

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

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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

Document Revision & Review Table		
Date	Comments	Author
July 2014	<ul style="list-style-type: none"> • Correction of General Requirement Numbers. • SVJ 7.301.1 measurements amended • SVJ 7.302.1 measurements amended • Inclusion of cable solvent wipes 	Richard Summers

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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**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**

JOINTING PROCEDURE 7.301

MATERIALS LIST

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

Item	Quantity
Stop End Kit SMOE 81613	1

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 (ST: CAØC)
Refer to Drawing SVJ 7.301.1 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/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	--

All dimensions in mm

Fig 1

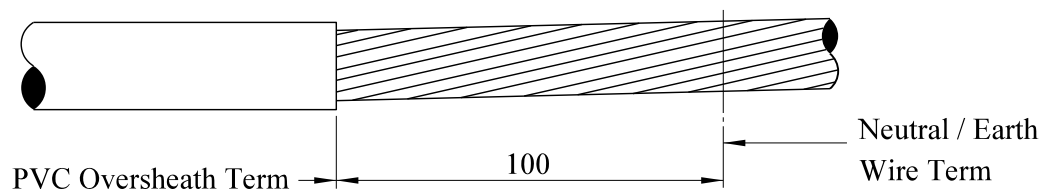


Fig 2

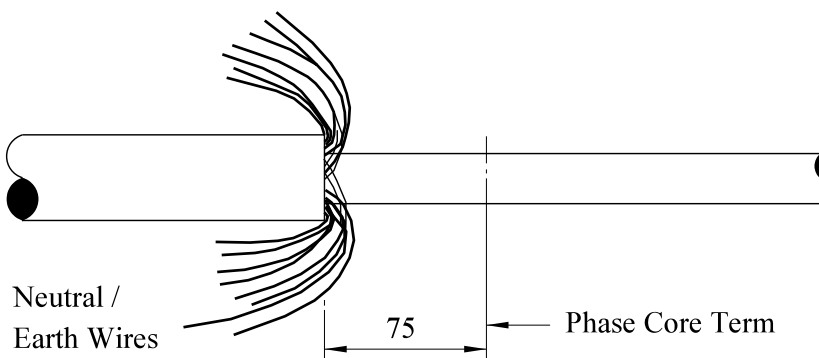


Fig 3

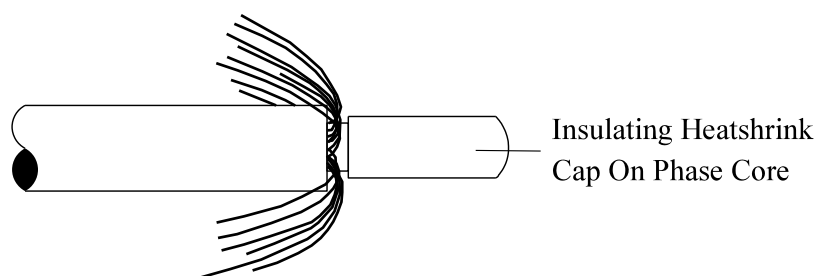


Fig 4

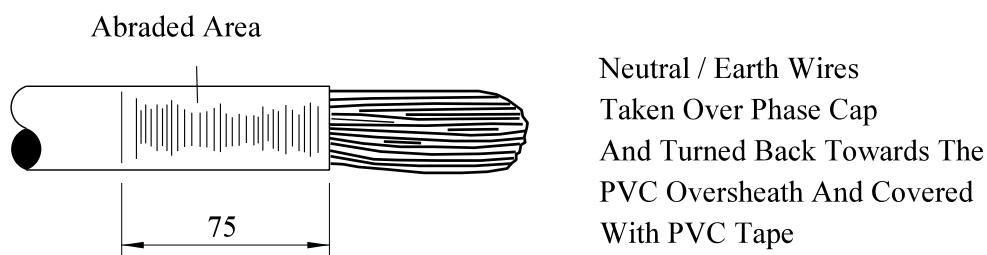



Fig 5



1	RJB			06/14	PHASE CORE TRIM LENGTH ALTERED			
Rev No	Drawn	Chk'd	App'd	Date	Revision			
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Drawn	RJB	04/12						
Checked								
Approved								
SCALE		N.T.S.		Title		PVC PLAIN CONC	Drg. No.	Rev No
				STOP END - SINGLE PHASE		STRIPPING DIMENSIONS / GENERAL LAYOUT	SVJ 7.301.1	1

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**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**

JOINTING PROCEDURE 7.302

MATERIALS LIST

CABLE SIZES - 16/25mm² Cu Plain Conc

Item	Quantity
Stop End Kit SMOE 81613	1

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

Actions	General Requirements (ST: CAØC)
Refer to Drawing SVJ 7.302.1, 7.302.2 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 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 earth wires over the conductor phase cap and cut level with the cap end - Fig 4	--
10. Ensure the wires are evenly spaced, and cover with three layers of PVC tape - Fig 5.	--
11. 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	
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

JOINTING PROCEDURE 7.302 - Continued

- | | | |
|-----|--|----|
| 15. | Fit and shrink the large cable end cap into place - Fig 7 | 21 |
| 16. | Allow the completed stop end to cool before applying any mechanical strain | -- |

