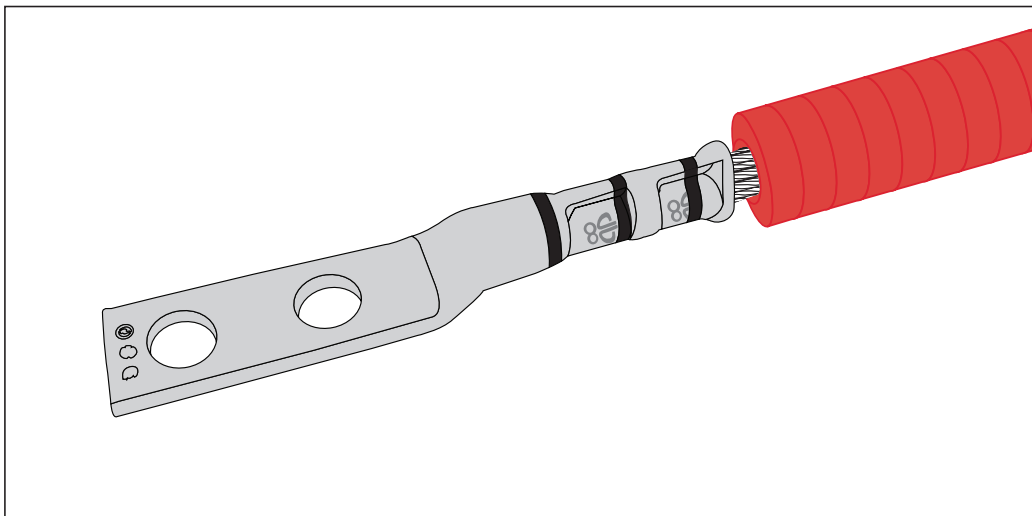


STS-HV

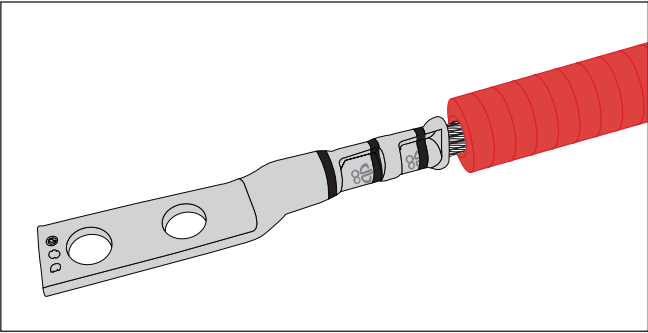
End Termination Installation Instructions (Power and End Term Boxes)



End Termination Installation Instructions (Power and End Term Boxes)

Minimum installation temperature is 0°C (32°F).

NOTE: A clean environment is necessary when performing this installation. The work area must be free of dust, dirt, sand, debris, rain and any other contaminants.



DESCRIPTION

The Raychem STS-HV End Termination Installation Instructions (H61694) illustrate the steps required to properly assemble an STS-HV End Termination. These instructions should be used in conjunction with the Raychem STS-HV End Termination Kit (1244-022791), the Raychem STS-HV Tool Kit (1244-022620) and the Raychem STS Crimp Kit Work Instructions (H87227). The kits contain materials and tools intended for use with STS-HV heating cables to make approved power terminations. For technical support, contact your Chemelex representative or call Chemelex at (800) 545-6258. You can also reach us via our website: chemelex.com.

