
	Specification for OSP Material Splice Closure OQMS SGD 034	Issue No. : 05
		Date of Issue : 19-May-2014
		Revision No. : 01
		Date of Revision : 30-Aug-2014
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1 General

This specification covers the splice closure which is an enclosure or a device covering the spliced conductors in a cable joint and restore the integrity of the cable sheaths at the cable joint.

With the closure, outer surface of the ends of the cable sheath which are to be joined are covered.

The splice closure shall be suitable for closing polyethylene sheathed underground or aerial cables with straight or branch joints.

There are two types of splice closures:

- 1.1.1 heat-shrinkable type
- 1.1.2 re-enterable mechanical type

1.2 Heat-shrinkable Closure

The heat-shrinkable closure is a sheet made of special polymer which shrinks when wrapped around the cable splice and applied heat. It forms a water tight permanent closure not re-openable.


1.3 Mechanical Closure

The mechanical closures are re-openable for modifications or maintenance purposes. Normally they are in split sleeves. Nuts and Bolts or clips are employed as fasteners. Gaskets are used in case of water tight closures. Also free breathin type closures available which allows ventilation to a certain degree inside the splice closure to prevent water condensation. Mainly these are two types of installation methods.

- 1.3.1 In-line
- 1.3.2 Dome type (Sleeve 31 BPO standard) Dome type is mountable on poles, walls or inside manholes. Suitable for capacity cables.

2 Material

- 2.1 Material used for the closure shall be of polymer specially formulated to resist ultra – violet radiation and adverse effects of surrounding environment

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- 2.2 The material of the closure shall be compatible with the material of the cable sheath and the other material used in outside plant in order to prevent corrosion or other electro/chemical reactions,
- 2.3 All metal parts used shall be of high quality and rust proof.
- 2.4 Any adhesive used for the closure shall possess long lasting qualities without deterioration under extreme humid and temperature conditions, shall be impervious to moisture and resistant to mould growth throughout its life time. The peel strength of the adhesive shall be indicated. The adhesive shall ensure a water tight seal.
- 2.5 The splice closure system shall be able to withstand stresses imposed into the joint.
- 2.6 It shall also provide electrical continuity of the shield across the joint and shall have a current carrying capacity of a 4mm diameter (6 AWG) copper conductor.
- 2.7 The material for the shield connector for the shield continuity shall be preferably made of Tin-plated Brass. The connector shall be capable of carrying 1200 amperes for 10 seconds or 1000 amperes for 20 seconds.

The heat shrinkable joint closure kit shall contain the following basic components.


- 2.7.1 A wrap around heat shrinkable closure.
- 2.7.2 A flexible stainless steel closure channel with under clip.
- 2.7.3 Non corrosive metallic support canister.
- 2.7.4 Branch- off- kits.
- 2.7.5 Cable shield continuity hardware.
- 2.7.6 PVC tapes, cleaning materials, etc
- 2.7.7 Any other components relevant for the joint

The mechanical joint closure kit shall contain the following basic components

- 2.7.8 End caps for single entry /multiple entry for cables.
- 2.7.9 Split sleeve closure body with stainless steel clips, nuts and bolts etc.
- 2.7.10 PVC tapes, cleaning material etc.
- 2.7.11 Cable shield continuity hardware.
- 2.7.12 Sealing gaskets or any other required material for the same.
- 2.7.13 Installation instructions in English Language.
- 2.7.14 Any other components relevant for the joint.

3 Branch – off –Kits included:

Basically it is identified that the Branch – Off- Kit supplied with the closures need the following items to be included.

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a) Tightness Test

Immerse in water at 23°C for 15 minutes at 40 Kpa test pressure. There should be no sign of air leakage from the complete closure joint.

b) Impact Test

A steel ball of 1Kg shall drop from a 2m height at 45°C for a direct impact on the surface of the closure.

Shall pass the tightness test as per 1.1.4.a) above

c) Static Load

Apply a load of 200N/cm² perpendicular to the closure surface at 45°C. Repeat the same at the diagonally opposite surface.

Shall pass the tightness test as per 1.1.4.a) above

d) Axial Tension

Tensile load at 50% of the yield strength of the cable for 15minutes at 45°C.