All dimensions in mm

Fig 1

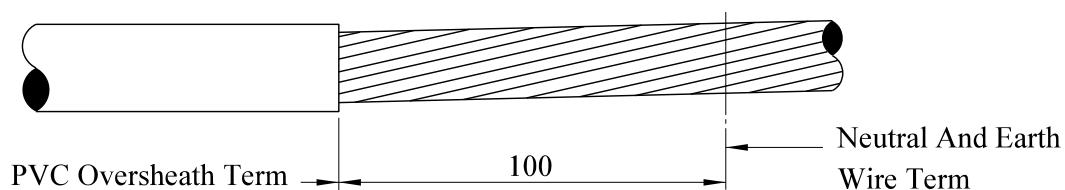


Fig 2

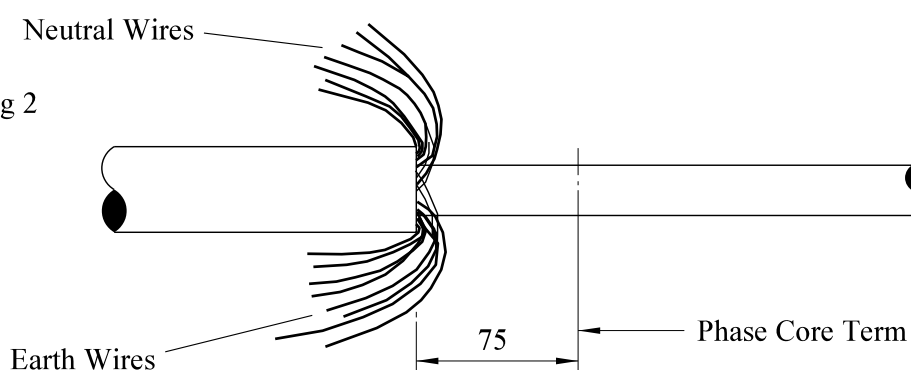


Fig 3

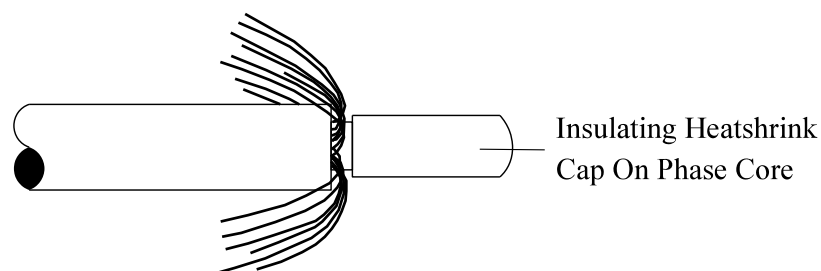
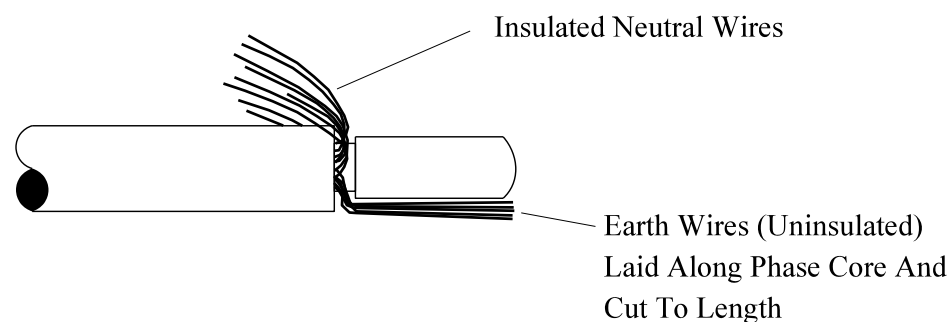



Fig 4



1	RJB			06/14	PHASE CORE TRIM LENGTH ALTERED	
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Drawn	RJB	04/12				
Checked						
Approved				Title		
SCALE		N.T.S.		PVC SPLIT CONC		
				STOP END - SINGLE PHASE		
				STRIPPING DIMENSIONS / GENERAL LAYOUT		
				Drg. No.		
				SVJ 7.302.1		
				Rev No		
				1		

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All dimensions in mm

Fig 5

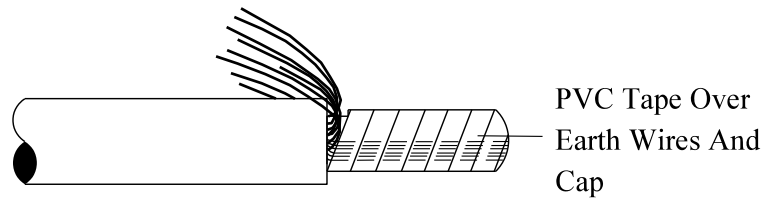


Fig 6

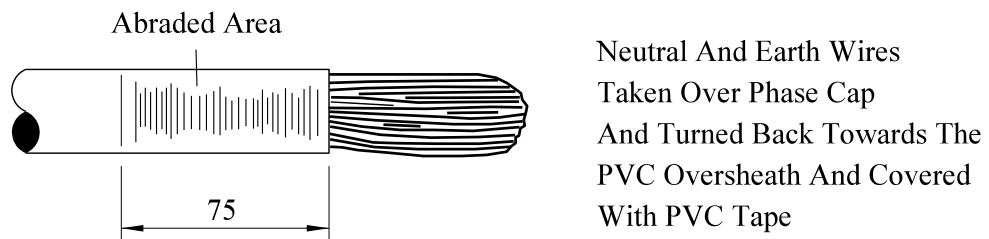
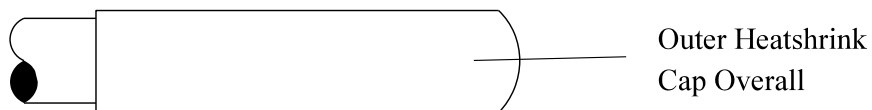



