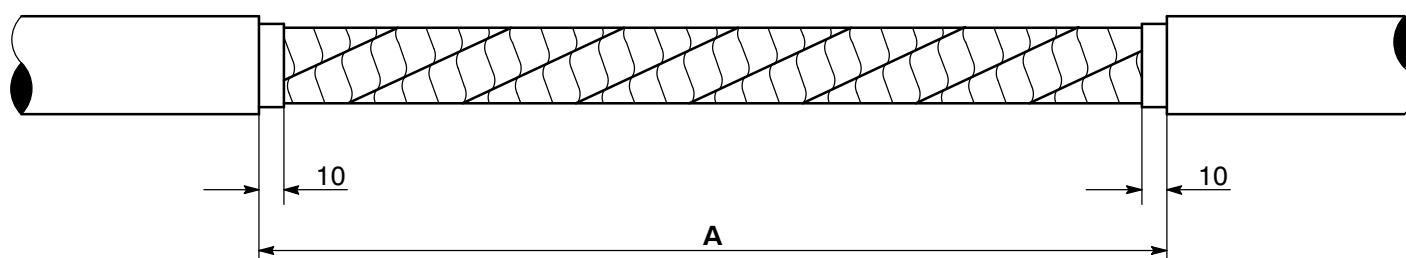
1



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.

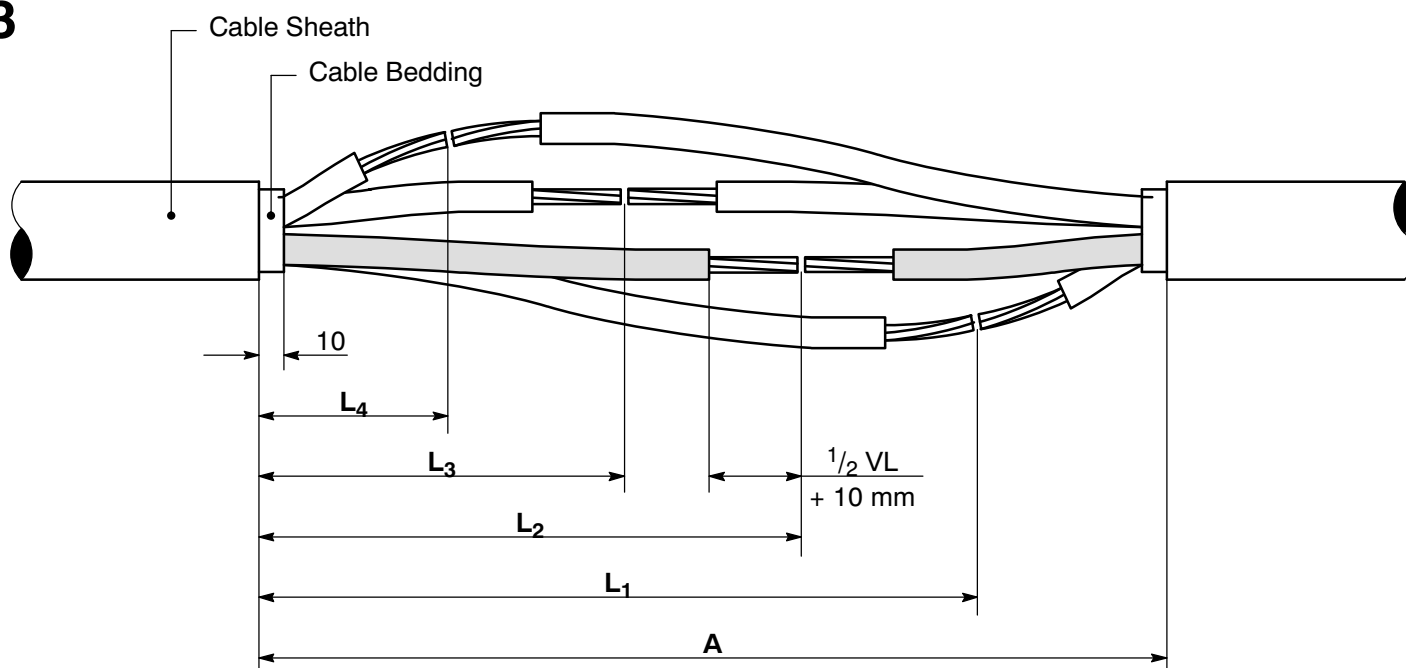
2



- 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.

