

### Joint Closure System for pressurized Telephone Networks



#### XAGA 1000 Kit contents

- Heat-shrinkable sleeve
- Metal canister (2 half shells)
- Flexible channels + underclip
- Aluminium closing strips
- Cleaning tissues
- Abrasive strip
- Aluminium cable foil
- Valve nut + valve plug
- Shield continuity wire
- Installation procedure

**Note:** For straight (1 in - 1 out) joints, use the standard XAGA 1000 kit. Branched joints require the use of one additional branch-off kit (BOKT 1000-6 or 7) per added cable.

#### Recommended safety rules

- check manhole for gas
- use safety glasses and safety gloves when working with open flame.

#### Selection table/Ordering information

all dimensions in mm

CommScope PART No.	Joint dia.	Single cable dia.	Sheath opening L	Recommended sum of branch cable dia's			Branch-off kit
	max.	min.	nom.	2 out max.	3 out max.	4 out max.	
XAGA-1000C-43/8-350	43	8	350	33			BOKT-1000-6
XAGA-1000C-62/15-250	62	15	250	52	40		BOKT-1000-6
XAGA-1000C-62/15-350	62	15	350	52	40		BOKT-1000-6
XAGA-1000C-62/15-500	62	15	500	52	40		BOKT-1000-6
XAGA-1000C-62/15-650	62	15	650	52	40		BOKT-1000-6
XAGA-1000C-92/30-350	92	30	350	82	70	58	BOKT-1000-6
XAGA-1000C-92/30-500	92	30	500	82	70	58	BOKT-1000-6
XAGA-1000C-92/30-650	92	30	650	82	70	58	BOKT-1000-6
XAGA-1000-122/38-300	122	38	300	112	100	88	BOKT-1000-6
XAGA-1000-122/38-500	122	38	500	112	100	88	BOKT-1000-6
XAGA-1000-122/38-650	122	38	650	112	100	88	BOKT-1000-6
XAGA-1000-122/38-900	122	38	900	112	100	88	BOKT-1000-6
XAGA-1000-160/55-300	160	55	300	142	130	118	BOKT-1000-7
XAGA-1000-160/55-500	160	55	500	142	130	118	BOKT-1000-7
XAGA-1000-160/55-650	160	55	650	142	130	118	BOKT-1000-7
XAGA-1000-160/55-720	160	55	720	142	130	118	BOKT-1000-7
XAGA-1000-160/55-900	160	55	900	142	130	118	BOKT-1000-7
XAGA-1000-200/65-500	200	65	500	172	160	148	BOKT-1000-7
XAGA-1000-200/65-720	200	65	720	172	160	148	BOKT-1000-7
XAGA-1000-200/65-900	200	65	900	172	160	148	BOKT-1000-7

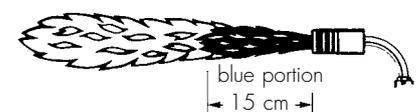


#### BOKT kit contents

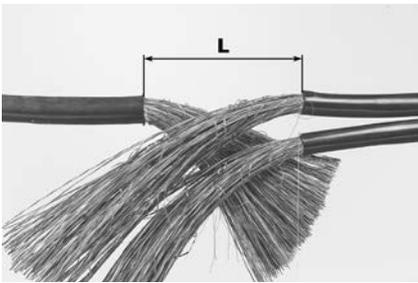
- 1 Branch-off clip
- 1 Cleaning tissue
- 1 Abrasive strip
- 1 Tie wrap
- 1 Aluminium tape
- 1 Shield continuity wire + connector

#### Flame description

Flame length 25-30 cm



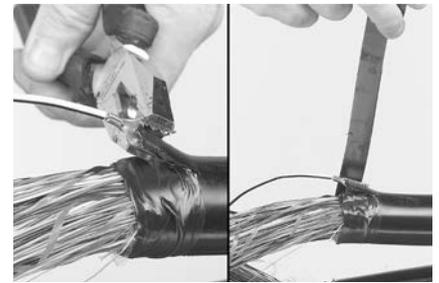
Use a CommScope nozzle FH-T001-0020 or equivalent.