Fig 7



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Drawn	RJB	04/12				
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Approved						
SCALE	N.T.S.		Title PVC SPLIT CONC STOP END - SINGLE PHASE STRIPPING DIMENSIONS / GENERAL LAYOUT			Drg. No. SVJ 7.302.2
						Rev No

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**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**

JOINTING PROCEDURE 7.303

MATERIALS LIST

CABLE SIZES - Up to 35mm² PILC

Item	Quantity
Shell 1046	1
Resin	3.2 lts
Armour bond LVSB 18	1

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

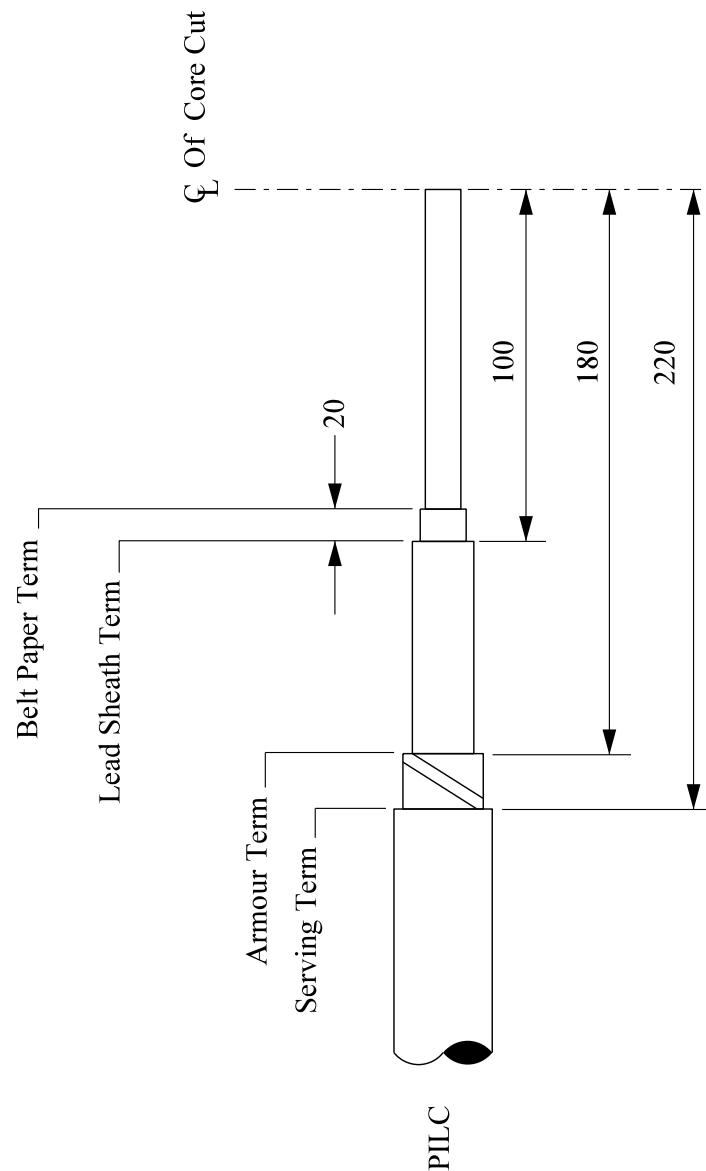
Actions


General Requirements (ST: CAØC)

Refer to Drawing **SVJ 7.303.1, 7.303.2** whilst undertaking this Jointing Procedure

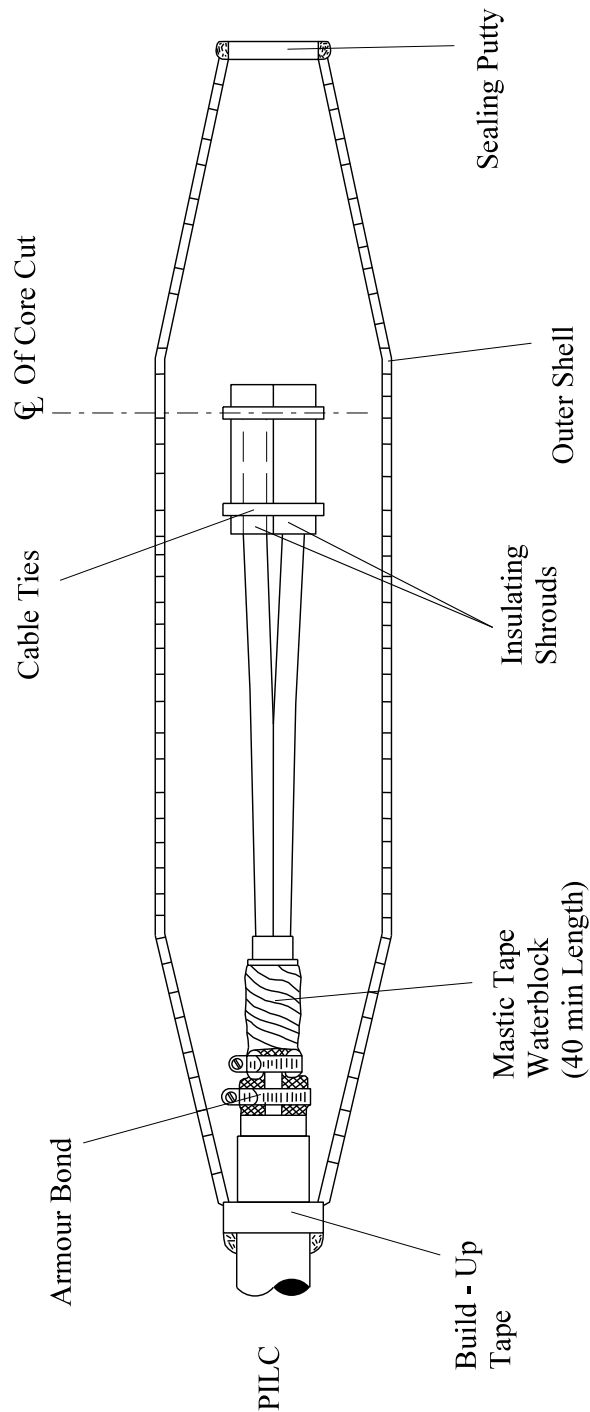
1.	Set up and mark cable	4
2.	Open and cut cable in accordance with General Requirement	12
3.	Apply armour bond	18
4.	Carefully apply cable ties around the core insulation shrouds	--
5.	Build up oversheath	--
6.	Thoroughly degrease the joint	29
7.	Apply mastic water block to lead sheath	27
8.	Prepare and fit shell, ensuring 15mm clearance	30
9.	Mix and pour resin	31

