

# Constructing a Proper Heatshrink Joint

Best Practice Procedures Straight through Joint 0.6 to 1KV High Ratio Tubing by Nu-Tech.us A products division of Cross Technology Inc

## Tube Selections

- **Size Selection** Choose a Heatshrink Tube size that recovers (smallest shrink dimension) A general rule of thumb is at least 10% smaller than the O.D. of the cable or jacket being covered.
- **Tube Length Selection** Allow sealing room on the cable jacket at each end of the joint. As High Ratio tubing is recovered it will grow slightly in length it is best to have more than not enough coverage so slightly longer is better.
- **Hot Melt Adhesive Lining** For added creep resistance and moisture proofing, Hot-melt linings provide dual walled protection for use in extreme service & environments

## Deployment into service

Figure 1 and 2

- Remove cable jacket outer sheath and expose core wires.
- Clean the cable before sliding over the heatshrink tubing. We can supply Solvent Wipes or menthylated spirits on a clean rag can be very effective.
- Slide inner heat shrink insulation sleeves over cores, and outer heatshrink sleeve over cable jacket.

Figure 3

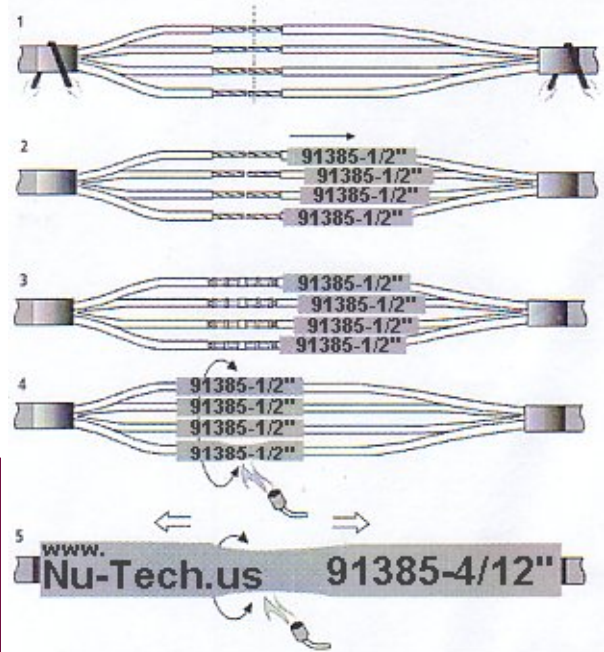
- Connect/crimp the conductors ensuring not to create any sharp points that could compromise your shrink tubing upon recovery.

Figure 4

- Slide the inner heat shrink insulation sleeves over the connectors whilst ensuring equal overlap on both sides of all connection points.
- By applying heat, shrink the inner tubing from the middle towards the outside edges. Be sure to keep moving the heat to ensure adequate distribution of shrinkage and avoid charring of the shrink tube.

Figure 5

- Slide the outer heat shrink jacket sleeve over the exposed cores and shrink. Pay attention to equal overlapping on both ends
- Adhesive flowing from the ends upon recovery indicates a moisture proofed seal.



Operating characteristics:

- 7,880 V/mm Dielectric performance
- Fast Shrinkage @ 120 C
- Cross-linked Polyolefin w/ Adhesive Lining
- Flame Retarded rated Non-Burning (ASTM D635)
- Suitable for Direct Burial
- Resists UV degradation
- Hot-Melt lining flows to fill voids and crevices upon recovery for a moisture proofed seal