**1** Remove cable sheath then follow locally prescribed jointing techniques.



**2** In order to install the shield continuity assembly, cut the cable jacket over a length of 25 mm and a width of 10 mm. Put cotton tape (not included in the standard kit) underneath the cable jacket strip.



**3** Install shield continuity clip with standard pair of pliers and wrap the entire shield continuity connector with PVC tape (not included in the kit).



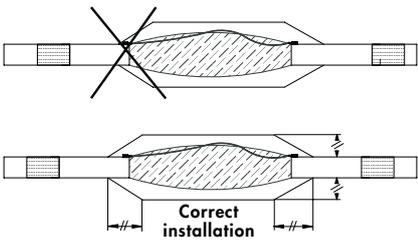
**4** For joints with more cables at one end install the branch continuity wire assembly, using a crimp connector.



**5** Construct joint according to standard procedure and wrap joint with insulating material (not included in standard kit).



**6** All sizes: assemble the two half shells symmetrical to form a hinged canister and secure one of the seams with self-adhering aluminium tape. Center and fit metal canister over the joint. Smooth the tape with a blunt tool.

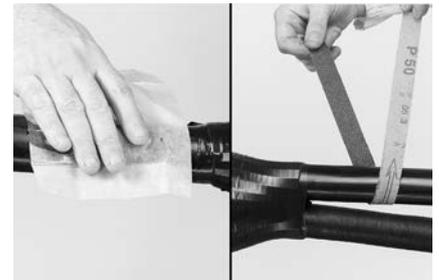


**7** Make sure the metal canister is centered correctly.



**8** Using PVC-tape (not included in standard kit), tape the crowns, starting from the canister body, down to the cable.

**Note for branched joints only:** Before taping, position canister such that one of the seams of canister is on top of the biggest cable.

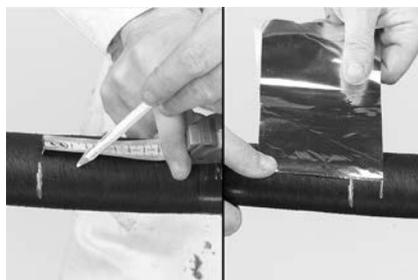


**9** Remove solvent impregnated tissue from its package and clean all cables for a distance of 20 cm. Abrade all the cables circumferentially over the same length.

**For lead sheath:** use local approved method to abrade.



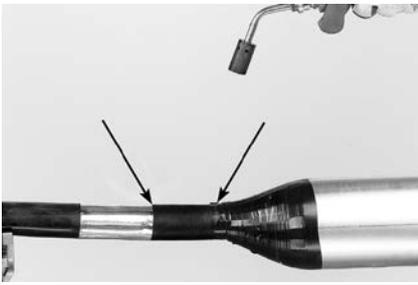
**10** Center the sleeve over the canister by placing the metal ring in the sleeve over the valve in the canister. Mark ends of sleeve on cable jacket.



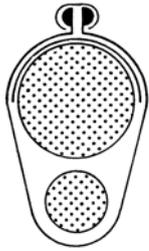
**11** Add a second mark 25 mm nearer the splice. Apply aluminium tape on PE-cables away from the canister starting from the inner mark.



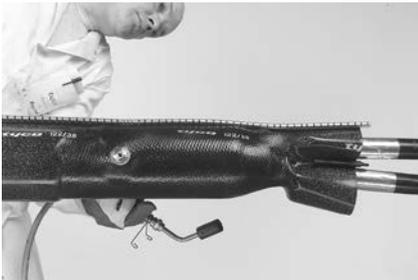
**12** Smooth the aluminium tape with a blunt tool to smooth sharp edges.



