Company Directive

STANDARD TECHNIQUE : CAØN/2

Relating to Procedures for Making
LV Service Cable Stop Ends

Policy Summary

This Standard Technique document contains the entire approved LV Service heat shrink and cold applied/pour Stop Ends for PVC Plain or Split Concentric and PILC cables. It shall be implemented in conjunction with the appropriate General Requirements in ST: CAØC.

This ST has not been written as a training document. It is not intended to be exhaustive in content and you must refer to your supervisor if you require training or instruction.

You shall work safely and skilfully, utilising the training/instruction you have already received, relating to the contents of this document and its cross-references.

You must make sure that you understand your job instructions and that you have the necessary tools and equipment for the job.

Author: Richard Summers

Implementation Date: July 2014

Approved by

Policy Manager

Date: 8 September 2014
IMPLEMENTATION PLAN

Introduction

This Standard Technique has been updated to correct errors in the numbering of the General Requirements and include the use of solvent wipes.

Main Changes

- General Requirement numbers amended
- SVJ 7.301.1 measurements amended
- SVJ 7.302.1 measurements amended
- Solvent wipes included in the Standard Techniques

Impact of Changes

The core cut length has been increased to 75mm to make fitting the cap easier when the neutral / earths are shrouded.

Implementation Actions

Distribution Managers and Team Managers shall brief their teams on the contents of this policy to the relevant staff.

Word Processing to issue copies to paper manual holders (Midlands and South)

Implementation Timetable

Immediate
<table>
<thead>
<tr>
<th>Date</th>
<th>Comments</th>
<th>Author</th>
</tr>
</thead>
<tbody>
<tr>
<td>July 2014</td>
<td>• Correction of General Requirement Numbers.</td>
<td>Richard Summers</td>
</tr>
<tr>
<td></td>
<td>• SVJ 7.301.1 measurements amended</td>
<td></td>
</tr>
<tr>
<td></td>
<td>• SVJ 7.302.1 measurements amended</td>
<td></td>
</tr>
<tr>
<td></td>
<td>• Inclusion of cable solvent wipes</td>
<td></td>
</tr>
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</table>
ST: CAØN/2 PROCEDURES FOR MAKING LV SERVICE CABLE STOP ENDS

INTRODUCTION

This Standard Technique document contains all the approved service cable stop ends, which shall be implemented in conjunction with the appropriate General Requirements contained in ST:CAØC, including:

1. General Cleanliness and Accident Prevention
2. General Jointing Procedures - Dead Cables
3. General Jointing Procedures and Safety Precautions - Live Cables

Resin encapsulated joints must not be broken down.

If the need arises to undertake a service stop end (ie non-standard) not covered within this Standard Technique the Policy Manager, Head Office, is to be consulted.

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</tr>
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<td>35mm² CNE Wavecon (Three Phase)</td>
<td>35</td>
</tr>
</tbody>
</table>

Note: - Any reference to plain concentric equally applies to hybrid. The phase conductor insulation may be either XLPE or PVC.
ST: CAØN/2 PROCEDURES FOR MAKING SERVICE CABLE
STOP ENDS

JOINTING PROCEDURE 7.301

PVC PLAIN CONCENTRIC SERVICE CABLE
STOP END - SINGLE PHASE

This procedure is to be read in conjunction with the appropriate
General Requirements ST: CAØC Section 6
of the LV Service Cable Jointing Manual

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JOINTING PROCEDURE 7.301

MATERIALS LIST

CABLE SIZES - 25/35mm² Hyb or 16/25mm² Cu Plain Conc

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
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</thead>
<tbody>
<tr>
<td>Stop End Kit SMOE 81613</td>
<td>1</td>
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ADDITIONAL ITEMS FOR EACH JOINT

- PVC tape
- Emery cloth
- De-solvit 1000FD
- Workhorse dry wipes
- Cable solvent wipes

Note: Individual material item numbers (SHOPS) are to be found in Section 4 of the LV Service Cable Jointing Manual.
## JOINTING PROCEDURE 7.301

