

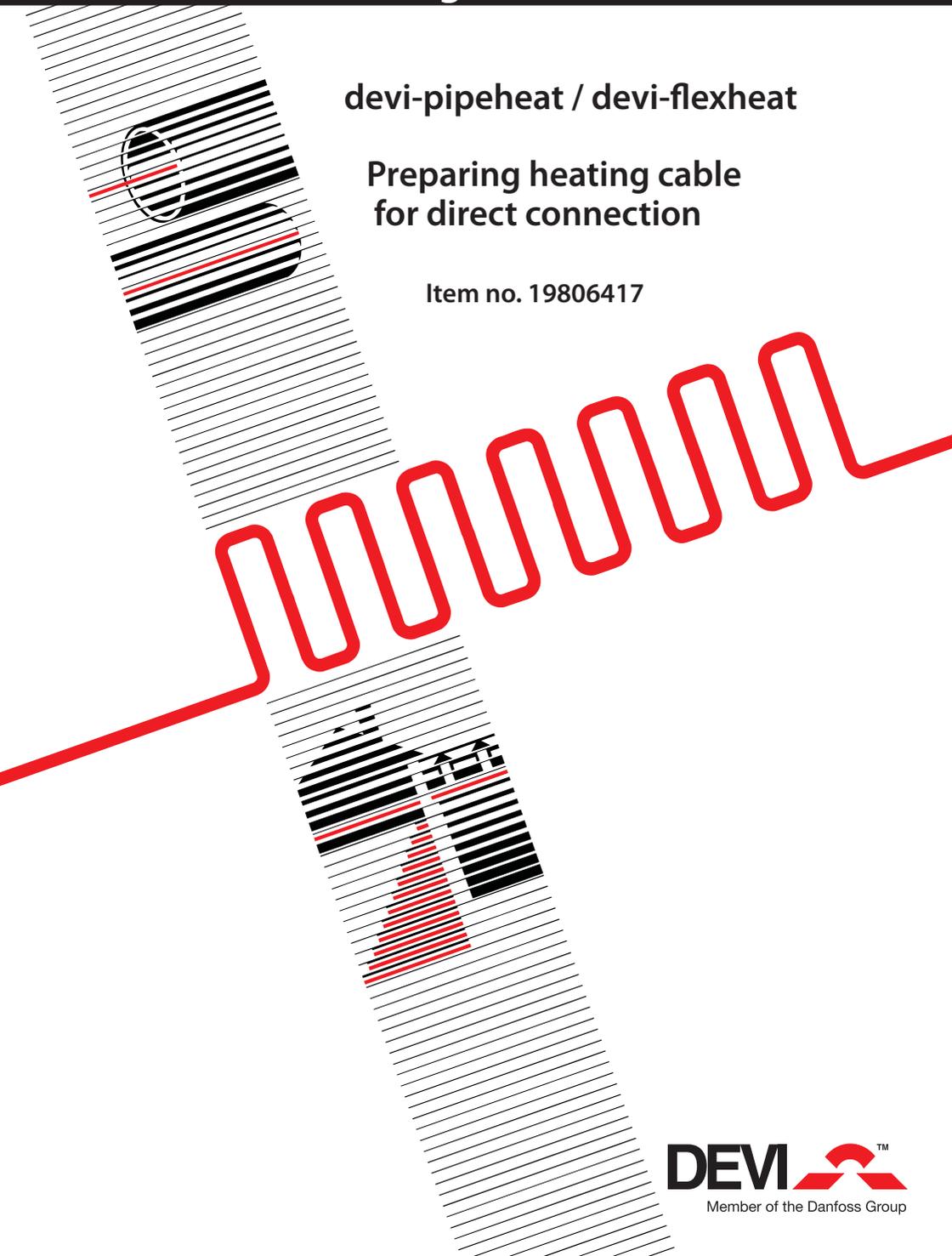
**GB**

# Fitting Instruction

**devi-pipeheat / devi-flexheat**

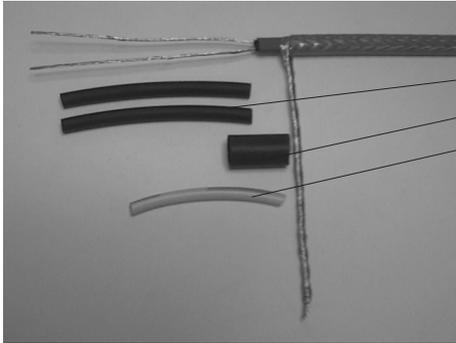
**Preparing heating cable  
for direct connection**

Item no. 19806417



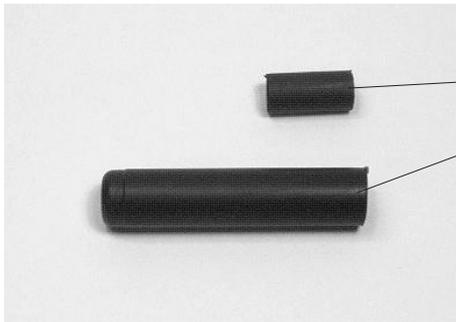


## Fitting set



### For connection:

- 2 x 4/1 crimp tube, 70 mm
- 1 x 9/3 crimp tube, 20 mm
- 1 x Yellow/Green tube, 50 mm



### For end sealing:

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

## Practical fitting details

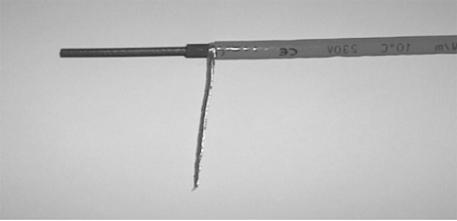
A temperature of approx. 150-200° is required for crimping down crimp tubes. A hot air blower with temperature control is the best fitted tool.

