

GB/NO

# Fitting instruction

devi-pipeheat / devi-flexheat

Assembly between cold tail and self-  
limiting heating cable

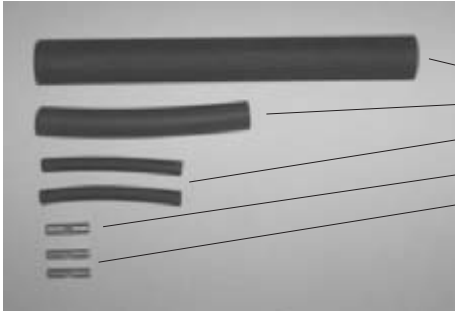
Item no. 19806415

Montering av tilledning på selvbegrensende  
varmekabel

Art. nr. 19806415



## Fitting set

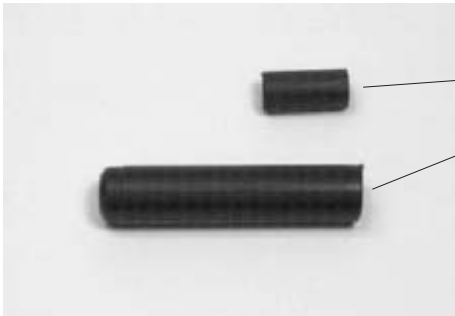


### For connection:

- 1 x 12/3 crimp tube, 150 mm
- 1 x 9/3 crimp tube, 85 mm
- 2 x 4/1 crimp tube, 45 mm
- 1 x rivet 2.5 mm<sup>2</sup>
- 2 x rivet, 1.5 mm<sup>2</sup>

### For tillkopling:

- 1 stk. 12/3 krympeflex, 150 mm
- 1 stk. 9/3 krympeflex, 85 mm
- 2 stk. 4/1 krympeflex, 45 mm
- 1 stk. skjøtehylse 2,5 mm<sup>2</sup>
- 2 stk. skjøtehylse 1,5 mm<sup>2</sup>



### For end sealing:

- 1 x 6/2 crimp tube, 20 mm
- 1 x end sealing, 11/4 x 60 mm

### For endeavslutning:

- 1 stk. 6/2 krympeflex, 20 mm
- 1 stk. krympe-ende, 11/4 x 60 mm

## Practical fitting details

A temperature of approx. 150-200° is required for crimping down crimp tubes. A hot air blower with temperature control is the best fitted tool. However, it is possible to apply propane burner modified for application on crimp plastics

To obtain the best possible contact between rivet and conductor appropriate pliers should be used, e.g. types DKB 0325 or RQ 0560.

Det kreves en temperatur på 150°C- 200°C, for å oppnå et godt resultat for krymping av krympeflex. En varmluftspistol med mulighet for regulering av temperaturen er et godt egnet verktøy.

Man må passe på at det blir god og varig kontakt mellom lederne og skjøtehylsene.

## Ready-making of the heating cable



1. Remove 30 mm of the heating cable outer sheath.

Fjern 30 mm av kabelens ytterkappe.



2. The screen is released and twisted.

Skjermen frigjøres, og tvinnes.



3. Now, remove the outmost 20 mm of the primary insulation. Use knife. Cut up the core material along one of the conductors and release it.

Finally, the core material is removed from the outmost 10 mm of the other conductor.

Fjern 20 mm av primærisolasjonen med kniv. Klipp kjernematerialet opp langs den ene lederen, og frigjør denne. Fjern deretter 10 mm av kjernematerialet på den andre lederen.

## Ready-making of the cold tail



4. Remove 50 mm of the outer sheath.

Fjern 50 mm av ytterkappen.



5. Remove the outmost 50 mm of the secondary insulation, too. Now, strip off approx. 10 mm of each of the three conductors.

Provided two-conductor cold-tail with screen is used, the screen is released and twisted.

Fjern 50 mm av mellomkappen, og deretter 10 mm av isolasjonen på hver leder.

## Assembly / Ready-making



6. Now the two cables are ready for assembly. 1.5 mm<sup>2</sup> rivet is squeezed onto the two conductors (L+N) and 2.5 mm<sup>2</sup> rivet is squeezed onto screen/ground wire, all on the cold tail.

Kablene er klare for tilkopling. Skjøtehylse 1,5 mm<sup>2</sup> klemmes på lederne (L+N), og 2,5 mm<sup>2</sup> skjøtehylse klemmes på jordlederen på tilledningen.



7. Crimp tube 4/1, L=45 mm is pulled in over the two conductors (L+N) of the cold tail. Crimp tube 12/3, L=150 mm is pulled in over the outer sheath of the cold tail. Crimp tube 9/3, L=85 mm is pulled in over the outer sheath of the heating cable.

Krympeflex 4/1, L=45 mm trekkes over de to lederne (L+N) på tilledningen. Krympeflex 12/3, L=150 mm trekkes over ytterkappen på tilledningen. Krympeflex 9/3, L=85 mm trekkes over ytterkappen på varmekabelen.



