

# MARINE CABLE SPLICE INSTRUCTIONS 33-045 MARINE SPLICE KIT

**IMPORTANT - PLEASE READ THESE DIRECTIONS COMPLETELY BEFORE PROCEEDING. ADHESIVE TO BE APPLIED AT TEMPERATURE ABOVE 15.6° C (60° F)**

## Application

This splice kit is designed to provide adequate materials for the splicing of two projector cables of 10mm (3/8") diameter (ref. Airmar C41 type), having two #16 AWG inner conductor wires.

## Tools Required

Solderless terminal crimping tool (not provided)  
Dispenser gun (sold separately ref. #09-458)  
Open-end wrench or slip-joint pliers (two)

## Splice Kit (see Figure 5)

Qty	Part No.	Description
1	08-036	Urethane Adhesive Duo-Pack
2	09-456	EPX Mixer Nozzle
2	09-455-1	Coupling Pipe
4	09-457	Compression Bushing
4	05-078	Butt Connector

## INSTRUCTIONS

### CABLE PREPARATION:

1. Cut the cable at location of planned splice. For Damaged cable, and examine cut ends for signs of corrosion, water, or dirt. Cut off affected cable, until trimmed cable ends are clean.
2. Slide one compression bushing at least 153mm (6") back from each cable end as shown in Figure 1.
3. Prepare the individual wires as indicated in Figure 1.

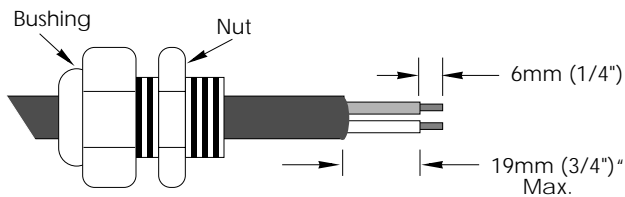


FIGURE 1 Cable Preparation

### PIPE ASSEMBLY

4. Slide the 77mm (3") long coupling pipe over the end of one of the prepped cables, allowing the compression bushing to advance up the cable.

5. Match and butt the stripped ends of the two black wires inside the butt-connector as shown in Figure 2. Crimp connector with crimping tool.

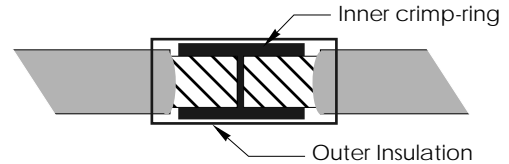


Figure 2 Crimp Inner Conductors

6. Repeat step 5 for the two blue wires.
7. Check distance from jacket-to-jacket as shown in Figure 3.

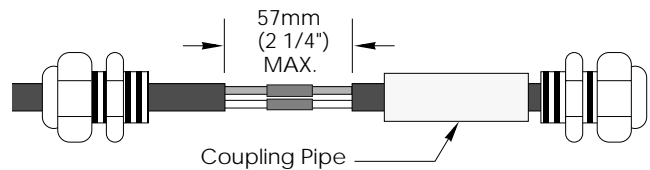


Figure 3 Maximum Jacket Gap

8. Thread nearest compression bushing all the way into the coupling pipe, using the narrow flange nut.
9. Slide the coupling pipe bushing assembly over the spliced wires as shown in Figure 4, and secure in place by tightening the compression bushing

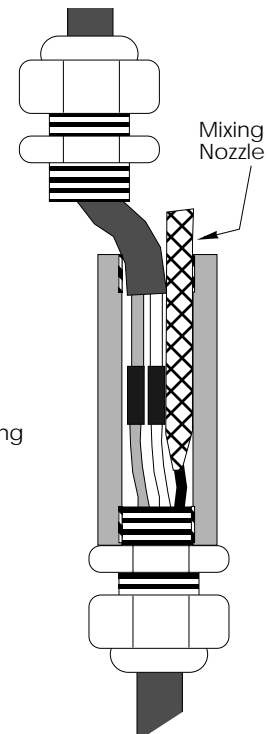


Figure 4

Filling Coupling Pipe

10. If a second splice is to be done, follow steps 1 through 9 on the second splice before proceeding to step 11.
11. Following Manufacturer's instructions, assemble the urethane adhesive Duo-pak, dispenser, and one mixer nozzle.
12. Insert the mixer nozzle as far as possible into the open end of the coupling pipe as shown in Figure 4. Fill the inside of the pipe, from the bottom, up, withdrawing the mixer nozzle slowly as the pipe fills. Fill the pipe to the top of the threads, taking care not to leave any air inside the pipe.
13. Quickly thread the remaining compression bushing into the open end of the pipe, and tighten the bushing securely.
14. Clean any excess urethane adhesive from the completed splice.
15. Remove the mixer nozzle and install the storage cap onto the urethane adhesive duo-pak.  
Note: enough adhesive remains to accommodate one more splice.