**Actions** | **General Requirements**
---|---
Refer to Drawing **SVJ 7.301.1** whilst undertaking this Jointing Procedure | (ST: CAOC)

1. Set up and mark cable | 4
2. Open and cut cable in accordance with General Requirement - Fig 1. | 13
3. Prepare neutral/earth wires for jointing - Fig 2 | 7
4. Apply temporary shrouding | 17
5. Cut phase conductor to length - Fig 2 | --
6. Thoroughly degrease the phase conductor insulation | 29
7. Fit and shrink the small phase conductor cap into place - Fig 3. **Allow to cool** | 21
8. Remove temporary shrouding applied in 4 | --
9. Lay the neutral/earth wires over the conductor phase cap and turn back to the oversheath termination - Fig 4 | --

**NOTE:** The neutral/earth wires must be spaced to form an earth screen over the phase conductor and cap

10. Ensure the wires are evenly spaced, trim off at the oversheath, termination and secure with PVC tape - Fig 4 | --
11. Abrade the oversheath - Fig 4 | 26
12. Thoroughly degrease the complete termination | 29
13. Fit and shrink the large cable end cap into place - Fig 5 | 21
14. Allow the completed stop end to cool before applying any mechanical strain | --
ST: CAØN/2 PROCEDURES FOR MAKING SERVICE CABLE STOP ENDS

JOINTING PROCEDURE 7.302

PVC SPLIT CONCENTRIC SERVICE CABLE STOP END - SINGLE PHASE

This procedure is to be read in conjunction with the appropriate General Requirements ST: CAØC Section 6 of the LV Service Cable Jointing Manual

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JOINTING PROCEDURE 7.302

MATERIALS LIST

CABLE SIZES - 16/25mm2 Cu Plain Conc

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
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</thead>
<tbody>
<tr>
<td>Stop End Kit SMOE 81613</td>
<td>1</td>
</tr>
</tbody>
</table>

ADDITIONAL ITEMS FOR EACH JOINT

PVC tape
Emery cloth
De-solvit 1000FD
Workhorse dry wipes
Cable solvent wipes

Note: - Individual material item numbers (SHOPS) are to be found in Section 4 of the LV Service Cable Jointing Manual.
# JOINTING PROCEDURE 7.302

<table>
<thead>
<tr>
<th>Actions</th>
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<tbody>
<tr>
<td>Refer to Drawing <strong>SVJ 7.302.1, 7.302.2</strong> whilst undertaking this Jointing Procedure</td>
<td></td>
</tr>
<tr>
<td>1. Set up and mark cable</td>
<td>4</td>
</tr>
<tr>
<td>2. Open and cut cable in accordance with General Requirement - Fig 1</td>
<td>13</td>
</tr>
<tr>
<td>3. Prepare neutral and earth wires for jointing - Fig 2</td>
<td>7</td>
</tr>
<tr>
<td>4. Apply temporary shrouding</td>
<td>17</td>
</tr>
<tr>
<td>5. Cut phase conductor to length - Fig 2</td>
<td>--</td>
</tr>
<tr>
<td>6. Thoroughly degrease the phase conductor insulation</td>
<td>29</td>
</tr>
<tr>
<td>7. Fit and shrink the small phase conductor cap into place - Fig 3</td>
<td>21</td>
</tr>
<tr>
<td><strong>Allow to cool</strong></td>
<td></td>
</tr>
<tr>
<td>8. Remove temporary shrouding applied in 4</td>
<td>--</td>
</tr>
<tr>
<td>9. Lay the earth wires over the conductor phase cap and cut level with the cap end - Fig 4</td>
<td>--</td>
</tr>
<tr>
<td>10. Ensure the wires are evenly spaced, and cover with three layers of PVC tape - Fig 5.</td>
<td>--</td>
</tr>
<tr>
<td>11. Lay the neutral wires over the conductor phase cap and turn back to the oversheath termination - Fig 6.</td>
<td>--</td>
</tr>
</tbody>
</table>