ITEMS REQUIRED FOR INSTALLATION

Item	Qty	Description	Source
A	1	Sapphire Blue Marker	Tool Kit
B	1	Shaving Tool (with replacement blade)	Tool Kit
C	1	Flat Cable Shears	Tool Kit
D	1	Crimp Lug	End Term. Kit
E	1	Hydraulic Crimper and Die U4CRTW, Grey #8	Crimp Kit
F	2	Gloves	End Term. Kit
G	2	HP Cleaning Wipes	End Term. Kit
H	2	1/4" Hex Screws, Bellville & Flat Washers	End Term. Kit

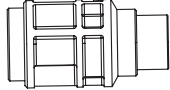
APPROVALS

PTB 21 ATEX 1005 X
II 2 G Ex eb 60079-30-1 IIB T6...T3 Gb
II 2 D Ex tb IIIB T80°C...T200°C Db

IECEX PTB 21.0011X
Ex eb sb IIB T6...T3 Gb
Ex tb sb IIIB T80°C...T200°C Db



A



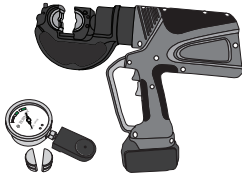
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C



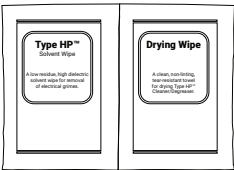
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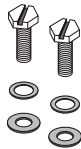
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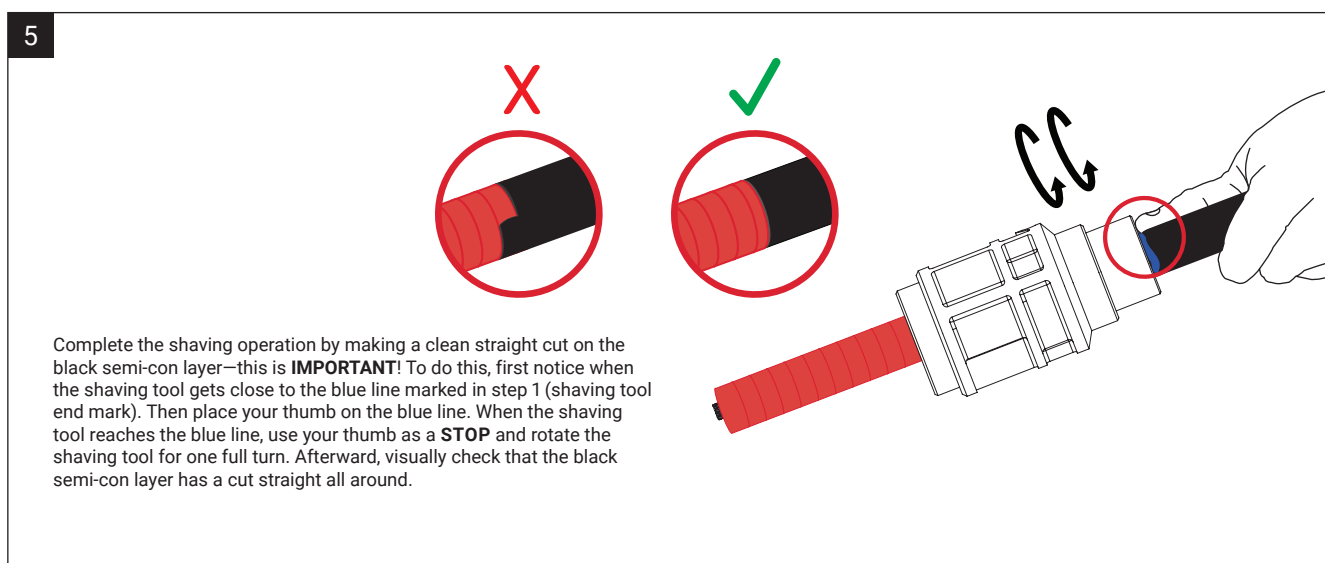
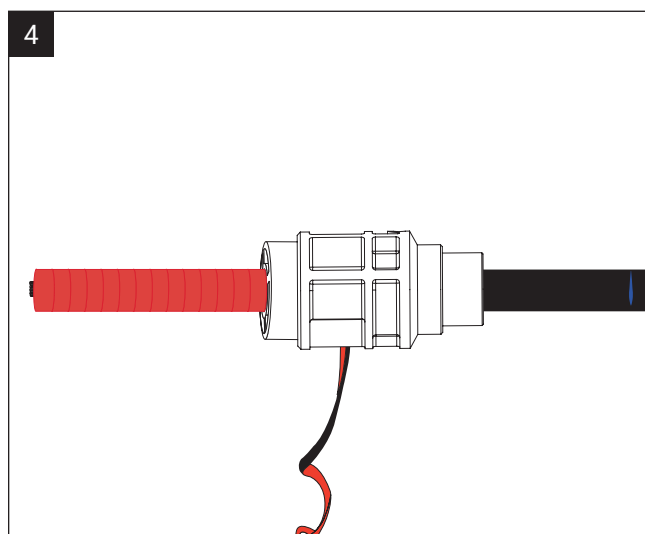
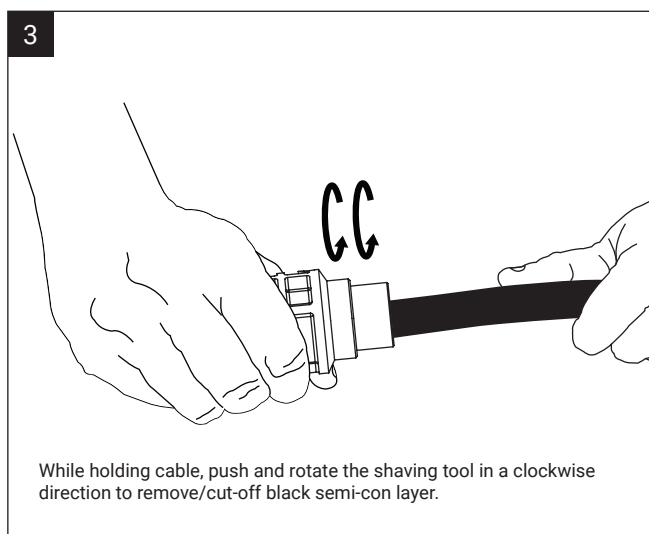
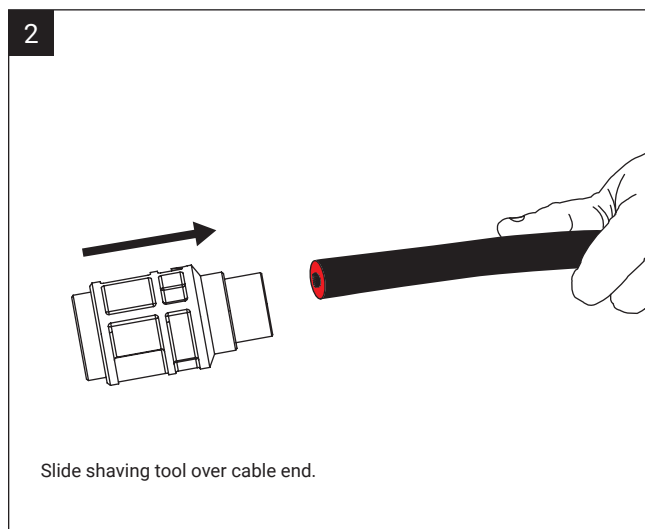
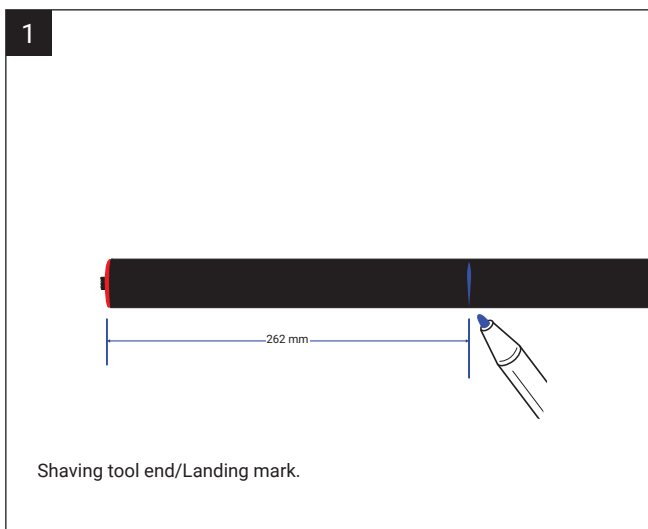
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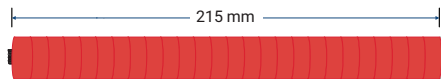
G