Shall pass the tightness test as per 1.1.4.a) above

e) Bending

Clamping distance 10x cable diameter from closure edge (min:250mm) for 500N max force, for 45 degree bend or 300 mm displacement for two complete flexure cycles at 45°C per cable.

Shall pass the tightness test as 1.1.4.a) above


f) Torsion

Clamping distance 10x cable diameter from closure edge for 50 Nm torsion or 90 degree max rotation for 2 complete torsion cycles per cable at 45°C.

g) Vibration

10 Hz sinusoidal vibration with 6mm amplitude (Peak to Peak) at a clamping 10 x cable diameter (min 250mm) from closure edge for 240 hours at 45°C

h) Temperature Cycling

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Temperature cycles from –40oC to 60oC with 8 hours duration for 10 cycles.

i) Heat resistance for jointers torch

Apply the tip of yellow flame of the jointer,s torch on the same spot of the sleeve for 10 seconds.

Shall pass the tightness test as per 1.1.4.a) above

j) Split propagation

Sleeve installed on substrate of maximum application diameter with perpendicular edge cut of 5mm length,the cut shall not propagate the split with the application of heat.


Compound filled complete mechanical closure joint shall comply with the following test series.

- Water soaked for 3 days at room temperature.
- Temperature cycling from –40°C to 60° C with 8 hourly cycle for 10 cycles.
- Re-enter the closure,remove all compound and re-encapsulate the closure with new compound.
- Temperature cycles from –40°C to 60°C with 8 hourly cycles for 10 cycles.
- Water soaked for 6 hours at 60°C.
- Apply tensile force at 50% of the yield strength of the cable for 15 minutes at 45°C.
- Water soaked for 3 days at ambient temperature, after being subjected to above series of tests the closure shall not show any deterioration. The insulation resistance of the connectors in the closure shall be more than 5000M Ω @ 500V DC.

3.2 Chemical reaction

The complete closure both mechanical /heat shrinkable shall be soaked in the following chemical for 24 hours.

a) 0.1N Sulphuric acid.

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- b) **0.1N Sodiumhydroxide.**
- c) **5% Sodium chloride,95% water by weight.**
- d) **0.1N Sodium carbonate.**
- e) **Commercial fuel oil.**

After each of the 24 –hour chemical soak, the closure shall not show any sign of damage or decay and the insulation resistance of the connections in the closure shall stay above 5,000 MΩ@ 500V DC.

4 Requirement

The closure carton shall be durable and properly labelled.

5 Marking

5.1 On the closure carton:


- 5.1.1 the manufacturer's name,
- 5.1.2 the Month and Year of manufacture,
- 5.1.3 expiry date,
- 5.1.4 splice closure designation, and
- 5.1.5 the cable pair sizes for which the kit to be used.

5.2 On the outer surface of the sleeve following shall be printed /engraved /embossed clearly and firmly to remain visible after installation(after heating the closure in the case of heat shrinkable closures).

- 5.2.1 SLT Logo. – The valid current logo shall be collected from the SLT Procurement Division by the Supplier in case of material supply.
- 5.2.2 Manufacturer's Name,
- 5.2.3 Month and year of Manufacture
- 5.2.4 Expiry Date

6 Packing

- a) **The splice closure shall be supplied in cartons in kit form containing all the requisite accessories,together with the installation instruction in simple and clear English.**
- b) **A list of contents in the kit shall be included in every unit.**

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7 Categorization of the Aerial Closures

The following table shows the Minimum and the Maximum sizes for each category.

Pairs \ Dia.	0.4 mm		0.5 mm		0.6 mm		0.9 mm	
	Min	Max	Min	Max	Min	Max	Min	Max
20	90	225	90	250	150	250	150	275
30	90	225	90	250	180	250	180	275
50	200	300	200	300	200	300	200	350
80	200	300	200	300	200	325	200	300
100	275	450	275	450	300	480	400	480
150	300	480	300	480	400	480	400	500
200	400	580	400	580	500	600	500	600

	Category 1	:	=	20 – 50 pairs	:	0.4 – 0.6mm
1	Category 2	:	=	80 – 100 pairs	:	0.4 – 0.6mm
2	Category 3	:	=	150 – 200 pairs	:	0.4 – 0.6mm
3	Category 4	:	=	20 – 50 pairs	:	0.9mm
4	Category 5	:	=	80 – 200 pairs	:	0.9mm

8 Compliance Sheet:


See Next Page.

