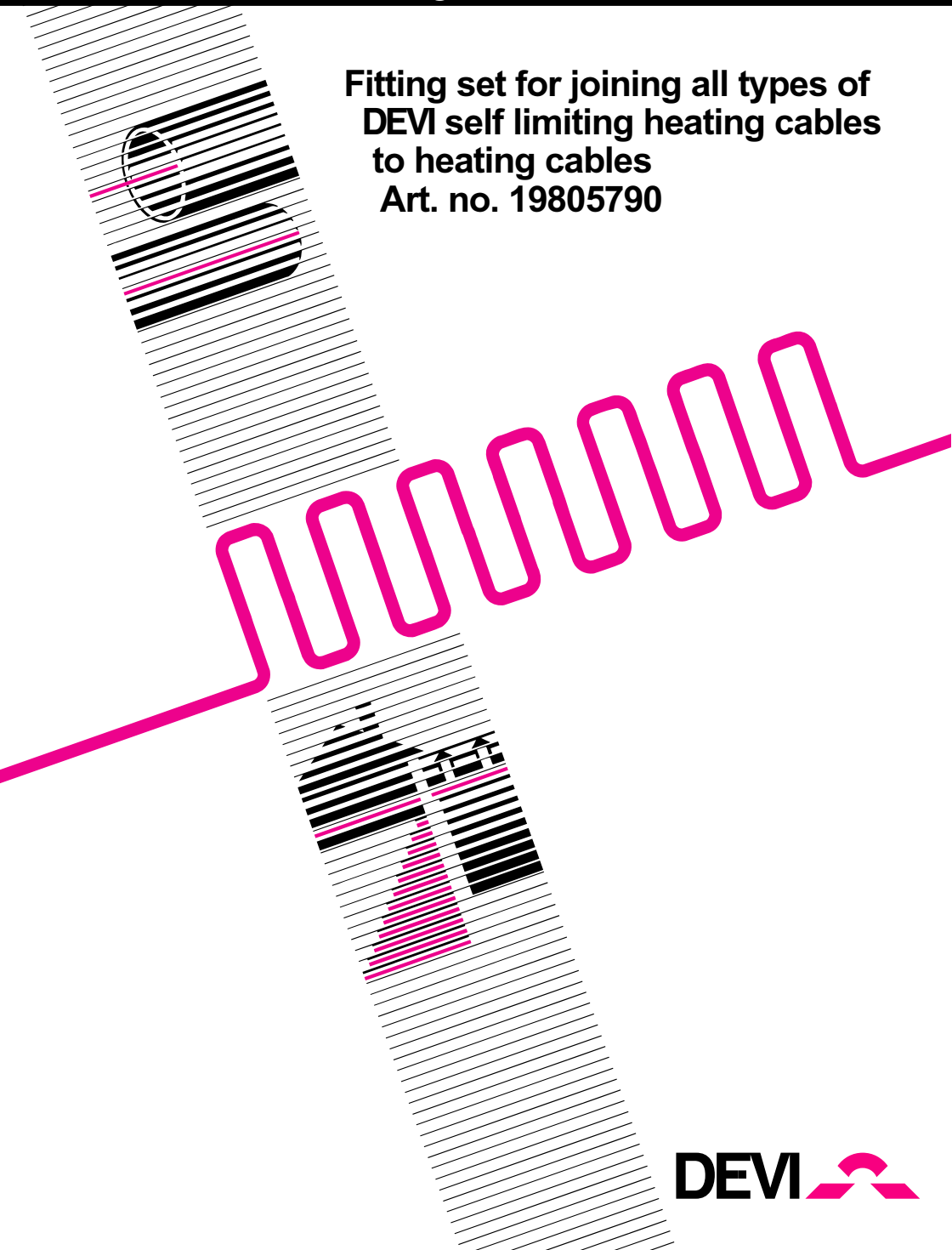


Fitting instructions

**Fitting set for joining all types of
DEVI self limiting heating cables
to heating cables
Art. no. 19805790**



Fitting set: 19805790

Connection box kit:

4 x crimp tube,
type 3/1, L = 15 mm
2 x squeeze connection tube,
fitcrimp 1
2 x crimp tube,
type 12/3, L=20 mm
1 x crimp tube,
type 12/3, L = 80 mm