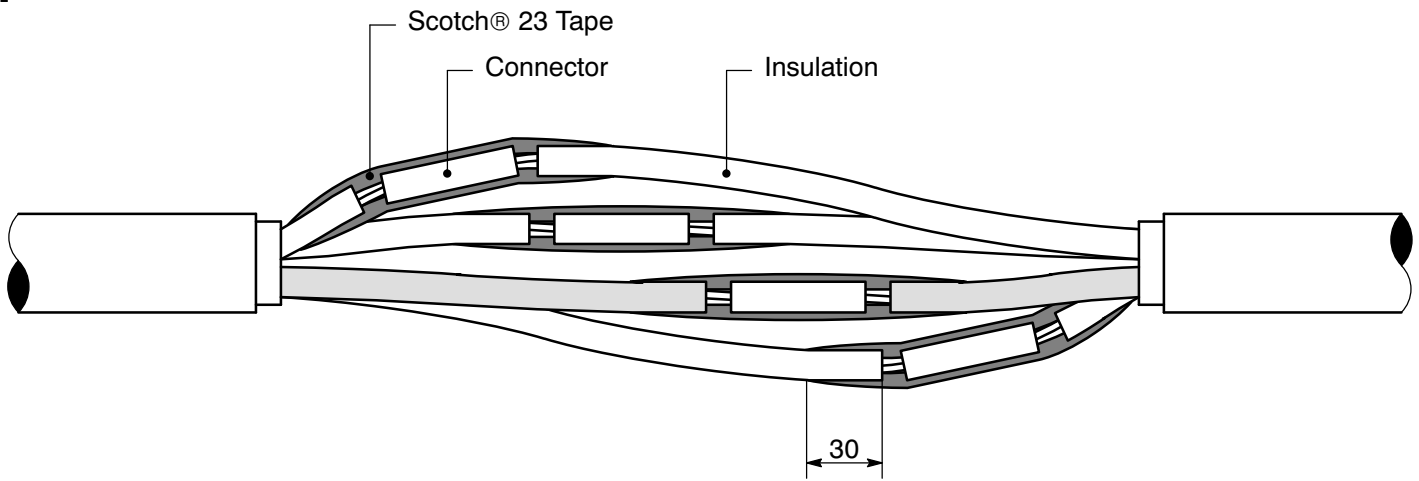
Cable Joint

3



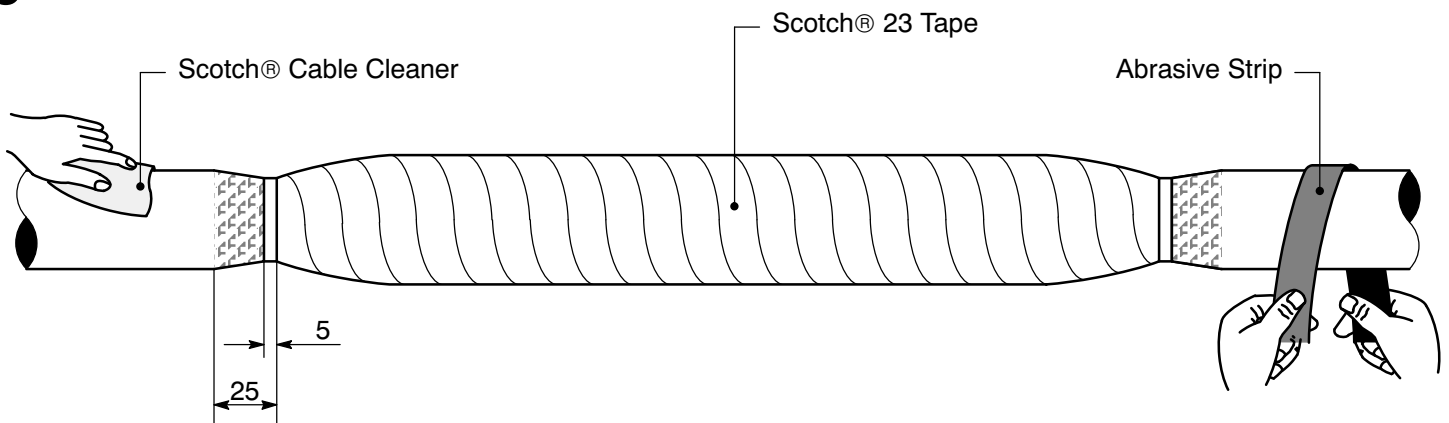
- 3.1 Arrange cores as shown to enable connector installation. Prepare cable according to diagram.
- 3.2 Leave 10 mm of bedding layer each side of the joint.
- 3.3 Cut cores according to dimensions **L₁**, **L₂**, etc.
- 3.4 Remove primary insulation to $\frac{1}{2}$ the connector length plus 10 mm.