H

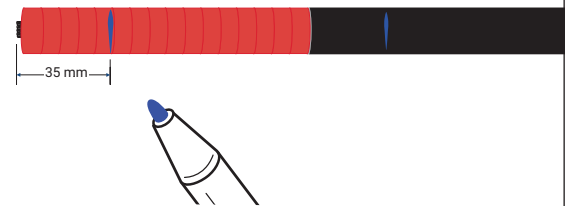


6



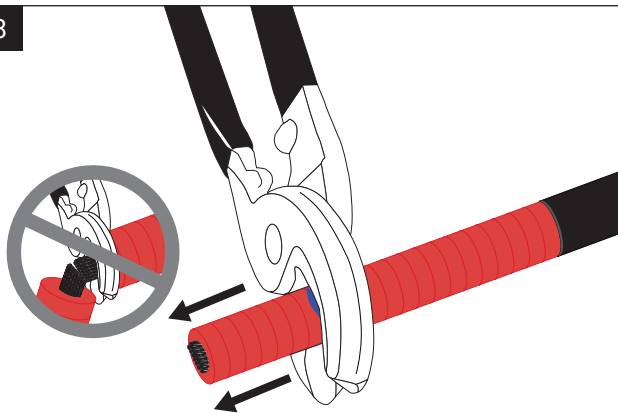
Verify distance to black semi-con layer is 215 mm.

7



Insulation Strip mark

8

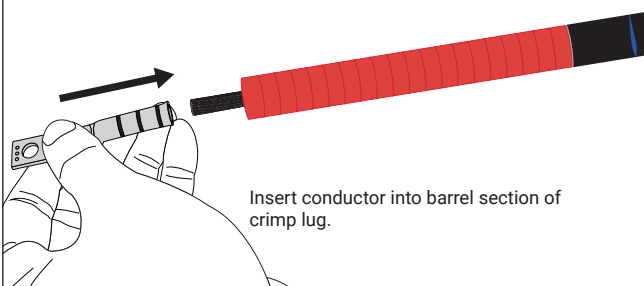


Strip off 35 mm of insulation and remove black paper layer to expose bare conductor. **IMPORTANT:** do not cut any conductor wires.