However, it is possible to use propane burner modified for application on crimp plastics.

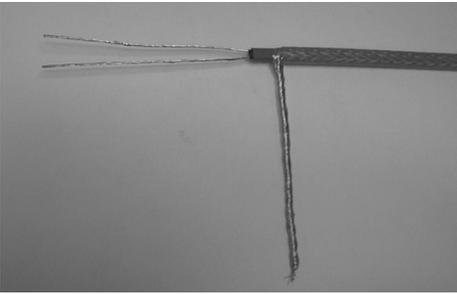
## Ready-making of the heating cable



1. The heating cable is stripped over a length of 90 mm.



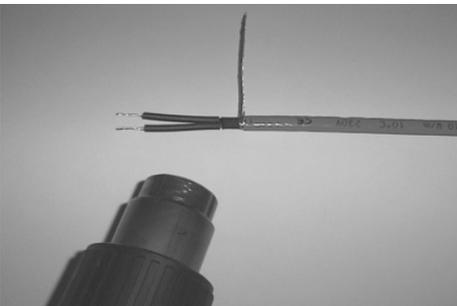
2. The screen is released and twisted. Following this, remove the outmost 80 mm of the primary insulation. Use knife.



3. The core material is removed from the conductors, also from the outmost 80 mm. Be careful no to damage the conductors.



4. Crimp tube 4/1, L=70 mm is pulled on to the two stripped wires.

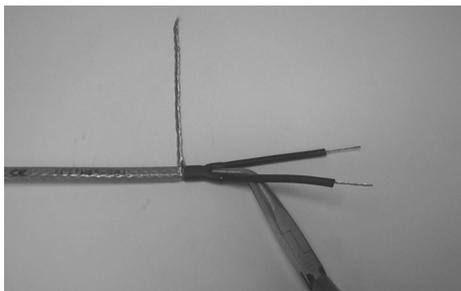


5. The crimp tube is crimped down from the core material towards the cable end.

## Ready-making of the heating cable



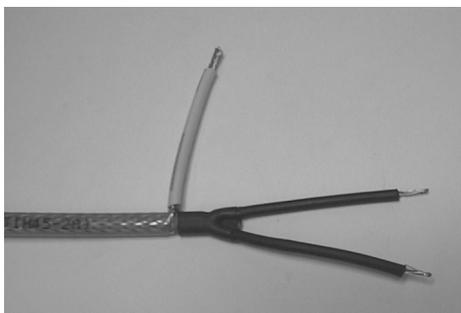
6. Crimp tube 9/3, L=20 mm is pulled in over the two conductors, all the way to the twisted screen in order to cover approx. 10 mm of the primary insulation and approx. 10 mm of the conductors.



7. The crimp tube is crimped down and immediately after this the outmost 10 mm are squeezed together on the middle with flat pliers.

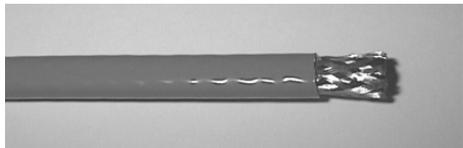


8. Yellow/Green, L=50 mm tube is pulled in over the twisted screen.



9. Now the heating cable is ready for direct connection.

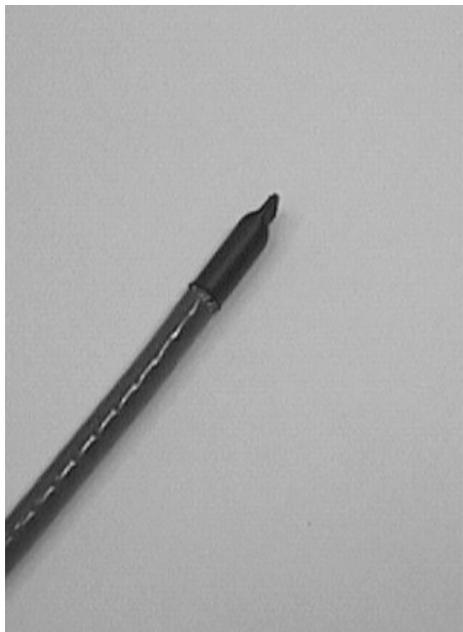
## Sealing the end of the heating cable



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.



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.



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.

## Sealing the end of the heating cable



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



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.



6. The heating cable is sealed / terminated.

## 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!

Article no. 08090252

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