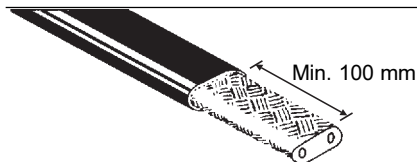
1 soldering tube
1 TESA insulation tape,
L = 60 mm
1 adhesive tape,
L = 100 mm
1 crimp tube,type KYNAR 3/4,
L =10 mm

Practical fitting instructions:

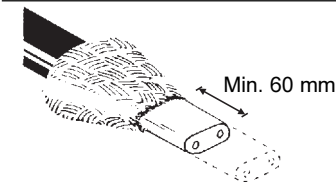
A temperature of $150^{\circ}\text{C} \pm 30^{\circ}\text{C}$ is necessary to crimp the tubes. A hot air gun with a temperature control is the most effective tool. However, a blow torch with a moderate flame can also be used or a gas lighter if nothing else is available.

If you have any questions concerning the installation instructions, please contact **DEVI** for further information.

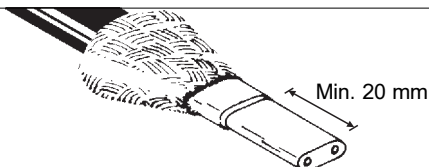
Preparation of the heating cable



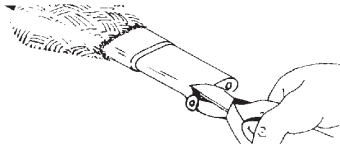
1. Remove the outer sheath from the cable with a wire stripper.



2. Pull the screen back over the cable. Cut away 60 mm.



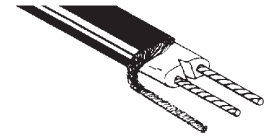
3. Cut away the conductor insulation with a knife.



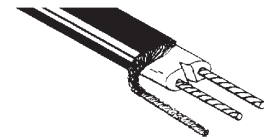
- Using side-cutting pliers, carefully cut away the inner layer of the material from between the two conductors without damaging them in the process.



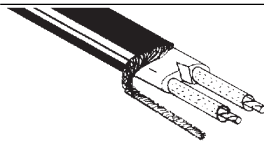
- Pull the conductors to the side and cut the inner layer away so that it flushes with the first layer of insulation.



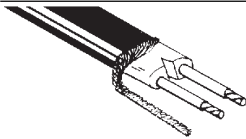
- The remaining material is loosened by twisting the conductors. Make sure that none of the earth wires are in contact with the conductors.



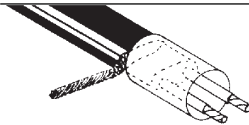
- Cut away any remaining material and trim the tip of the conductors.



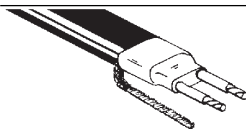
- Mount the crimp tube 3/1, L = 15 mm onto the conductors.



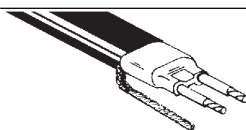
- Crimp the tubes.



- Pull crimp tube, type 12/3. L = 20 mm over the cable so that it meets the outer sheath and protrudes at least 5 mm over the inner layer of the material.



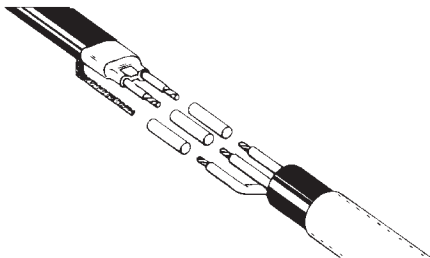
- Crimp the tube.



- Press the tube between the conductors with flat bit pliers until the glue becomes visible.

Assembling

1. Pull the crimp tube 12/3, L = 80 mm over cable no. 2
2. The conductors are joined together with the help of squeeze connection tubes.



3. Warm the squeeze connection tubes until the tubes crimp and the glue flows.
4. Place the crimp tube, type 12/3 over the joint in a central position.
5. Pull the screen (from cable no.1) over the joint and secure it.
6. Pull the screen (from cable no.2) over the joint and screen of cable no. 1. Secure the screen with the enclosed TESA insulation tape.
7. Place the soldering tube over the joint and crimp so that the tin solder flows out properly.
8. Wrap 50 mm of adhesive tape around the outside sheath of the cable. Start approximately 30 mm inside and pull the tape over the joint. The outer end of the joint is taped in
9. the same way. Place the crimp tube, type KYNAR
10. 3/4, L = 170 mm centrally and crimp down. Make sure that the adhesive tape flows properly out over the entire joint.

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