9

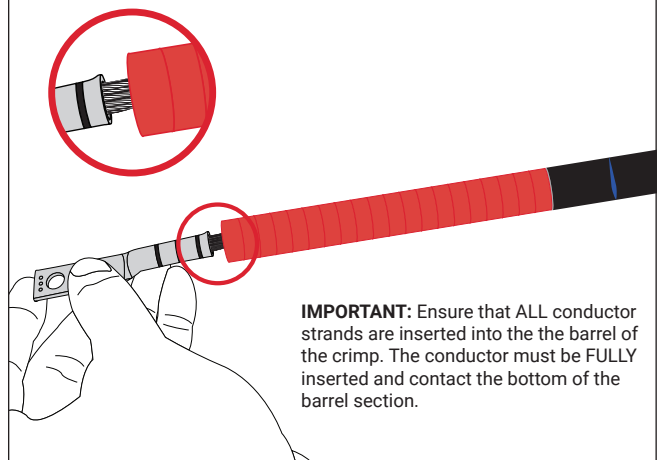


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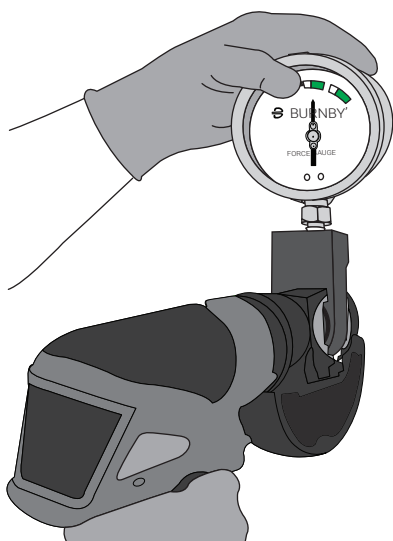
Insert conductor into barrel section of crimp lug.

11



IMPORTANT: Ensure that ALL conductor strands are inserted into the the barrel of the crimp. The conductor must be FULLY inserted and contact the bottom of the barrel section.

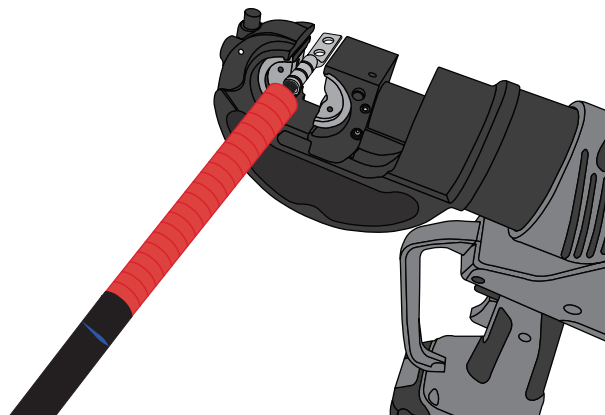
12



Calibrate hydraulic crimper using calibration dies and Force Test gauge to ensure compression force is at least 12 Tons. Install the blank dies, perform the crimp on the gauge, and ensure the needle reaches the accepted 12 ton zone before proceeding to the next step. Detailed calibration instructions can be found in the Raychem STS Crimp Kit Work Instructions (H87227).

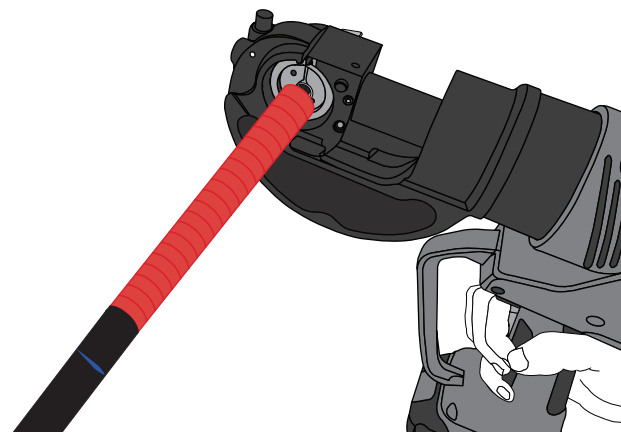
13

Place crimp lug with inserted conductor into groove of crimping die. Align barrel section of crimp lug so that it is in the center of the die compression zone.



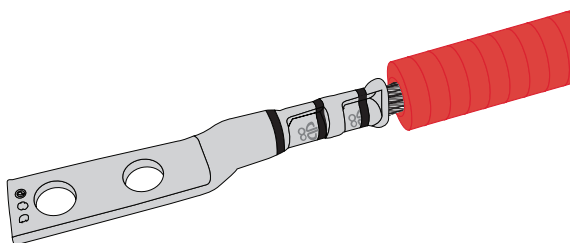
14

Compress barrel section of crimp lug onto conductor by using hydraulic crimping tool to press the die halves together.