**NOTE:** The neutral and earth wires must be spaced to form an earth screen over the phase conductor and cap

| 12. Ensure the neutral wires are evenly spaced, trim off a the oversheath termination position, and secure with PVC tape - Fig 6 | -- |
| 13. Abrade the oversheath - Fig 6 | 26 |
| 14. Thoroughly degrease the complete termination | 29 |
15. Fit and shrink the large cable end cap into place - Fig 7

16. Allow the completed stop end to cool before applying any mechanical strain
Fig 5
PVC Tape Over
Earth Wires And
Cap

Fig 6
Abraded Area
Neutral And Earth Wires
Taken Over Phase Cap
And Turned Back Towards The
PVC Oversheath And Covered
With PVC Tape

Fig 7
Outer Heatshrink
Cap Overall
ST: CAØN/2 PROCEDURES FOR MAKING SERVICE CABLE STOP ENDS

JOINTING PROCEDURE 7.303

PILC SERVICE CABLE STOP END
- SINGLE PHASE

This procedure is to be read in conjunction with the appropriate General Requirements ST: CAØC Section 6 of the LV Service Cable Jointing Manual

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JOINTING PROCEDURE 7.303

MATERIALS LIST

CABLE SIZES - Up to 35mm² PILC

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
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</thead>
<tbody>
<tr>
<td>Shell 1046</td>
<td>1</td>
</tr>
<tr>
<td>Resin</td>
<td>3.2 lts</td>
</tr>
<tr>
<td>Armour bond LVSB 18</td>
<td>1</td>
</tr>
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</table>

ADDITIONAL ITEMS FOR EACH JOINT

Insulation patch
Black cotton tape
Sealing putty
Cable ties
Shell support
Whipping thread
PVC tape
De-solvit 1000FD
De-solvit 1000
Workhorse dry wipes
Cable solvent wipes

Note: - Individual material item numbers (SHOPS) are to be found in Section 4 of the LV Service Cable Jointing Manual.
**JOINTING PROCEDURE 7.303**

<table>
<thead>
<tr>
<th>Actions</th>
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<tr>
<td>Refer to Drawing <strong>SVJ 7.303.1, 7.303.2</strong> whilst undertaking this</td>
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<td>12</td>
</tr>
<tr>
<td>3. Apply armour bond</td>
<td>18</td>
</tr>
<tr>
<td>4. Carefully apply cable ties around the core insulation shrouds</td>
<td>--</td>
</tr>
<tr>
<td>5. Build up oversheath</td>
<td>--</td>
</tr>
<tr>
<td>6. Thoroughly degrease the joint</td>
<td>29</td>
</tr>
<tr>
<td>7. Apply mastic water block to lead sheath</td>
<td>27</td>
</tr>
<tr>
<td>8. Prepare and fit shell, ensuring 15mm clearance</td>
<td>30</td>
</tr>
<tr>
<td>9. Mix and pour resin</td>
<td>31</td>
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</tbody>
</table>
ST: CAØN/2 PROCEDURES FOR MAKING SERVICE CABLE
STOP ENDS

JOINTING PROCEDURE 7.304

PVC PLAIN CONCENTRIC SERVICE CABLE
STOP END - THREE PHASE

This procedure is to be read in conjunction with the appropriate
General Requirements ST: CAØC Section 6
of the LV Service Cable Jointing Manual

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JOINTING PROCEDURE 7.304

MATERIALS LIST

CABLE SIZES - 25/35mm² Hybrid or 16/25mm² Cu Plain Conc

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
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</thead>
<tbody>
<tr>
<td>Stop End Kit SMOE 81614</td>
<td>1</td>
</tr>
</tbody>
</table>

ADDITIONAL ITEMS FOR EACH JOINT

- PVC tape
- Emery cloth
- De-solvit 1000FD
- Workhorse dry wipes
- Cable solvent wipes

Note: Individual material item numbers (SHOPS) are to be found in Section 4 of the LV Service Cable Jointing Manual.
# JOINTING PROCEDURE 7.304