4



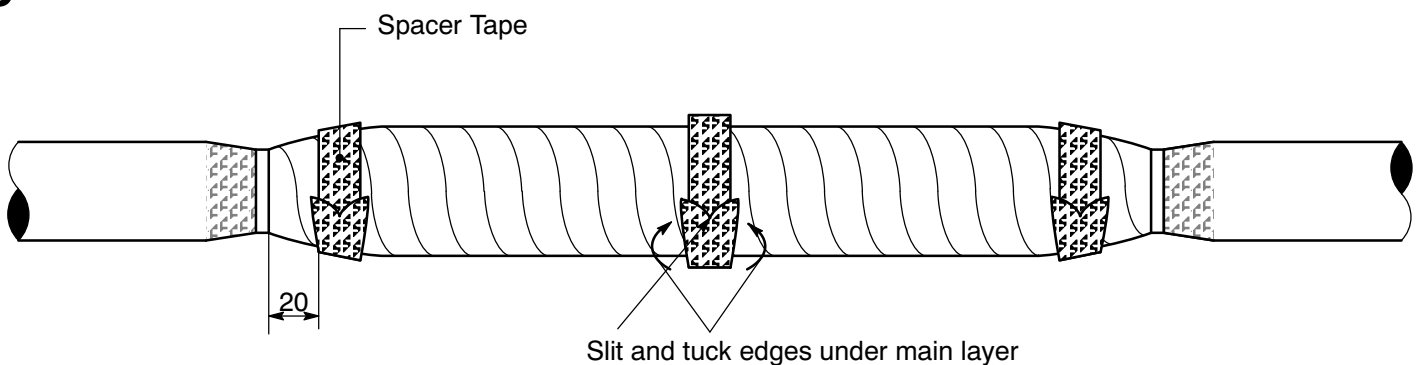
- 4.1 Install connector and remove any sharp edges.
- 4.2 Apply three half lapped layers of Scotch® 23 tape, stretched to approx 100%. Cover the connector, and 30 mm each side onto the insulation as shown.

5



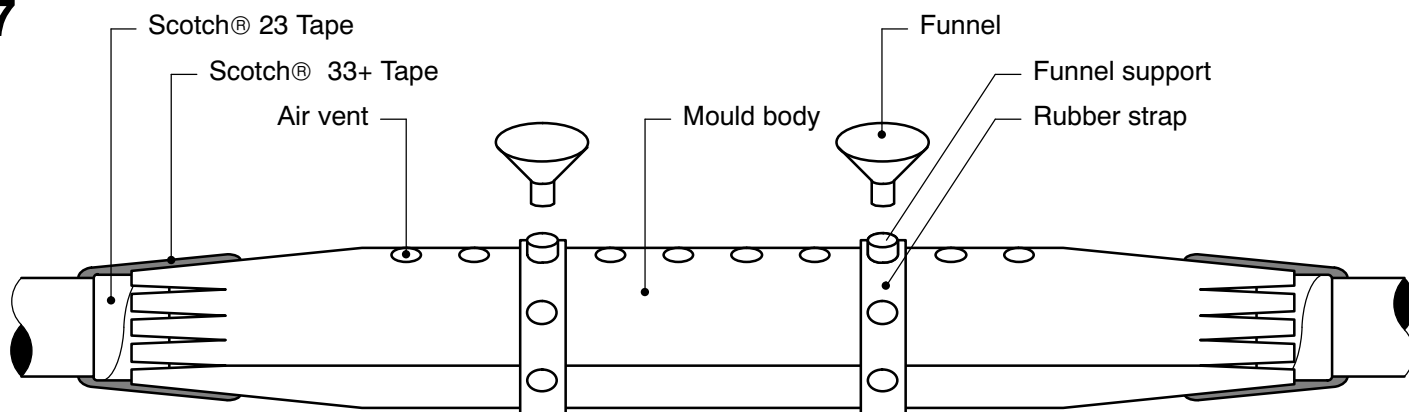
- 5.1 Pencil and smooth the edges of the outer sheath.
- 5.2 Adjust the cable to ensure the joint is straight.
- 5.3 Apply two half lapped layers of Scotch® 23 tape to cover the joint, 5 mm on to the bedding layer each side of the joint.
- 5.4 Clean and abraide the cable sheath each side of the joint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