9 Compliance Sheet for Heat Shrinkable Closures – 4 Pages

10 Compliance Sheet for Mechanical Closures – 3 Pages

11 Field Test Report for Heat Shrinkable Closures – 2 Pages

12 Filed Test Report for Mechanical Closures – 2 Pages

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Field Test Report For Heat Shrinkable Closures


(In this format item no. 1 shall be filled after 6 months (for samples) / when you cut or open the closure)

Sample Description:		Manhole/ Hand Hole No	
Area Installed			
Sample No		Date Installed	

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
1.	Closure	1.1 Material	Fibre Reinforced laminated Material	
			Compatible with cable sheath	
		1.2 Adhesive	Long lasting under extreme humid & Temperature conditions	
			Moisture Resistant	
			Resistant to moss growth	
		1.3 Seal	Water Tight Seal	
		1.4 Continuity across the joint	Yes	
2.	Closure Kit shall contain	2.1 A wrap around heat shrinkable closure	Yes	
		2.2 A flexible stainless steel closure channel with under clip	Yes	
		2.3 Non corrosive metallic support canister	Yes	
		2.4 Branching clips	Yes	
		2.5 Cable shield continuity hardware (Earth Wire Accessory)	Yes	
		2.6 Adhesive PVC Tapes	Yes	
		2.7 Cleaning Tissues	Yes	
		2.8 Cellophane Tape roll	Yes	
		2.9 Silica Gel Desiccant	Yes	
		2.10 Adhesive Aluminium Foil	Yes	
		2.11 Adhesive Aluminium Tape	Yes	
	Continued to next page...			

Test Done By:.....
(Signature & Date)

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Field Test Report For Heat Shrinkable Closures

(In this format item no. 1 shall be filled after 6 months (for samples) / when you cut or open the closure)

Sample Description:		Manhole/ Hand Hole No	
Area Installed			
Sample No		Date Installed	

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
	Closure Kit shall contain Continued ...	2.12 Americ strip	Yes	
		2.13 Tie Wrap	Yes	
		2.14 Installation details in English	Yes	
		2.15 Any other components relevant for the joint (mention)	Yes	
3	Other Requirements	Closure Carton	Durable	
			Labeled with	
			1. Manufacturer's Name	
			2. Month & Year of Manufacture	
			3. Splice closure Designation	
4	Marking (This needs to be visible after heating)	On the Outer surface of the sleeve shall be printed/ engraved/ embossed	4. Expiry date	
			1. SLT Logo	
			2. Month & Year of Manufacture	
			3. Expiry Date	
			4. Name of Manufacturer	

Overall Comments (Write)

Recommended/ Not


Signature of Officer Tested

Date

Employee No

Test Done By:.....
(Signature & Date)

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Compliance Sheet For Heat Shrinkable Closures

Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
5.	Other Requirements	Closure Carton	Durable	
		Labeled with		
		1. Manufacturer's Name		
		2. Year of Manufacture		
6.	Marking	On the Outer surface of the sleeve shall be printed/ engraved/	3. Splice closure Designation	
			4. Cable pair sizes for which kit to be used	
7.	Packaging	Shall be supplied in cartons in kit form containing all the accessories together with installation instructions in simple and clear instructions	1. SLT Logo	
			2. Year of Manufacture	
			3. Manufacturer's name	
7.	Packaging	Shall be supplied in cartons in kit form containing all the accessories together with installation instructions in simple and clear instructions	Yes	

Note 1: Tests

1.1. Tightness Test

Immerse in water at 23°C for 15 minutes at 40 Kpa test pressure. There should be no sign of air leakage from the complete closure joint.