<table>
<thead>
<tr>
<th>Actions</th>
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<tbody>
<tr>
<td>Refer to Drawing SVJ 7.304.1 whilst undertaking this Jointing Procedure</td>
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</tr>
<tr>
<td>1. Set up and mark cable</td>
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<tr>
<td>2. Open and cut cable in accordance with General Requirement - Fig 1</td>
<td>13</td>
</tr>
<tr>
<td>3. Prepare the neutral/earth wires for jointing - Fig 2</td>
<td>7</td>
</tr>
<tr>
<td>4. Apply temporary shrouding</td>
<td>17</td>
</tr>
<tr>
<td>5. Cut the first phase conductor to length - Fig 2</td>
<td>--</td>
</tr>
<tr>
<td>6. Thoroughly degrease the phase conductor insulation</td>
<td>--</td>
</tr>
<tr>
<td>7. Fit and shrink the small phase conductor cap into place - Fig 3. <strong>Allow to cool</strong></td>
<td>21</td>
</tr>
<tr>
<td>8. Repeat actions 5 to 7 for remaining phase conductors in turn. <strong>Allow to cool</strong></td>
<td>--</td>
</tr>
<tr>
<td>9. Remove temporary shrouding applied in 4</td>
<td>--</td>
</tr>
<tr>
<td>10. Bind the three cores together with three layers of PVC tape - Fig 3</td>
<td>--</td>
</tr>
<tr>
<td>11. Lay the neutral/earth wires over the conductor phase caps and turn back to the oversheath termination - Fig 4</td>
<td>--</td>
</tr>
</tbody>
</table>

**NOTE:** The neutral/earth wires must be spaced to form a earth screen over the phase conductors and caps

<table>
<thead>
<tr>
<th>Actions</th>
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<tbody>
<tr>
<td>12. Ensure neutral/earth wires are evenly spaced, trim off at the oversheath termination position and secure with PVC tape - Fig 4</td>
<td>--</td>
</tr>
<tr>
<td>13. Abrade the oversheath - Fig 4</td>
<td>26</td>
</tr>
<tr>
<td>14. Thoroughly degrease the complete termination</td>
<td>29</td>
</tr>
<tr>
<td>15. Fit and shrink the large cable end cap into place - Fig 5</td>
<td>21</td>
</tr>
<tr>
<td>16. Allow the completed stop end to cool before applying mechanical strain</td>
<td></td>
</tr>
</tbody>
</table>
Fig 1

PVC Oversheath Term

All dimensions in mm

Neutral / Earth Wire Term

200

Fig 2

Belt Tape Term

Neutral / Earth Wires

10

Phase Core Term

70

Fig 3

Insulating Heatshrink Caps On Phase Cores

PVC Tape Binder Overall

Fig 4

Abridged Area

Neutral / Earth Wires

Taken Over PVC Tape Binder And Turned Back Towards The PVC Oversheath And Covered With PVC Tape

75

Fig 5

Outer Heatshrink Cap Overall
ST: CAØN/2 PROCEDURES FOR MAKING SERVICE CABLE
STOP ENDS

JOINTING PROCEDURE 7.305

PVC SPLIT CONCENTRIC SERVICE CABLE
STOP END - THREE PHASE

This procedure is to be read in conjunction with the appropriate
General Requirements ST: CAØC Section 6
of the LV Service Cable Jointing Manual
JOINTING PROCEDURE 7.305

MATERIALS LIST

CABLE SIZES - 25/35mm² Hybrid or 16/25mm² Cu Split Conc

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
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<tr>
<td>Stop End Kit SMOE 81614 Raychem</td>
<td>1</td>
</tr>
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</table>

ADDITIONAL ITEMS FOR EACH JOINT

- PVC tape
- Emery cloth
- De-solvit 1000FD
- Workhorse dry wipes
- Cable solvent wipes

Note: - Individual material item numbers (SHOPS) are to be found in Section 4 of the LV Service Cable Jointing Manual.
## JOINTING PROCEDURE 7.305

