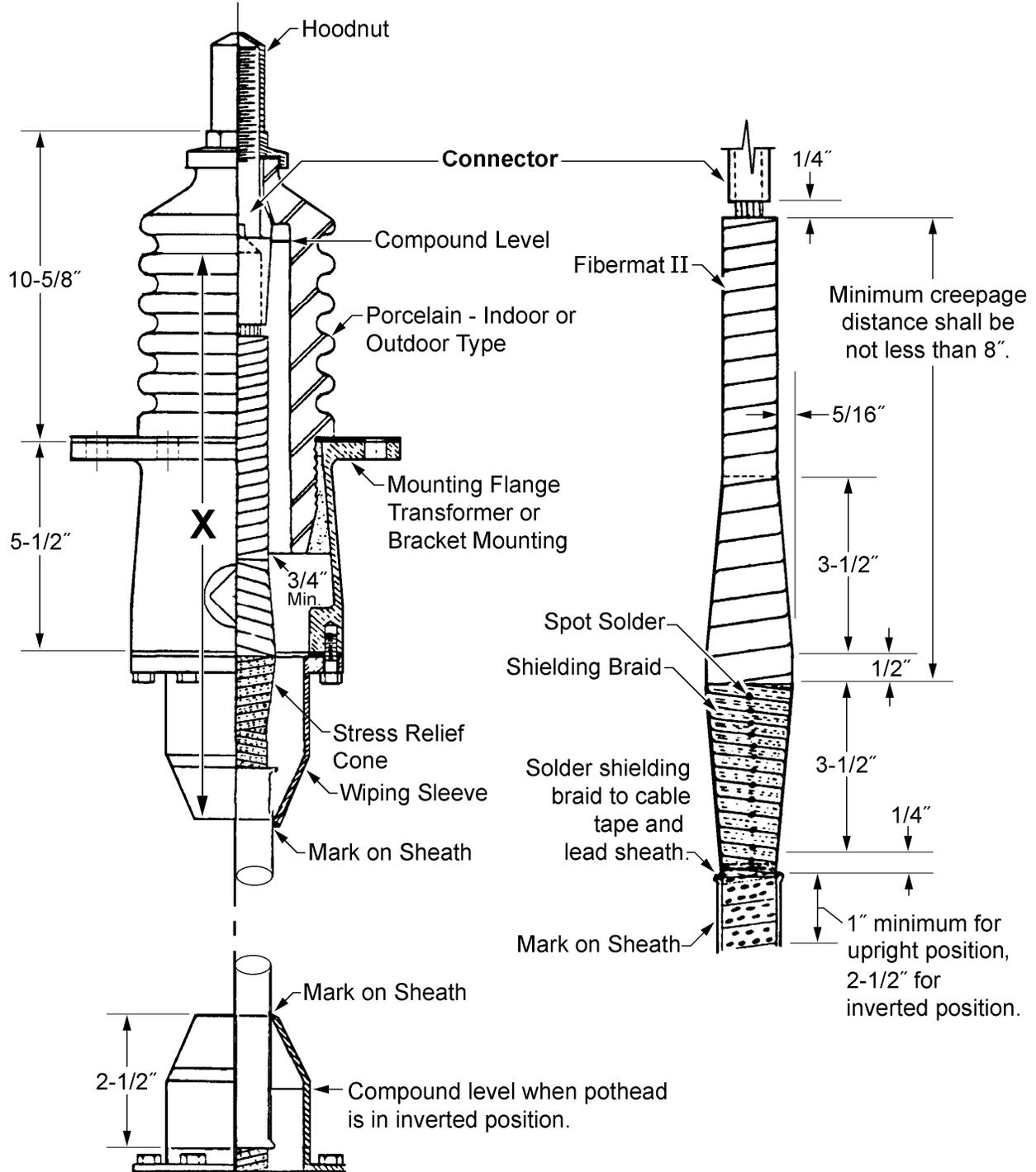


**TERMINATION - POTHEAD, 25 KV  
 SINGLE CONDUCTOR, PILC-PEJ**



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**CONSTRUCTION GUIDELINE**

- A. Mount pothead temporarily in position. Cut wiping sleeve fitting to slip over cable sheath. Train cable in front of pothead and mark cable sheath even with the bottom of the wiping sleeve.
- B. Assemble the connector temporarily in the porcelain. Using a stiff wire, measure the length "X" from the bottom of the connector soldering hole to the bottom of the wiping sleeve.
- C. Cut off the cable that is beyond the "X" distance from the mark on the sheath.
- D. Remove the wiping sleeve fitting from the pothead and slip it down over the cable.
- E. When pothead is installed in upright position, strip off the sheath to within one inch (minimum) from the entrance location mark. When pothead is installed in an inverted position, strip off the sheath to within 2-1/2 inches from the entrance location mark so that the compound level will be above the end of the lead sheath when the pothead is filled. Remove the metalized paper tape to within 1/4-inch from the end of sheath.
- F. Remove the insulation from the end of the cable approximately 1/4-inch longer than the depth of the connector soldering hole. Also remove exposed semi-conducting tape next to the surface of the conductor. Pencil the paper insulation approximately 1-inch. Remove the connector from the pothead and solder on to the conductor. Be sure that the connector locking fins will line up with the slots in the top of the porcelain.
- G. Brush the exposed insulation with heated taping oil\*. Starting at the connector end of the cable, wrap 3/4-inch varnished poly tape, half-lapped, in the same rotational direction as the outer layer of conductor insulation. Wrap back and forth evenly, basting each layer of tape with taping oil until the double cone has been built up to a thickness of 5/16-inch. Finish by wrapping the last layer toward the connector end of the conductor.
- H. Starting 3-3/4 inches above the cable sheath, wrap one layer of 1-inch tinned copper shielding mesh tape half-lapped so that the upper edge is even and continue wrapping down the cone - over the cable shielding. Solder the mesh tape between turns and to the cable shielding. Solder shielding to the lead sheath.
- I. Assemble pothead and attach entrance flange to base. Screw the hoodnut onto the connector. Solder wipe the lead sheath to the wiping sleeve entrance.
- J. Remove the lower 1-inch gasketed pipe plug from the body and insert a standpipe of sufficient length to extend 1-foot above the pothead. Loosen the hoodnut. Place funnel in standpipe and fill with heated\* compound until compound shows at top of porcelain. Wipe the porcelain clean and tighten hoodnut. Apply heat to standpipe adding compound as required, until compound in the pothead has cooled. When the pothead is installed in an inverted position with the hoodnut below the compound filling hole, the hoodnut cannot be loosened for venting. In this case drill a 1/4-inch hole in the wiping sleeve entrance fitting for venting.
- K. Remove standpipe and screw in pipe plug. Seal by soldering edge of plug to boss. Clean exposed surfaces of the porcelain.
- L. The following potheads are covered by this Construction Guideline:  
 Joslyn Cat. J9283-1 for No. 1 Cable;  
 Joslyn Cat J9283-2 for 500 kcmil Cable  
 G&W Cat. ST 182E for 250 kcmil Cable.

\* See manufacturers recommendations for application temperatures.

**Material List**

Quantity	Description	Stock No.
As Required	Rosin Core Solder	728504
2 RL	3/4" Varnished Poly Tape	736682
1 RL	1" Tinned Copper Shielding Braid	736244
1 QT	Taping Oil – Mineralac #1 Compound	726320
5 EA	40 – 60 Bar Solder	728496
1 EA	Solder Flux	728112
As Required	Filling Compound	726318