All dimensions in mm




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Drawn	RJB	04/12					
Checked				Title PILC STOP END - SINGLE PHASE STRIPPING DIMENSIONS		Drg. No. SVJ 7.303.1	Rev No
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SCALE		N.T.S.					

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PLAN VIEW

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Drawn	RJB	04/12			
Checked				Title <div>PILC STOP END - SINGLE PHASE GENERAL LAYOUT</div> <div>Drg. No. SVJ 7.303.2</div> <div>Rev No</div>	
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**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**

JOINTING PROCEDURE 7.304

MATERIALS LIST

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

Item	Quantity
Stop End Kit SMOE 81614	1

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

Actions	General Requirements (ST: CAØC)
Refer to Drawing SVJ 7.304.1 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 the neutral/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	--
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 neutral/earth wires over the conductor phase caps and turn back to the oversheath termination - Fig 4	--
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
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	

Fig 1

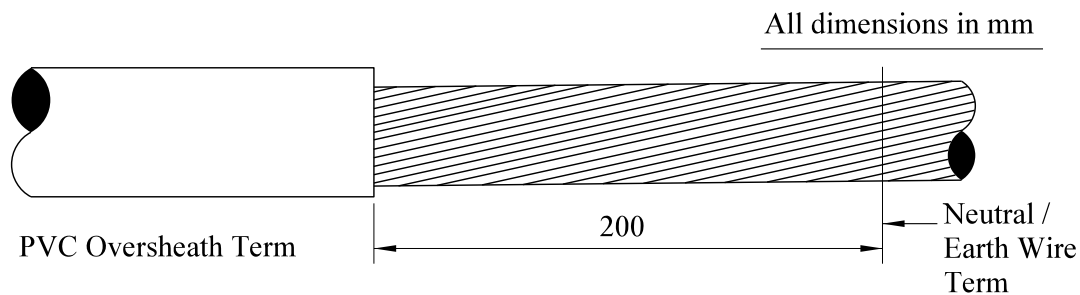


Fig 2

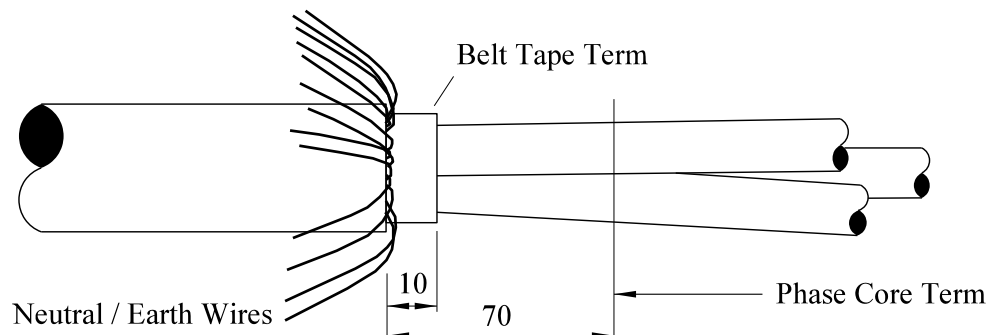


Fig 3

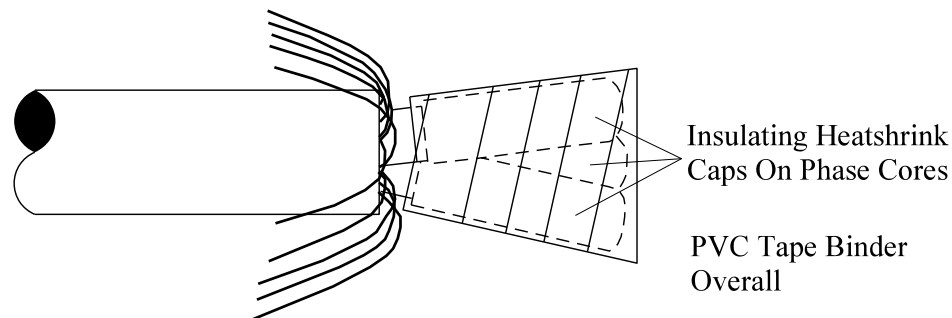


Fig 4

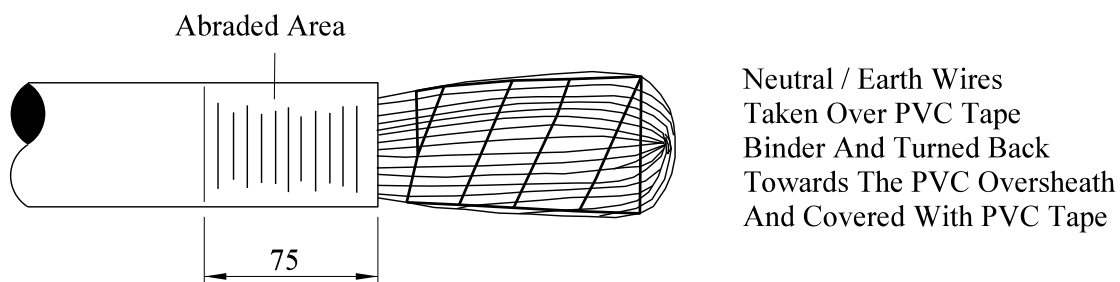


Fig 5



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Drawn	RJB	04/12		Title PVC PLAIN CONC STOP END - THREE PHASE STRIPPING DIMENSIONS / GENERAL ARRANGEMENT	
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**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

Item	Quantity
-------------	-----------------

Stop End Kit SMOE 81614 Raychem	1
---------------------------------	---

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	General Requirements (ST: CAØC)
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

JOINTING PROCEDURE 7.305 - Continued

- | | | |
|-----|--|----|
| 16. | Thoroughly degrease the complete termination | 29 |
| 17. | Fit and shrink the large cable and cap into places - Fig 7 | 21 |
| 18. | Allow the completed stop end to cool before applying mechanical strain | -- |

All dimensions in mm

Fig 1

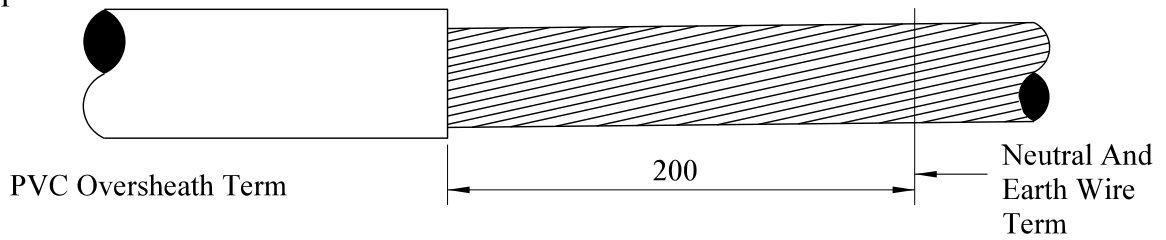


Fig 2

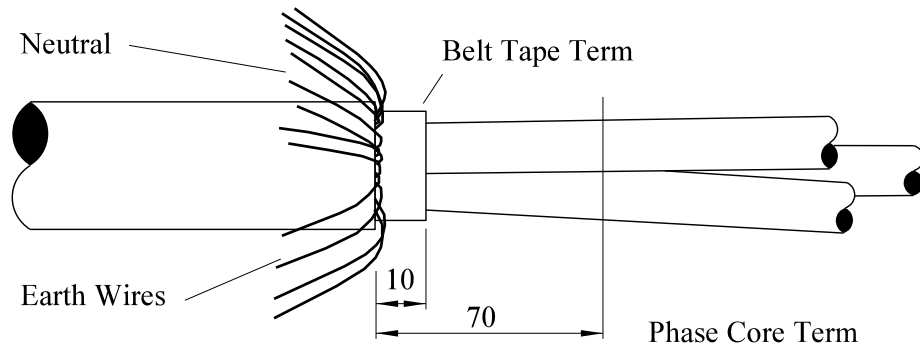


Fig 3

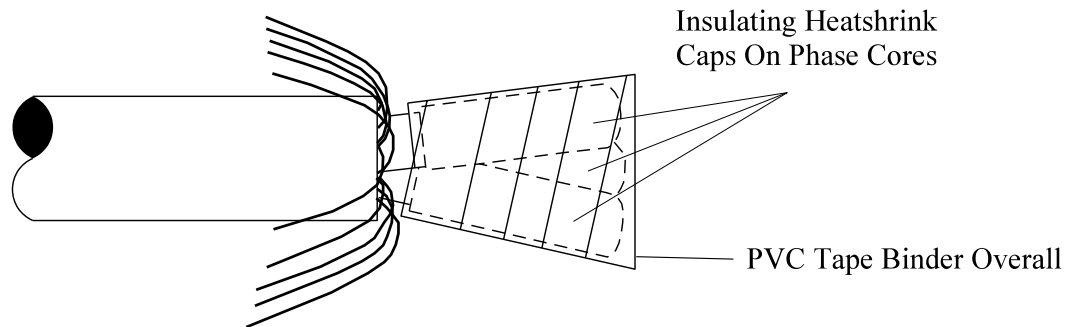
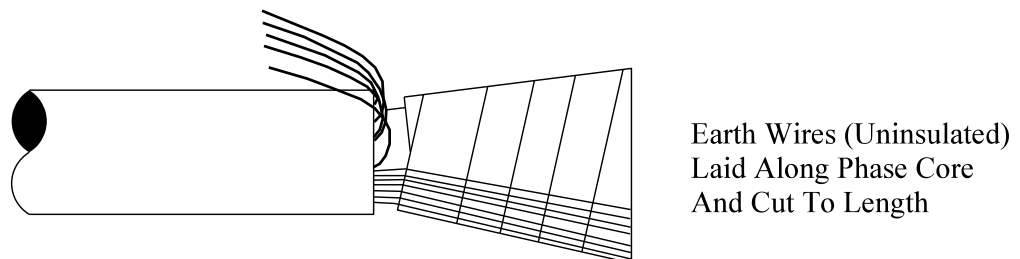