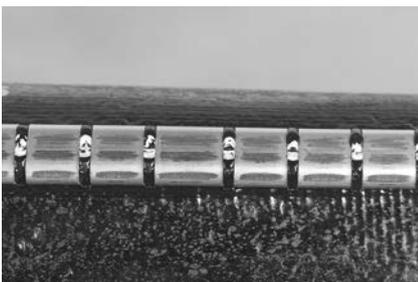
**13** Flame brush cable areas between arrows for about 10 seconds. Make sure to touch entire cable surface with yellow tip of flame.  
**For lead cables:** preheat cables up to 60°C (hot to the touch).



**16 Important:** for branched joints: position the sleeve such that the adhesive flap and sleeve rails are over the largest cable (see drawing).



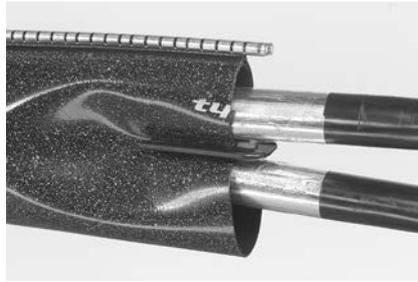
**19** When the paint has completely changed to black, gradually and progressively move towards the end moving the flame circumferentially around the closure.



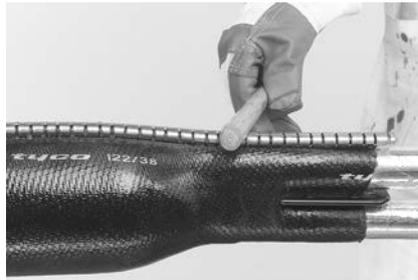
**22** When all the T.I. paint has changed on the first half of the closure, white lines should be visible underneath the channel between the center and the end of the transition. If at any point the white lines are not visible then heat the closure at that point until they appear.



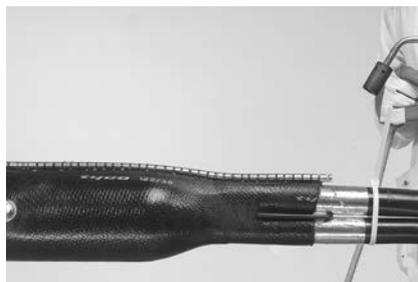
**14** Attach the sleeve to the canister with the valve nut and hand tighten.  
**Note:** do not install insert or plug before completion of installation.



**17** For branched joints insert the branch-off clip (from BOKT-kit) between the cables. Ensure that it is totally inserted. Best results are achieved by apportioning the sleeve according to the cable diameters.



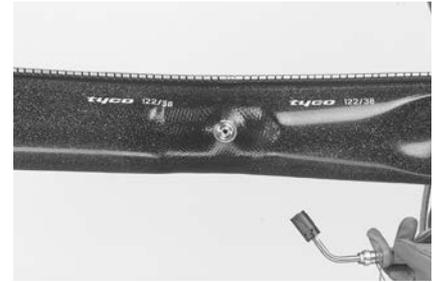
**20** Push the channel down to follow the transition of the sleeve with a suitable tool.



**23** Now circumferentially heat the outlet until two separate white lines are visible or adhesive flows from the rail and channel area is visible. For branched outlets also ensure that the yellow clip adhesive is flowing.



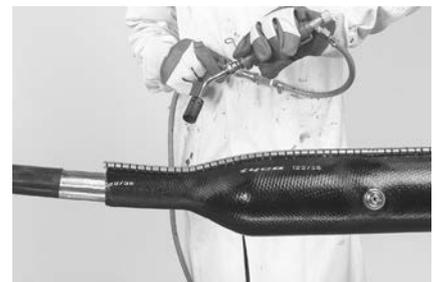
**15** Slide the flexible channels over the sleeve rails leaving a small gap at the center for the retention clip. Position the retention clip in the opening between the channels and slide the channels evenly over the clip.



**18** Start heating at the center around the valve. Shrink sleeve circumferentially until the temperature sensitive point has changed from green to black.