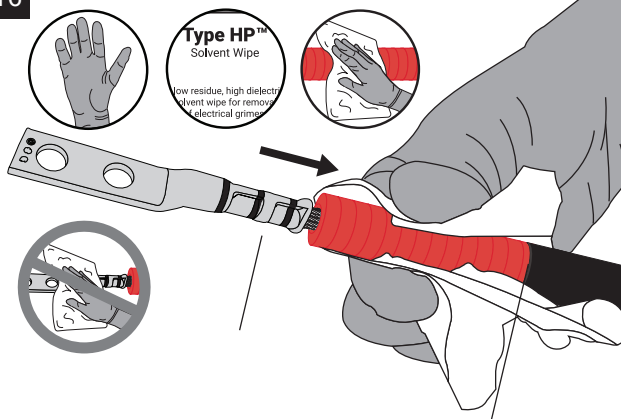


15

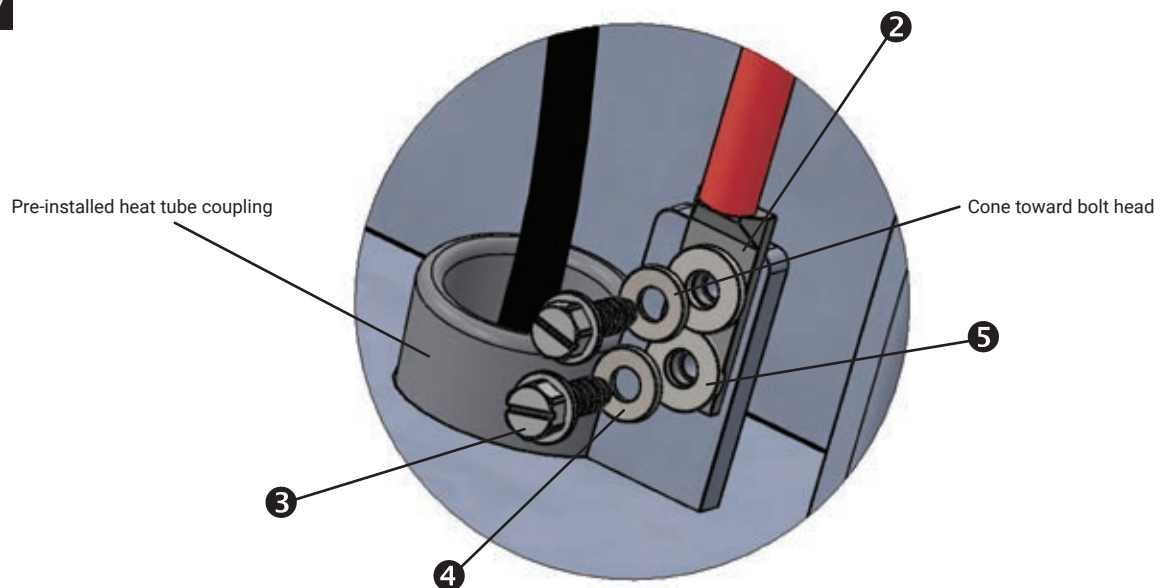
Ensure the die's embossing mark has been engraved into the crimped lug and is visible before proceeding. This is a quality check for a properly formed crimp.