Fig 4



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Drawn	RJB	04/12					
Checked							
Approved							
SCALE		N.T.S.		Title		Drg. No.	Rev No
				PVC SPLIT CONC STOP END - THREE PHASE STRIPPING DIMENSIONS / GENERAL LAYOUT		SVJ 7.305.1	

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All dimensions in mm

Fig 5

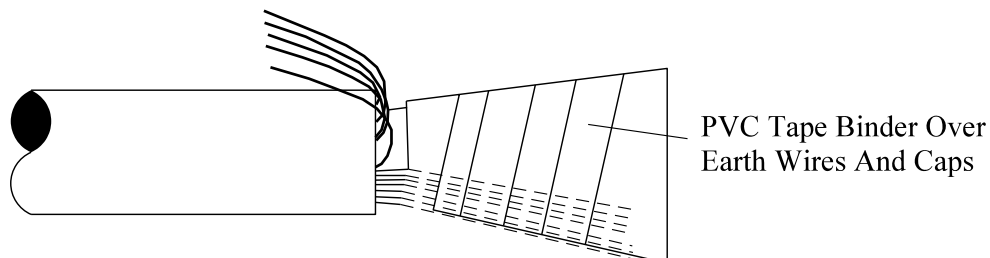


Fig 6

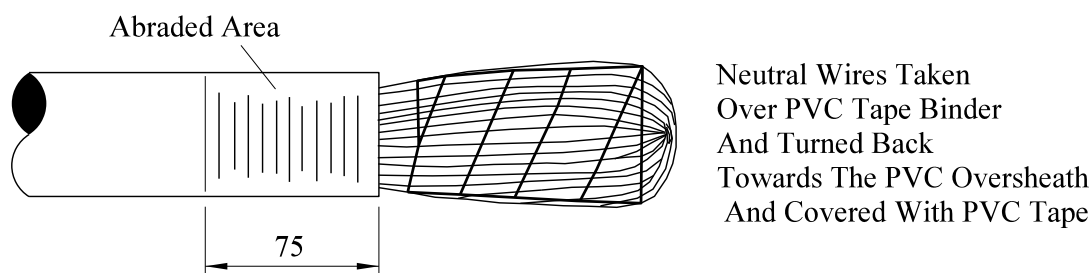



Fig 7



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Drawn	RJB	04/12			
Checked					
Approved				Title	
SCALE		N.T.S.		PVC SPLIT CONC	
				STOP END - THREE PHASE STRIPPING	
				DIMENSIONS / GENERAL LAYOUT	
				Drg. No.	
				SVJ 7.305.2	
				Rev No	

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**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**

JOINTING PROCEDURE 7.306

MATERIALS LIST

CABLE SIZES - Up to 35mm² PILC

Item	Quantity
Shell 1046	1
Resin	3.2 litres
Armour bond LVSB 18	1

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

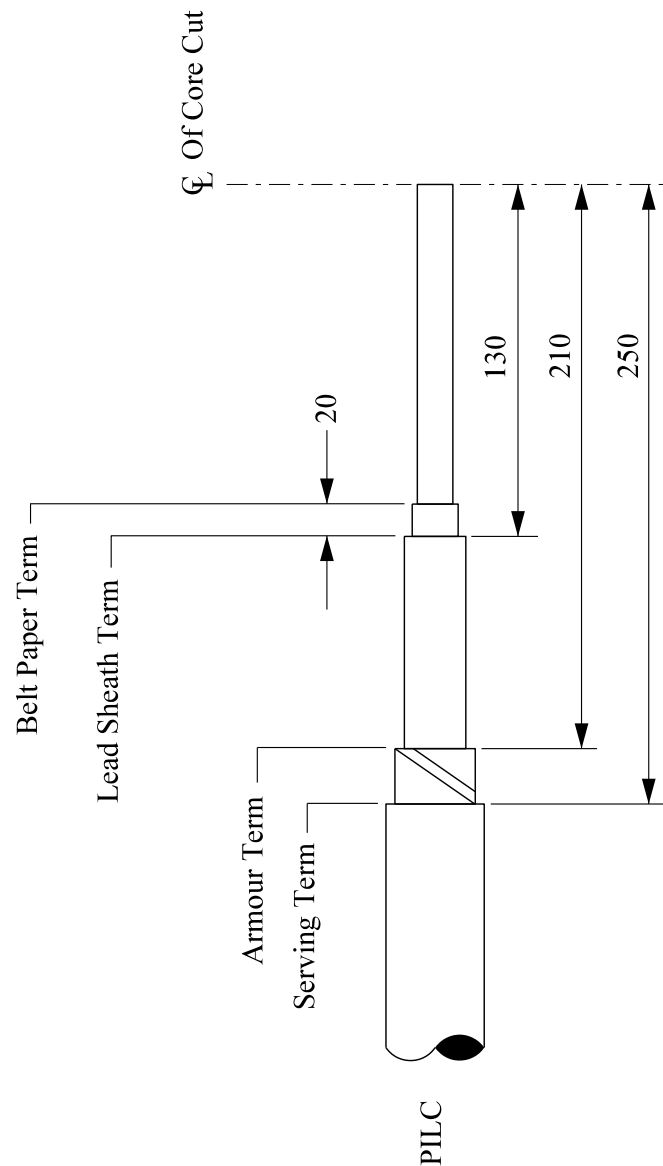
Actions


General Requirements (ST: CAØC)