### Actions

Refer to Drawing SVJ 7.305.1, 7.305.2 whilst undertaking this Jointing Procedure

1. Set up and mark cable 4
2. Open and cut cable in accordance with General Requirement - Fig 1 13
3. Prepare neutral and earth wires for jointing - Fig 2 7
4. Apply temporary shrouding 17
5. Cut the first phase conductor to length - Fig 2 --
6. Thoroughly degrease the phase conductor insulation 29
7. Fit and shrink the small phase conductor cap into place - Fig 3 Allow to cool 21
8. Repeat actions 5 to 7 for remaining phase conductors in turn. Allow to cool --
9. Remove temporary shrouding applied in 4 --
10. Bind the three cores together with three layers of PVC tape - Fig 3 --
11. Lay the earth wires over the conductor phase caps and cut level with the cap end - Fig 4 --
12. Ensure the earth wires are evenly spaced and cover with three layers of PVC tape - Fig 5 --
13. Lay the neutral wires over the conductor phase cap and turn back to the oversheath termination - Fig 6 --

**NOTE:** The neutral and earth wires must be spaced to form an earth screen over the phase conductor and cap

14. Ensure the neutral wires are evenly spaced, trim off at the oversheath termination position and secure with PVC tape - Fig 6 --
15. Abrade the oversheath - Fig 6 26
16. Thoroughly degrease the complete termination

17. Fit and shrink the large cable and cap into places - Fig 7

18. Allow the completed stop end to cool before applying mechanical strain
All dimensions in mm

Fig 1
PVC Oversheath Term
Neutral And Earth Wire Term

200

Fig 2
Neutral
Belt Tape Term
Earth Wires
Phase Core Term
10
70

Fig 3
Insulating Heatshrink Caps On Phase Cores
PVC Tape Binder Overall

Fig 4
Earth Wires (Uninsulated)
Laid Along Phase Core
And Cut To Length
All dimensions in mm

Fig 5

PVC Tape Binder Over Earth Wires And Caps

Fig 6

Abraded Area

Neutral Wires Taken Over PVC Tape Binder And Turned Back Towards The PVC Oversheath And Covered With PVC Tape

Fig 7

Outer Heatshrink Cap Overall
ST: CAØN/2 PROCEDURES FOR MAKING SERVICE CABLE STOP ENDS

JOINTING PROCEDURE 7.306

PILC SERVICE CABLE STOP END
- THREE PHASE

This procedure is to be read in conjunction with the appropriate General Requirements ST: CAØC Section 6 of the LV Service Cable Jointing Manual

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JOINTING PROCEDURE 7.306

MATERIALS LIST

CABLE SIZES - Up to 35mm² PILC

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shell 1046</td>
<td>1</td>
</tr>
<tr>
<td>Resin</td>
<td>3.2 litres</td>
</tr>
<tr>
<td>Armour bond LVSB 18</td>
<td>1</td>
</tr>
</tbody>
</table>

ADDITIONAL ITEMS FOR EACH JOINT

- Insulation patch
- Black cotton tape
- Sealing putty
- Cable ties
- Shell support
- Whipping thread
- PVC tape
- De-solvit 1000FD
- De-solvit 1000
- Workhorse dry wipes
- Cable solvent wipes

Note: - Individual material item numbers (SHOPS) are to be found in Section 4 of the LV Service Cable Jointing Manual.
## JOINTING PROCEDURE 7.306

<table>
<thead>
<tr>
<th>Actions</th>
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<tbody>
<tr>
<td>Refer to Drawing <strong>SVJ 7.306.1, 7.306.2</strong>, whilst undertaking this</td>
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<tr>
<td>1. Set up and mark cable</td>
<td>4</td>
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<tr>
<td>2. Open and cut cable in accordance with General Requirement</td>
<td>12</td>
</tr>
<tr>
<td>3. Apply armour bond</td>
<td>18</td>
</tr>
<tr>
<td>4. Carefully apply cable ties around the core insulation shrouds</td>
<td>--</td>
</tr>
<tr>
<td>5. Build up oversheath</td>
<td>--</td>
</tr>
<tr>
<td>6. Thoroughly degrease the joint</td>
<td>29</td>
</tr>
<tr>
<td>7. Apply mastic water block to lead sheath</td>
<td>27</td>
</tr>
<tr>
<td>8. Prepare and fit shell, ensuring 15mm clearance</td>
<td>30</td>
</tr>
<tr>
<td>9. Mix and pour resin</td>
<td>31</td>
</tr>
</tbody>
</table>
ST: CAØN/2 PROCEDURES FOR MAKING SERVICE CABLE STOP ENDS