6



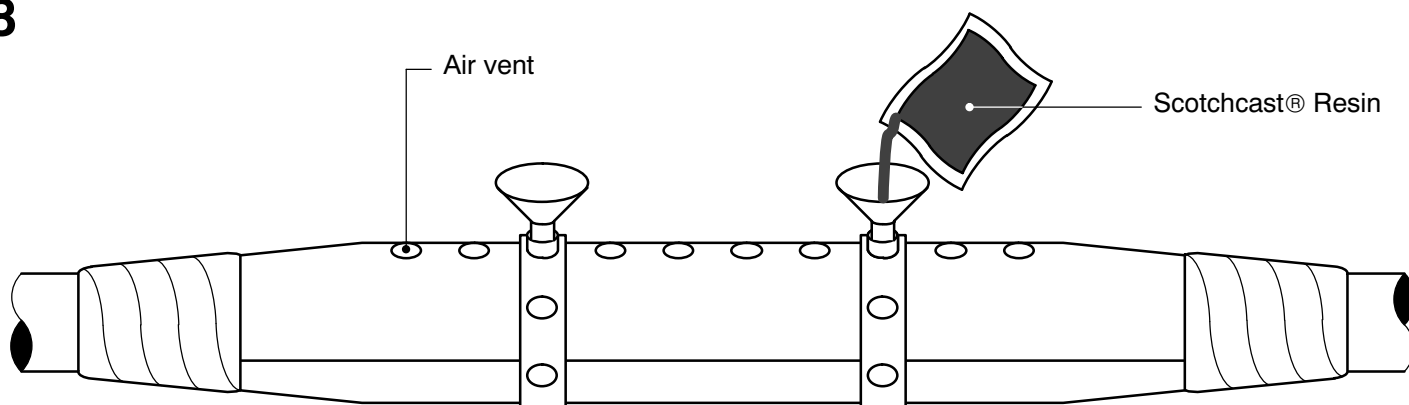
- 6.1 Apply spacer tape as shown, to enable centralisation of the mould.

7



- 7.1 Apply Scotch® 23 tape onto the cable sheath under the edges of the mould.
- 7.2 Wrap the mould body around the joint tightly, ensuring that the air vents are at the top, and the mould is in contact with the spacer tape. It may be necessary to cut the mould to prevent a large overlap when jointing smaller cables.
- 7.3 Slide the rubber strap onto the mould, and install funnel supports, ensuring that they are lined up with the air vents.
- 7.4 Seal the mould onto the cable sheath using Scotch® 33+ tape, ensuring that the shaped edges of the mould are covered.

8

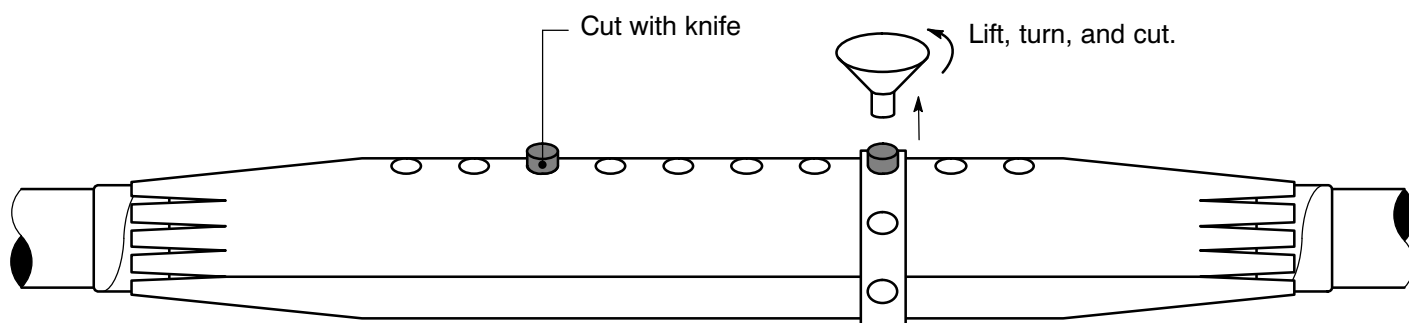


Attention: Fast Curing resin - mix for maximum of 2 minutes!

- 8.1 Mix the resin according to the instructions on the resin pack.
- 8.2 Pour the resin into the mould using the funnels. Ensure any air can be released through the vents.

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 funnel as shown.
- 9.2 Remove the funnel supports and rubber straps.
- 9.3 Remove tape 33+ from each end of the joint.
- 9.4 Remove the mould body.
- 9.5 Trim excess cured resin from joint edges and areas such as overlap or air vent.