Refer to Drawing **SVJ 7.306.1, 7.306.2**, whilst undertaking this Jointing Procedure

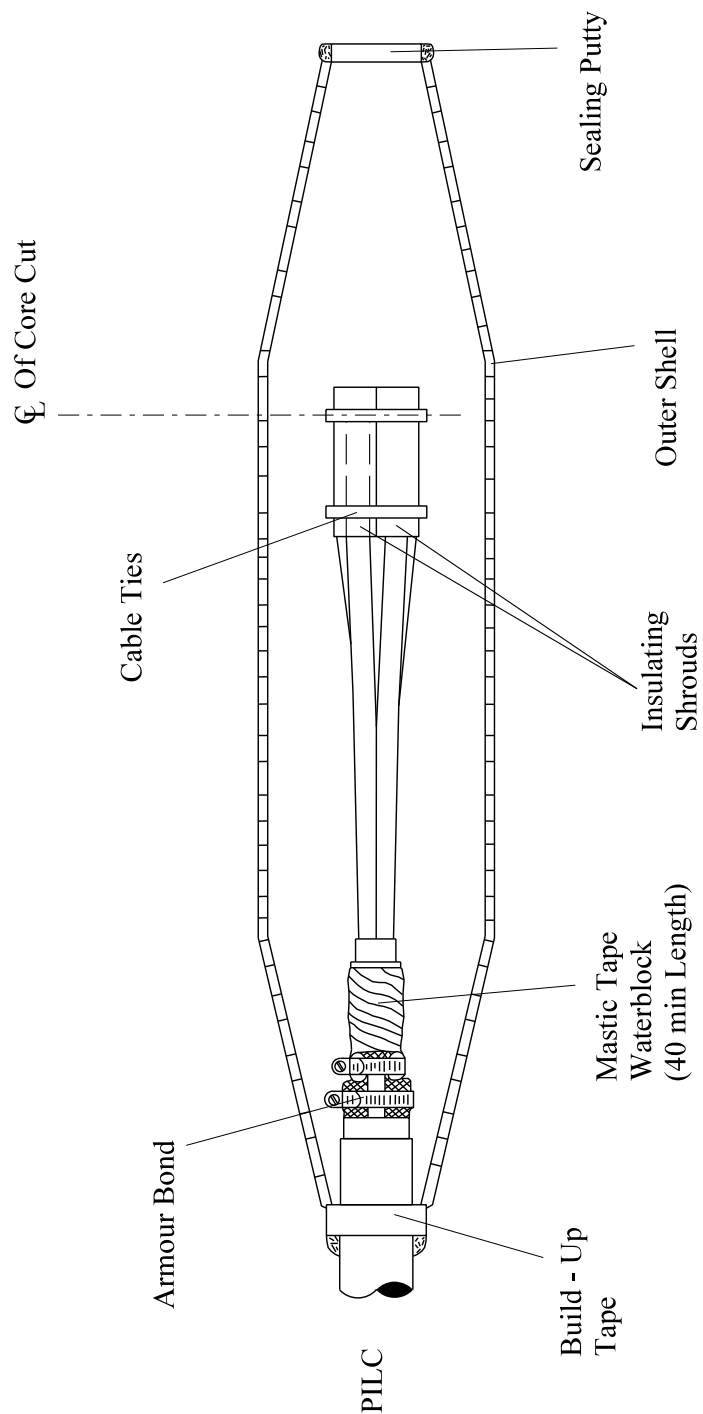
1.	Set up and mark cable	4
2.	Open and cut cable in accordance with General Requirement	12
3.	Apply armour bond	18
4.	Carefully apply cable ties around the core insulation shrouds	--
5.	Build up oversheath	--
6.	Thoroughly degrease the joint	29
7.	Apply mastic water block to lead sheath	27
8.	Prepare and fit shell, ensuring 15mm clearance	30
9.	Mix and pour resin	31

All dimensions in mm



Rev No	Drawn	Chk'd	App'd	Date	Revision
ORIGINAL ISSUE		DATE		<div>WESTERN POWER DISTRIBUTION Design Department. Avonbank,Feeder Road,Bristol BS2 0TB Tel: 0117 933 2000 Fax: 0117 933 2001.</div> <div>WESTERN POWER DISTRIBUTION</div>	
Drawn	RJB	04/12			
Checked					
Approved					
SCALE		N.T.S.			
Title				PILC STOP END - THREE PHASE STRIPPING DIMENSIONS	
				Drg. No. SVJ 7.306.1	
				Rev No	

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PLAN VIEW

Rev No	Drawn	Chk'd	App'd	Date	Revision	
ORIGINAL ISSUE					WESTERN POWER DISTRIBUTION Design Department. Avonbank, Feeder Road, Bristol BS2 0TB Tel: 0117 933 2000 Fax: 0117 933 2001.	
Drawn	RJB	04/12				
Checked					Title PILC STOP END - THREE PHASE GENERAL LAYOUT	WESTERN POWER DISTRIBUTION Drg. No. SVJ 7.306.2
Approved						
SCALE	N.T.S.					Rev No

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**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**

JOINTING PROCEDURE 7.307

MATERIALS LIST

CABLE SIZES – 35mm² Wavecon

Item	Quantity
Stop End Kit SMOE 81614	1

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

Actions

General Requirements (ST: CAØC)