1.2. Impact Test

A steel ball of 1Kg shall drop from a 2m height at 45°C for a direct impact on the surface of the closure. Shall pass the tightness test as per 1.1


1.3. Static Load

Apply a load of 200N/cm² perpendicular to the closure surface at 45°C. Repeat the same at the diagonally opposite surface.

Shall pass the tightness test as per 1.1

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Compliance Sheet For Heat Shrinkable Closures

Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
1.4.	Axial Tension			
	Tensile load at 50% of the yield strength of the cable for 15minutes at 45°C			
	Shall pass the tightness test as per 1.1			
1.5.	Bending			
	Clamping distance 10x cable diameter from closure edge (min:250mm) for 500N max force, for 45 degree bend or 300 mm displacement for two complete flexure cycles at 45°C per cable.			
	Shall pass the tightness test as per 1.1			
1.6.	Torsion			
	Clamping distance 10x cable diameter from closure edge for 50 Nm torsion or 90 degree max rotation for 2 complete torsion cycles per cable at 45°C.			
1.7.	Vibration			
	10 Hz sinusoidal vibration with 6mm amplitude (Peak to Peak) at a clamping 10 x cable diameter (min 250mm) from closure edge for 240 hours at 45°C			
1.8.	Temperature Cycling			
	Temperature cycles from -40°C to 60°C with 8 hours duration for 10 cycles.			
1.9.	Heat resistance for jointers torch			
	Apply the tip of yellow flame of the jointer,s torch on the same spot of the sleeve for 10 seconds.			
	Shall pass the tightness test as per 1.1			
1.10.	Split propagation			
	Sleeve installed on substrate of maximum application diameter with perpendicular edge cut of 5mm length,the cut shall not propagate the split with the application of heat.			

Note 2: Chemical Reaction

The complete heat shrinkable closure shall be soaked in the following chemical for 24 hours.

- 0.1N Sulphuric acid.
- 0.1N Sodiumhydroxide.
- 5% Sodium chloride ,95% water by weight.
- 0.1N Sodium carbonate.
- Commercial fuel oil.

Overall Comments (Write)


Recommended/ Not

Signature of Officer Tested/ Suppler

Date

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Compliance Sheet For Mechanical Closures


Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
1	Closure	1.1 Material	Fibre Reinforced laminated Material	
			Compatible with cable sheath	
		1.2 Connector	Capable of carrying 1200A for 10 seconds or 1000A for 20 seconds	
		1.3 Adhesive	Long lasting under extreme humid & Temperature conditions	
			Moisture Resistant	
			Resistant to moss growth	
		1.4 Seal	Water Tight Seal	
2	Closure Kit shall contain	1.5 Continuity across the joint	Yes	
		2.1 End caps for single entry/ Multiple entry for cables	Yes	
		2.2 Split sleeve with stainless steel clips, stainless steel bolts, nuts etc	Yes	
		2.3 Filling compound	Yes	
		2.4 Sealing gaskets or any other required for the same	Yes	
		2.5 Cable shield continuity hardware	Yes	
		2.6 PVC Tapes, Cleaning Materials, etc	Yes	
		2.7 Installation details in English Language	Yes	
		2.8 Any other components relevant for the joint (mention)	Yes	

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Compliance Sheet For Mechanical Closures


Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
3.	Tests	Water soaked for 3 days at room temperature		
		Temperature cycling from -40°C to 60°C with 8 hourly cycle for 10 cycles	a. Closure shall not show any deterioration.	
		Re-enter the closure, remove all compound and re-encapsulate the closure with new compound		
		Temperature cycling from -40°C to 60°C with 8 hourly cycle for 10 cycles		
		Water soaked for 6 hrs at 60°C	b. Insulation resistance of the connectors in the closure shall be >5000MΩ	
		Apply tensile force at 50% of the yield strength of the cable for 15 minutes at 45°C		
4.	Chemical Reaction (See note 1)	After 24hr chemical soak	No sign of damage - Supportive certificates shall be supplied by the supplier	
			Insulation resistance of the connections shall be >5000MΩ	

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Compliance Sheet For Mechanical Closures

Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
5.	Other Requirements	Closure Carton	Durable	
		Labeled with		
		1. Manufacturer's Name		
		2. Year of Manufacture		
6.	Marking	On the Outer surface of the sleeve shall be printed/ engraved/	3. Splice closure Designation	
			4. Cable pair sizes for which kit to be used	
7.	Packaging	Shall be supplied in cartons in kit form containing all the accessories together with installation instructions in simple and clear instructions	1. SLT Logo	
			2. Year of Manufacture	
			3. Manufacturer's name	
			Yes	

Note 1: Chemical Reaction

The complete heat shrinkable closure shall be soaked in the following chemical for 24 hours.

