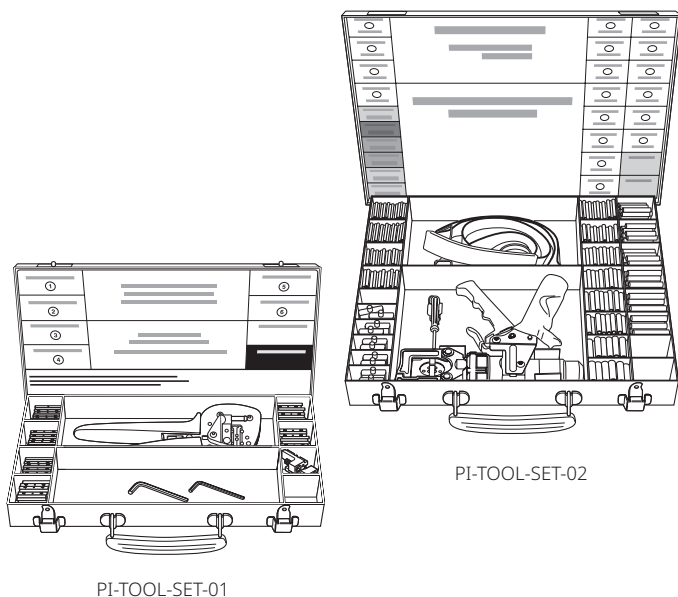


## Toolbox for electrical connection system for PI heating cables

### PRODUCT OVERVIEW



The Raychem PI-TOOL-SET-xx is a handy metal box containing all materials required to connect Polymer Insulated (PI) heating cables to a suitable cold lead and also to splice two PI heating cables. Electrical continuation is maintained via specially engineered crimps, which provide a highly reliable electrical (gas tight) connection.

In order to assure consistently reliable connections, the crimp is to be performed with the specified crimp tool (PI-TOOL-xx) equipped with the appropriate crimping dies (CD-PI-xx). Different tools are available: a mechanical tool for connecting small size cables (up to 2.5 mm<sup>2</sup>) and an hydraulic tool for large size cables (from 4 to 25 mm<sup>2</sup>).

Apart from the crimp tool and dies, the kit contains a variety of crimps (CRP-PI-xx). The tables on this datasheet are providing an overview of the possible combinations of tools, dies and crimps for various PI heating cables. Packs containing 10 pc of crimps are available as spare parts. Connection kits providing the insulation of the connection, have to be ordered separately.

### Application

Electrical connection system for Polymer Insulated (PI) heating cables.

### Kit contents

	PI-TOOL-SET-01	PI-TOOL-SET-02
Crimp tool	PI-TOOL-01	PI-TOOL-02
Crimping dies	CD-PI-02	CD-PI-03, CD-PI-04, CD-PI-05, CD-PI-06
Crimps	PI-CRP-01N, PI-CRP-02N, PI-CRP-03N, PI-CRP-04 to PI-CRP-06 (50 pcs each)	PI-CRP-07 to PI-CRP-017 (50 pcs each) PI-CRP-18 to PI-CRP-24 (25 pcs each)

### ORDERING INFORMATION

Part number (Weight)	1244-000583 (2.5 kg)	1244-000584 (12.5 kg)
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
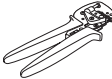
## General Accessories

Crimp tool set with various inserts and crimps	Part number	
PI-TOOL-SET-01	1244-000583	Complete set for cold leads/heating cables up to 2.5 mm <sup>2</sup>
PI-TOOL-SET-02	1244-000584	Complete set for cold leads/heating cables from 4 to 25 mm <sup>2</sup>

Crimp tools (spare part)	Part number	Crimping dies (spare part)	Part number
PI-TOOL-01	1244-000549	CD-PI-02	1244-000554
PI-TOOL-02	1244-000551	CD-PI-03	1244-000552
		CD-PI-04	1244-000553
		CD-PI-05	1244-000555
		CD-PI-06	1244-000556