JOINTING PROCEDURE 7.307

35mm² CNE WAVECON SERVICE CABLE STOP END - THREE PHASE

This procedure is to be read in conjunction with the appropriate General Requirements ST: CAØC Section 6 of the LV Service Cable Jointing Manual

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JOINTING PROCEDURE 7.307

MATERIALS LIST

CABLE SIZES – 35mm² Wavecon

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Stop End Kit SMOE 81614</td>
<td>1</td>
</tr>
</tbody>
</table>

ADDITIONAL ITEMS FOR EACH JOINT

- PVC tape
- Emery cloth
- De-solvit 1000FD
- Workhorse dry wipes
- Cable solvent wipes

Note: - Individual material item numbers (SHOPS) are to be found in Section 4 of the LV Service Cable Jointing Manual.
## JOINTING PROCEDURE 7.307

<table>
<thead>
<tr>
<th>Actions</th>
<th>General Requirements</th>
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</thead>
<tbody>
<tr>
<td>1. Set up and mark cable</td>
<td>4</td>
</tr>
<tr>
<td>2. Open and cut cable in accordance with General Requirement - Fig 1</td>
<td>13</td>
</tr>
<tr>
<td>3. Prepare the neutral/earth wires for jointing - Fig 2</td>
<td>7</td>
</tr>
<tr>
<td>4. Apply temporary shrouding</td>
<td>17</td>
</tr>
<tr>
<td>5. Cut the first phase conductor to length - Fig 2</td>
<td>--</td>
</tr>
<tr>
<td>6. Thoroughly degrease the phase conductor insulation</td>
<td>--</td>
</tr>
<tr>
<td>7. Fit and shrink the small phase conductor cap into place - Fig 3. <strong>Allow to cool</strong></td>
<td>21</td>
</tr>
<tr>
<td>8. Repeat actions 5 to 7 for remaining phase conductors in turn. <strong>Allow to cool</strong></td>
<td>--</td>
</tr>
<tr>
<td>9. Remove temporary shrouding applied in 4</td>
<td>--</td>
</tr>
<tr>
<td>10. Bind the three cores together with three layers of PVC tape - Fig 3</td>
<td>--</td>
</tr>
<tr>
<td>11. Lay the neutral/earth wires over the conductor phase caps, turn back to the oversheath termination - Fig 4</td>
<td>--</td>
</tr>
</tbody>
</table>

**Note:** The neutral/earth wires must be spaced to form a earth screen over the phase conductors and caps

| 12. Ensure neutral/earth wires are evenly spaced, trim off at the oversheath termination position and secure with PVC tape - Fig 4 | -- |
| 13. Abrade the oversheath - Fig 4 | 26 |

Refer to Drawing **SVJ 7.307.1** whilst undertaking this Jointing Procedure.
JOINTING PROCEDURE 7.307 - Continued

14. Thoroughly degrease the complete termination 29
15. Fit and shrink the large cable end cap into place - Fig 5 21
16. Allow the completed stop end to cool before applying mechanical strain --
APPENDIX A

SUPERSEDED DOCUMENTATION

This Standard Technique supersedes ST:CAØN/1 dated May 2012 which should now be withdrawn.

APPENDIX B

ASSOCIATED DOCUMENTATION


APPENDIX C

IMPACT ON COMPANY POLICY

None, as this document has just been updated to incorporate all the latest SHOPS numbers and other subtle minor changes.

APPENDIX D

IMPLEMENTATION OF POLICY

This Standard Technique shall be communicated to all relevant WPD engineers and site staff at the next Team Briefing by the Team Manager.

APPENDIX E

KEY WORDS

Stop Ends, Service Cable Stop Ends.