- 0.1N Sulphuric acid.
- 0.1N Sodiumhydroxide.
- 5% Sodium chloride ,95% water by weight.
- 0.1N Sodium carbonate.
- Commercial fuel oil.


Overall Comments (Write)

Recommended/ Not

Signature of Officer Tested/ Supplier

Date

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Field Test Report For Heat Shrinkable Closures


Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
1	Closure	1.1 Material	Fibre Reinforced laminated Material	
			Compatible with cable sheath	
		1.2 Adhesive	Long lasting under extreme humid & Temperature conditions	
			Moisture Resistant	
			Resistant to moss growth	
		1.3 Seal	Water Tight Seal	
		1.4 Continuity across the joint	Yes	
2	Closure Kit shall contain	2.1 A wrap around heat shrinkable closure	Yes	
		2.2 A flexible stainless steel closure channel with under clip	Yes	
		2.3 Non corrosive metallic support canister	Yes	
		2.4 Branch off clips	Yes	
		2.5 Cable shield continuity hardware	Yes	
		2.6 PVC Tapes, Cleaning Materials, etc	Yes	
		2.7 Installation details in English Language	Yes	
		2.8 Any other components relevant for the joint (mention)	Yes	

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Field Test Report For Heat Shrinkable Closures

Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
3	Other Requirements	Closure Carton	Durable	
			Labeled with	
			1. Manufacturer's Name	
			2. Year of Manufacture	
			3. Splice closure Designation	
4	Marking	On the Outer surface of the sleeve shall be printed/ engraved/ embossed	4. Cable pair sizes for which kit to be used	
			1. SLT Logo	
			2. Year of Manufacture	
			3. Manufacturer's name	
7.	Packaging	Shall be supplied in cartons in kit form containing all the accessories together with installation instructions in simple and clear instructions	Yes	

Overall Comments (Write)


Recommended/ Not

Signature of Officer Tested/ Supplier

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Field Test Report For Mechanical Closures


Sample Description:

Sample No Date

No	Test Parameter	SLT Specification	Complied/ Not	Remarks
1	Closure	1.1 Material	Fibre Reinforced laminated Material	
			Compatible with cable sheath	
		1.2 Adhesive	Long lasting under extreme humid & Temperature conditions	
			Moisture Resistant	
			Resistant to moss growth	
2	Closure Kit shall contain	1.3 Seal	Water Tight Seal	
		1.4 Continuity across the joint	Yes	
		2.1 End caps for single entry/ Multiple entry for cables	Yes	
		2.2 Split sleeve with stainless steel clips, stainless steel bolts, nuts etc	Yes	
		2.3 Filling compound	Yes	
		2.4 Sealing gaskets or any other required for the same	Yes	
		2.5 Cable shield continuity hardware	Yes	
		2.6 PVC Tapes, Cleaning Materials, etc	Yes	
		2.7 Installation details in English Language	Yes	
		2.8 Any other components relevant for the joint (mention)	Yes	

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Sample Description:

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No	Test Parameter		SLT Specification	Complied/ Not	Remarks
3.	Other Requirements	Closure Carton	Durable		
			Labeled with		
			1. Manufacturer's Name		
			2. Year of Manufacture		
4.	Marking	On the Outer surface of the sleeve shall be printed/ engraved/	3. Splice closure Designation		
			4. Cable pair sizes for which kit to be used		
			1. SLT Logo		
5.	Packaging	Shall be supplied in cartons in kit form containing all the accessories together with installation instructions in simple and clear instructions	2. Year of Manufacture		
			3. Manufacturer's name		
			Yes		

Overall Comments (Write)

Recommended/ Not

Signature of Officer Tested/ Supplier

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