## Compatibility- and selection chart and selection for crimps, dies and tools


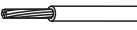


Table 1:  PI-TOOL-SET-01 for conductor size ≤ 2,5 mm<sup>2</sup>

XPI-F Kit	Possible combinations for all XPI (XPI, XPI-S) heating cables (Ω/km)	Crimp type	Part number		Spare tool & crimping dies	
	FROM	TO	(10 pieces per pack)		Die	Tool
CS-150-2.5-PI						
	65 / 100 (only XPI-F) / 180 / 200 / 380 / 480 / 600 / 700 / 810 / 1000 / 1440 / 1750 / 2000 / 3000 / 4000 / 4400 / 5600 / 7000 / 8000	65 / 100 (only XPI-F) / 180 / 200 / 380 / 480 / 600 / 700 / 810 / 1000 / 1440 / 1750 / 2000 / 3000 / 4000 / 4400 / 5600 / 7000 / 8000	PI-CRP-01N	1244-016256	CD-PI-02 (black)	PI-TOOL-01
	11.7	65 / 100 (only XPI-F) / 180 / 200 / 380 / 480 / 600 / 700 / 810 / 1000 / 1440 / 1750 / 2000 / 3000 / 4000 / 4400 / 5600 / 7000 / 8000	PI-CRP-02N	1244-016257		
	11.7 / 15 / 17.8 / 25 / 50 / 80 / 100 (only XPI & XPI-S) / 150 / 320	11.7 / 15 / 17.8 / 25 / 50 / 80 / 100 (only XPI & XPI-S) / 150 / 320	PI-CRP-03N	1244-016258		
	7 / 10 / 11.7 / 31.5 / 100 (only XPI & XPI-S)	65 / 100 (XPI-F only) / 180 / 200 / 380 / 480 / 600 / 700 / 810 / 1000 / 1440 / 1750 / 2000 / 3000 / 4000 / 4400 / 5600 / 7000 / 8000	PI-CRP-04	1244-016259		
	7 / 10 / 11.7 / 31.5 / 100 (only XPI & XPI-S)	11.7 / 15 / 17.8 / 25 / 50 / 80 / 100 (XPI & XPI-S only) / 150 / 320	PI-CRP-05	1244-016260		
7 / 10 / 11.7 / 31.5 / 100 (only XPI & XPI-S)	7 / 10 / 11.7 / 31.5 / 100 (only XPI & XPI-S)	PI-CRP-06	1244-016261			

**Important:** The electrical insulation for the crimp connection has to be ordered separately (CS-150-xx-PI). If the inscriptions on crimps PI-CRP-01N, PI-CRP-02N and PI-CRP-03N do not contain 'N', please do no longer use. Contact Chemelex for more information.

## Crimp selection and installation table

Table 2:  PI-TOOL-SET-02 for conductor size 4 to 25 mm<sup>2</sup>

XPI-F Kit	Possible combinations for all XPI (XPI, XPI-S) heating cables (Ω/km)	Crimp type	Part number		Spare tool & crimping dies	
	FROM	TO	(10 pieces per pack)		Die	Tool
CS-150-6-PI					CD-PI-03 (Grey)	
	4.4	11.7 / 15	PI-CRP-07	1244-016262		
	4.4	7 / 10	PI-CRP-08	1244-016263		
	4.4	4.4	PI-CRP-09	1244-016264	CD-PI-04 (Blue)	
	2.9	11.7 / 31.5 / 100 (only XPI & XPI-S)	PI-CRP-10	1244-016265		
	2.9	7 / 10	PI-CRP-11	1244-016266		
	2.9	4.4	PI-CRP-12	1244-016267		
2.9	2.9	PI-CRP-13	1244-016268			
CS-150-25-PI	1.8	7	PI-CRP-14	1244-016269	CD-PI-04 (Blue)	
	1.8	7 / 4.4	PI-CRP-15	1244-016270		
	1.8	2.9	PI-CRP-16	1244-016271		
	1.8	1.8	PI-CRP-17	1244-016272		
	1.1	4.4	PI-CRP-18	1244-016273	(Red) V + N	
	1.1	2.9	PI-CRP-19	1244-016274		
	1.1	1.8	PI-CRP-20	1244-016275		
	1.1	1.1	PI-CRP-21	1244-016276		
	0.8	2.9	PI-CRP-22	1244-016277	CD-PI-06 (Yellow) V + N	
	0.8	1.8	PI-CRP-23	1244-016278		
0.8	1.1	PI-CRP-24	1244-016279			

**Important:** The electrical insulation for the crimp connection has to be ordered separately. (CS-150-xx-PI)

### The crimp for the electrical connection of the braid is included in the CS-150-xx-PI kit

Table 3: CS-150-xx-PI braid crimps

Kit	Cable family used in kit	Braid crimp to use	Part number	Die	Tool
CS-150-2.5-PI	XPI-F	BR-CRP-1.5	1244-018980	CD-PI-02	PI-TOOL-01
	XPI	BR-CRP-2.5	1244-016304	CD-PI-02	PI-TOOL-01
	XPI-S	BR-CRP-2.5	1244-016304	CD-PI-02	PI-TOOL-01
CS-150-6-PI	XPI-F	BR-CRP-2.5	1244-016304	CD-PI-02	PI-TOOL-01
	XPI	BR-CRP-6	1244-016305	CD-PI-03	PI-TOOL-02
	XPI-S	BR-CRP-6	1244-016305	CD-PI-03	PI-TOOL-02
CS-150-25-PI	XPI-F	BR-CRP-2.5	1244-016304	CD-PI-02	PI-TOOL-01
	XPI	BR-CRP-25	1244-016306	CD-PI-04	PI-TOOL-02
	XPI-S	BR-CRP-25	1244-016306	CD-PI-04	PI-TOOL-02

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