8. The two heating cable conductors are connected with the two 1.5 mm<sup>2</sup> rivets of the two cold tail conductors (L+N). The rivets are squeezed onto it.

Varmekabelens ledere klemmes i hver sin 1,5 mm<sup>2</sup> skjøtehylse påsatt tilledningen (L+N).



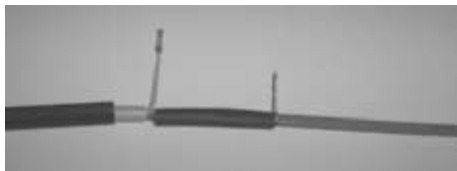
9. Crimp tube 4/1, L=45 mm is pulled in over the two riveted conductors. Make sure that they reach the primary insulation of the heating cable. Make sure that the crimp tube covers the wire completely.

Krympeflex 4/1, L=45 mm trekkes over skjøtehylsene, helt inn mot primærisolasjonen. Sørg for at krympeflexen dekker ledende deler. Alle krympeflex må sentreres innen krympning.



10. The two crimp tubes are crimped down from the middle out towards the ends.

De to krympeflexene krympes fra midten, og ut mot sidene.



11. Crimp tube 9/3, L=85 mm is pulled over the connection to ensure that the screen/ground wire is still free.

Krympeflex 9/3, L=85 mm trekkes over skjøten. Pass på at jordlederene fortsatt er frie.



12. The crimp tube is crimped down from the middle out towards the ends.

Krympeflexen krympes fra midten og ut mot sidene.



13. The heating cable screen is connected with the 2.5 mm<sup>2</sup> rivet on the cold tail screen/ground wire. The rivet is squeezed onto it.

2,5 mm<sup>2</sup> skjøtehylse klemmes på varmekabelens og tilledningens jordleder.



14. Crimp tube 12/3, L=150 mm is pulled over the entire connection. The crimp tube is crimped down from the middle out towards the ends.

Krympeflex 12/3, L=150 mm trekkes over hele skjøten, og krympes fra midten og ut mot sidene.



15. Make sure that the glue is running out from both ends of the crimp tube.

Now the assembly is finished.

Kontroller at limet kommer frem i hver ende av krympeflexen.

Tillkoplingen/konfeksjoneringen er nå ferdig.

## Sealing the end of the heating cable



1. Remove 15 mm of the outer sheath.  
Remove the screen braid from the 15 mm stripped cable, too.  
Be careful not to damage the primary insulation.

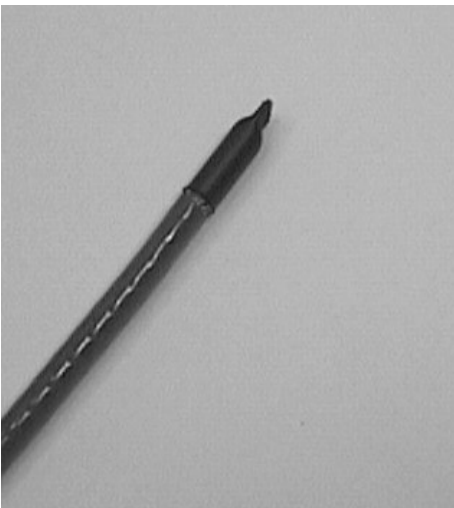
Fjern 15 mm av ytterkappen.

Fjern også skjermen(jordleder), fra den avisolerte kabel. Pass på at primærisolasjonen ikke blir skadet.



2. Crimp tube 6/2, L = 20 mm is pulled in over the end of the cable to the edge of the removed outer sheath. 5 mm of the crimp tube must still be free of the cable.

Trekk krympeflex 6/2, L = 20 mm inn over enden av kabelen til kanten av den avisolerte ytterkappen. 5 mm av krympeflexen må overlape ytterkappen.



3. The crimp tube is crimped down, whereafter the outer 5 mm is squeezed with a pliers. Make sure that the glue is running out from both ends of the crimp tube.

Krympeflexen krympes, og de ytterste 5 mm klemmes sammen med en flattang.

Kontroller at limet kommer frem i hver ende av krympeflexen.



4. Pull the end sealing in over the heating cable.

Trekk krympeflex-enden, inn over enden.



5. The end sealing is crimped down from the sealed end and in over the cable. Make sure that the glue is running out from the end of the end sealing.

Krympeflex-enden krympes fra enden og inn mot varmekabelen.

Kontroller at limet kommer frem i enden.



6. The heating cable is sealed / terminated.

Endeavslutningen er nå ferdig.

## Application of devi-pipeheat in pipes



1. For fitting of devi-pipeheat in pipes should be applied 1" stuffing box for water proof lead-in of the heating cable in the pipe.

Order 1" stuffing box as item no. 19805367.

Important!

Never install devi-flexheat inside a pipe!

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