

# Installation Procedure Sheet for Heat Shrink End Caps

## Cable Preparation

- Place the heat shrinkable end cap onto the cable end and mark the bonding area
- Position the cable vertically, pointing up as far as possible.
- Use a hammer to give round shape to the sharp, pointing profiles on the cable end.
- Clean the bonding area of the cable end with a clean, dry cloth, If the surface is greasy, Degrease it using a suitable solvent.
- Abrade the bonding area using an abrading cloth strip.
- Flame-brush the bonding area.
- Place the end cap over the cable end.



## Shrinking the End cap with a Gas torch

- Regulate the flame to a length of approximately one foot (30 cms) with the yellow tip of about four inches long (10 cms.)
- Start shrinking from the top of the end cap and move the flame around the circumference. Keep moving the yellow tip in brush like strokes.
- When the top of the end cap is shrunk, pull the end cap manually over the cable end if required. Let the end cap top cool to grip the cable end firmly
- Continue shrinking the end cap circumferentially gradually towards the open end. Make sure that the end cap shrinks uniformly without any wrinkles or creases.
- Continue heating the end cap more till the hot melt adhesive comes out of the open end of end cap. This is an indication that the bonding temperature of the hot melt adhesive is attained and the installation is complete
- Let the end cap cool down to the room temperature. Do not apply gas pressure or mechanical force in any form, before the end cap cools down.
- **If the end cap is fitted with the valve, tighten the nut of the valve if required**

## Important Notes

- **DO NOT USE GAS FLAME WITH A BLUE TIP TO HEAT THE END CAP. THE HIGH TEMPERATURE OF BLUE TIP CAN DAMAGE THE END CAP MATERIAL.**
- **DO NOT OVERHEAT AT A SPOT, KEEP MOVING THE GAS TORCH FLAME ALL THE TIME.**