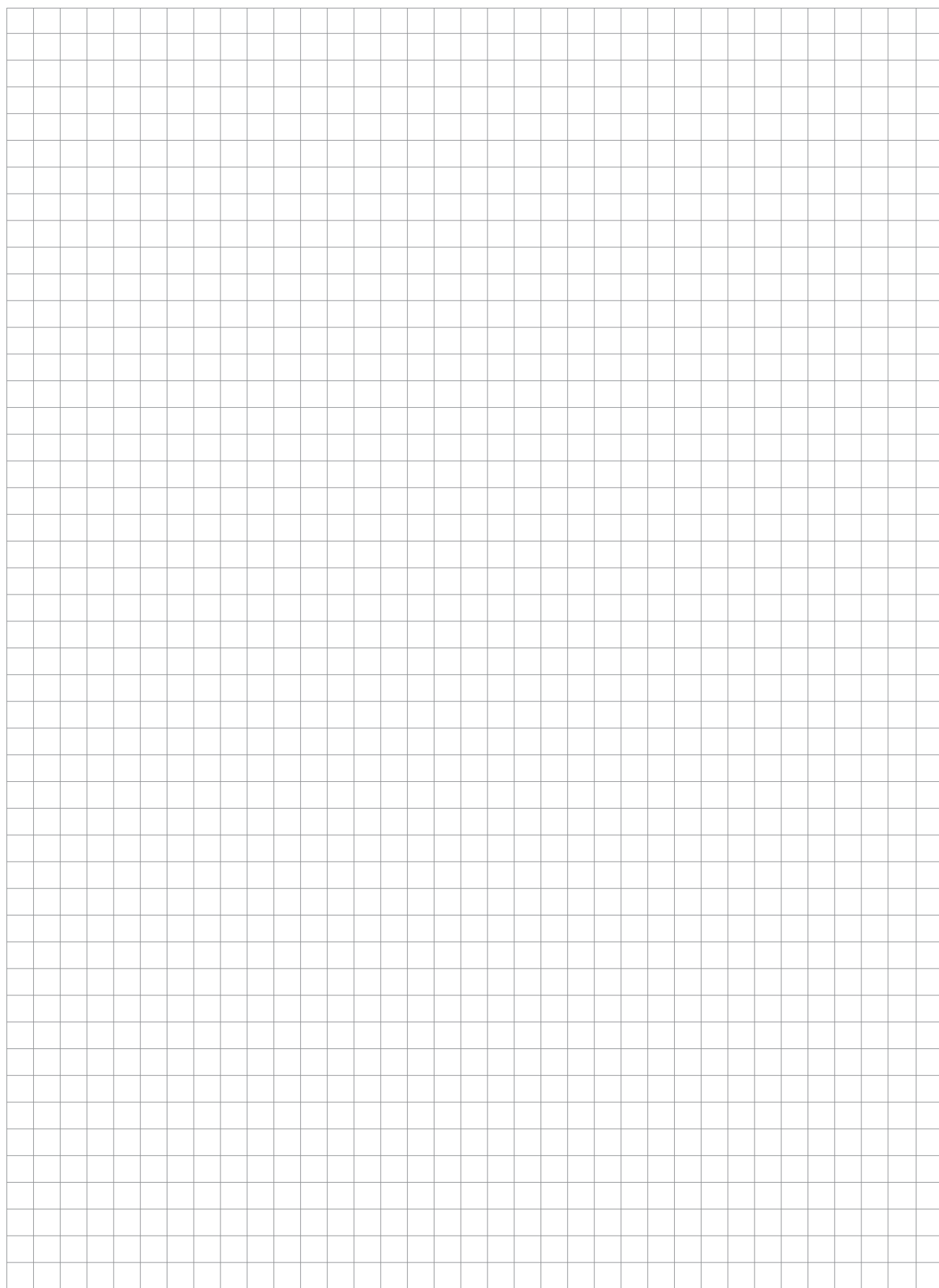
16



Use gloves and Solvent Wipe to clean insulation and remove any surface debris. Wipe in one direction only, going from the crimp lug towards the black semi-con layer.



Clean the tube terminal surface and termination lug 2 with the HP wipes, removing any dirt, grease or corrosion. Bolt the termination lug 2 to the terminal using two sets of the 1/4" bolt hardware. Be sure to place the washers as shown, and ensure that the Bellville washer 4 has the cone toward the bolt heads, with the flat washers 5 against the termination lug 2. Tighten bolt 3 until the Bellville washer 4 has just flattened.



North America

Tel +1 800 545 6258
info@chemelex.com

Latin America

Tel +1 713 868 4800
info@chemelex.com

Europe, Middle East, Africa, India

Tel +32 16 213 511
Fax +32 16 213 604
info@chemelex.com

Asia Pacific

Tel +86 21 2412 1688
infoAPAC@chemelex.com

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