



Fitting instructions

Devicrimp kit 1-cond. Assembly or repair Fitting set for single conductor cables

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by Danfoss

1 Fitting set

18055442 (1,5-2,5 mm²)

- 2 x outer crimp tube
- 2 x inner crimp tube
- 2 x cu-rivets
- 2 x cu-screen
- 4 x cu-wire

2 How to connect the heating cable

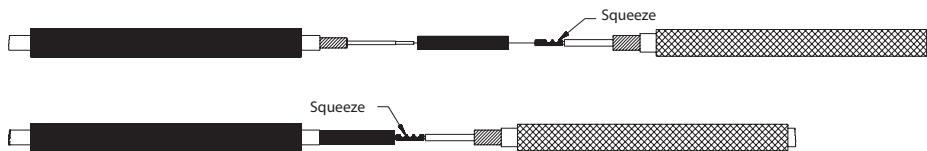
It is very essential to follow this instruction very carefully that when finished no connections are missing or wrong with the risk of the cable not working or being overheated. Therefore read the entire instruction to the end before you start.

2.1 Preparation of the heating cable

1. Make sure that the fitting set is complete.
2. Push the outer crimp tube over the heating cable and the copper protection screen over the cold tail end and strip the cable.

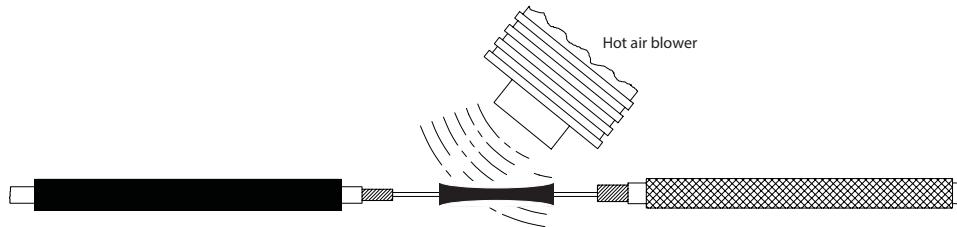


3. Push the inner crimp tube over the heating cable. Connect the ends of the cable wires with the rivet, and then squeeze the rivet tight with pliers type DKB 0325 or other appropriate pliers.
Type DKB 0325 up to 2,5 mm²
Type CWB 4099 from 4,0 up to 10 mm²

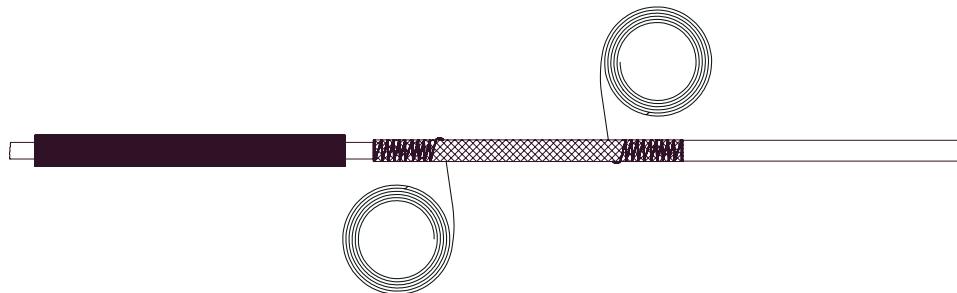


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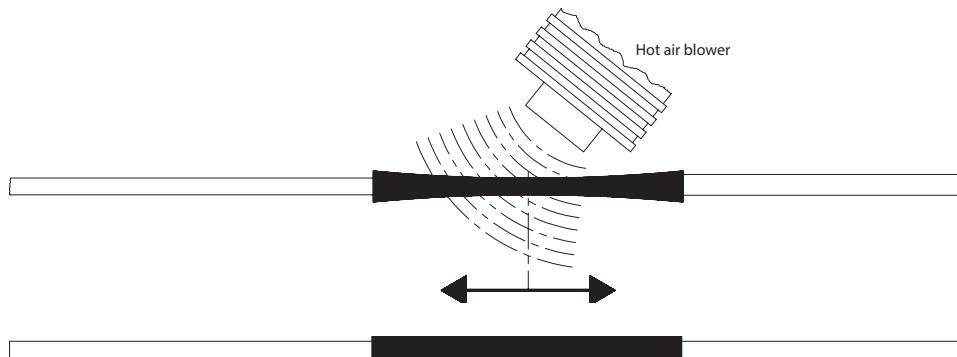
4. Push the inner crimp tubes over the rivet joint, and crimp down with the help of a hot air blower (temperature approximately 200°C).



5. Pull the copper protection screen over the joint, and fasten it in position using cu-wire. Make sure the protection screen has good contact with the cable screen/earth wire.



6. Pull the large crimp tube over the copper protection screen making sure that the tube overlaps equally at both ends.
7. Start by heating the middle of the crimp tube so that the air is pressed out of it. Make sure that the glue is running out from both ends of the crimp tube before stopping. The entire assembly should be completely tight and water proof.



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