**21** For branched joints only: press the cables together with a tie wrap from the BOKT-kit.



**24** Return to the starting point at the center and repeat for the other half (steps 18 to 23).



**25** Allow the sleeve to cool down undisturbed for at least 15 minutes. Tighten the valve nut.



**26** Insert the valve plug or other device.

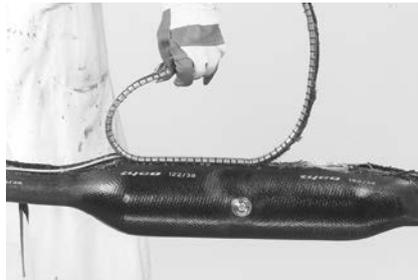


**27** Re-pressurisation may be done after 30 minutes cooling time.

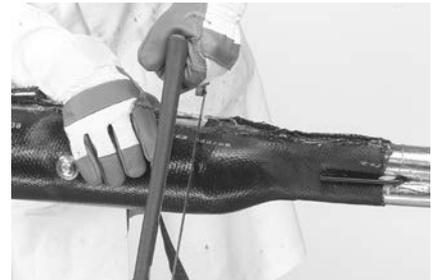
## Removal



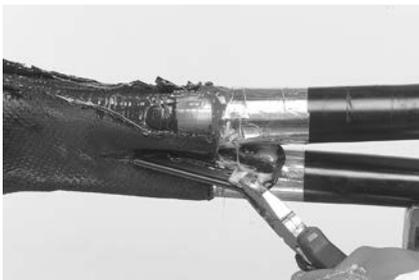
**1** Remove the valve plug or the core valve.



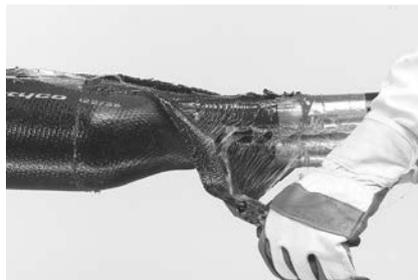
**2** Heat the channel area and cut off channel starting at ends cutting towards middle.



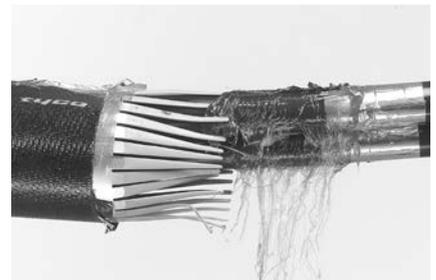
**3** Using a hack-saw, cut through sleeve material onto the inner metal canister.



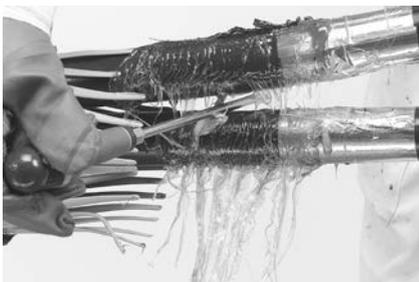
**4 For branched joint:** heat clip area and remove clip with a pair of pliers.



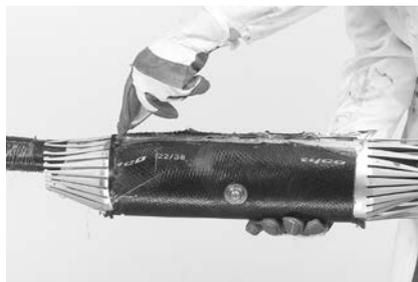
**5** Remove the sleeve ends with pliers, if necessary reheat.



**6** Remove tape on the crowns of the canister.



**7** While the adhesive is hot, separate cable, with appropriate tool (e.g. screwdriver) to facilitate clip inserting when reclosing.



**8** Longitudinally cut the sleeve on the seam of the canister and separate the canister.



**9** Remove the canister and rework the splice.

## Re-closing

Use a new XAGA 1000 kit and repeat installation instructions procedure. The remaining adhesive does not have to be removed from the cables, but it has to be cleaned free of grease and dirt.

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