Refer to Drawing **SVJ 7.307.1** 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 the neutral/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	--
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 neutral/earth wires over the conductor phase caps, turn back to the oversheath termination - Fig 4	--
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

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 | -- |

Fig 1

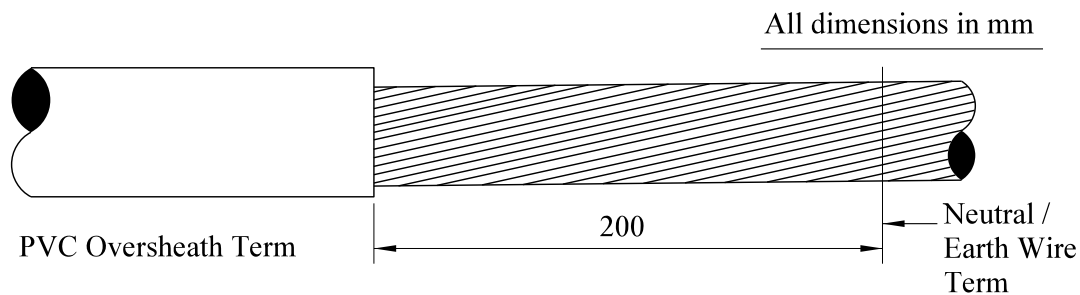


Fig 2

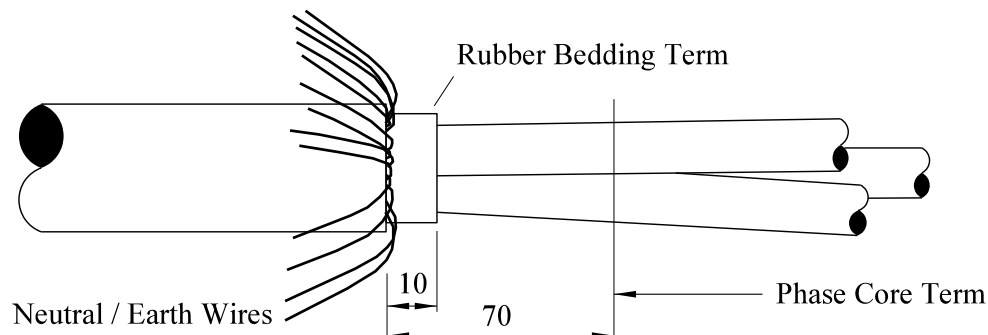


Fig 3

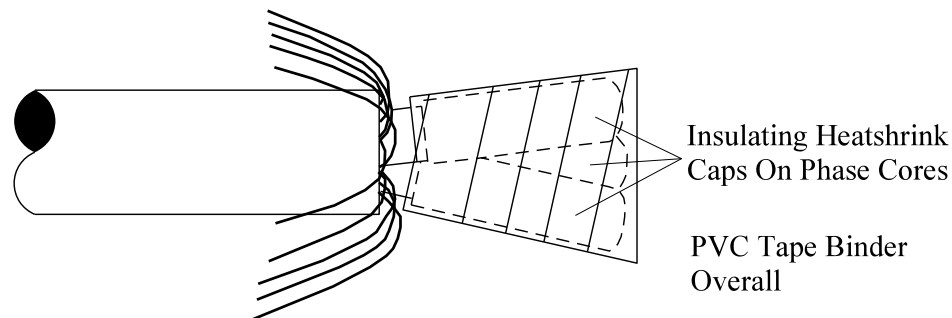


Fig 4

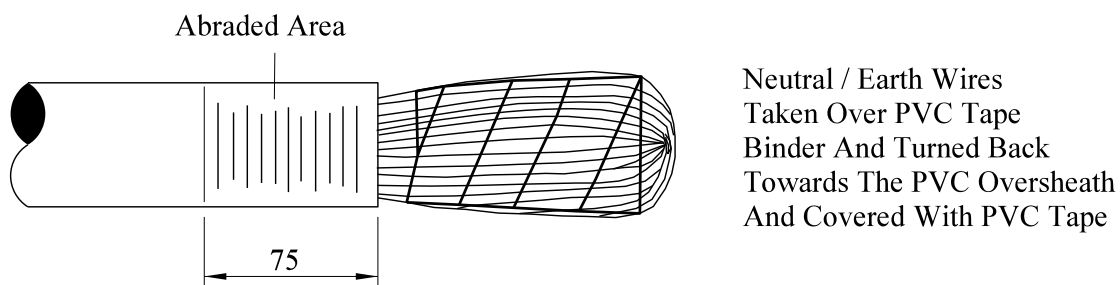


Fig 5



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Drawn	RJB	04/12	Title 35mm ² CNE WAVECON STOP END - THREE PHASE STRIPPING DIMENSIONS / GENERAL ARRANGEMENT		
Checked					
Approved			Title 35mm ² CNE WAVECON STOP END - THREE PHASE STRIPPING DIMENSIONS / GENERAL ARRANGEMENT		
SCALE	N.T.S.		<div style="display: flex; justify-content: space-between;"> Drng. No. SVJ 7.307.1 Rev No </div>		

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APPENDIX A

SUPERSEDED DOCUMENTATION

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

APPENDIX B

ASSOCIATED DOCUMENTATION

ST:CAØA, ST:CAØB, ST:CAØC, ST:CAØM, ST:CAØS, ST:CAØT, ST:CAØU, ST:CAØV, ST:CAØW, ST:CAØZ.

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.