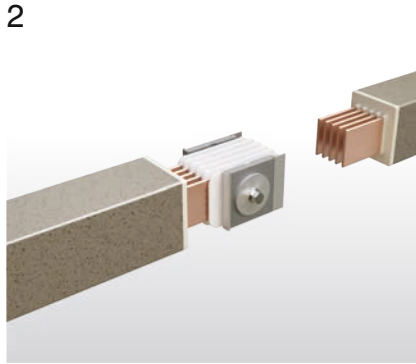
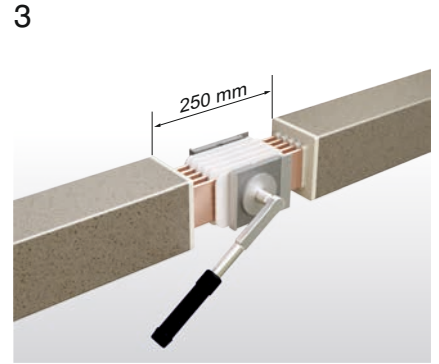


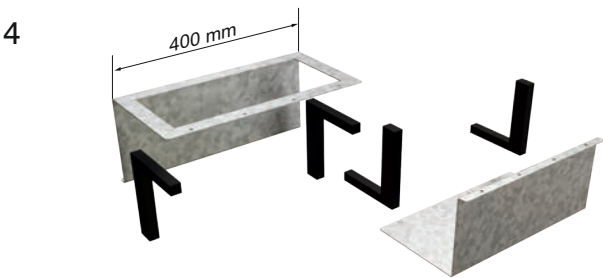
1
Conductors must be cleaned using a cloth to remove dust and damp. Then install and fix the joint block



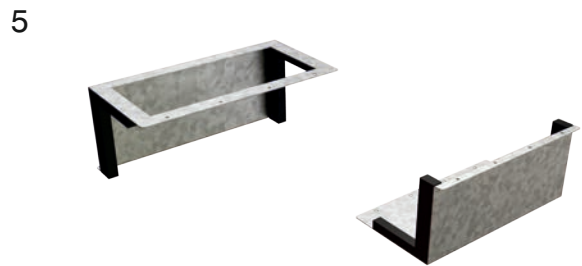
2
The second busbar is introduced and installed to the joint block



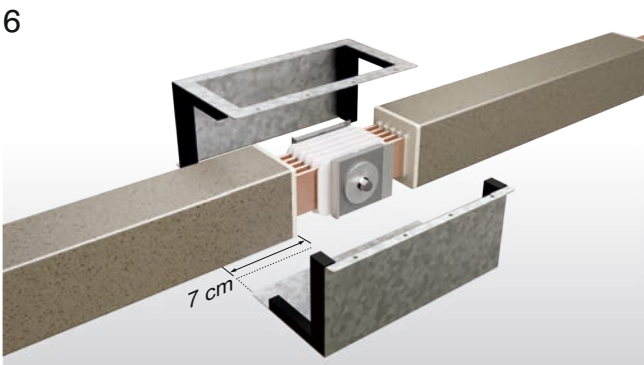
3
After checking the three parts for correct alignment, and the distance between the two busbar lengths is 25cm tighten the joint to 83 Nm using a torque wrench.



4
Assemble the casting moulds and place rubber sealing strips into the shaped returns.



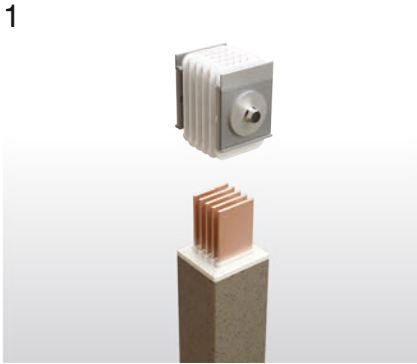
5
Before the casting mould is fitted, apply de-moulding agent wax to all surfaces of the inside of the casting moulds and wait until wax is totally dry. This is imperative to enable removal of the casting moulds after setting.



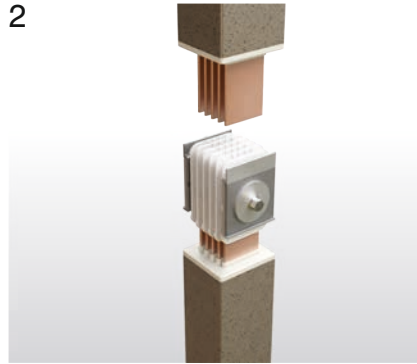
6
The casting mould plates must be fitted approximately 7 cm from busbar end.



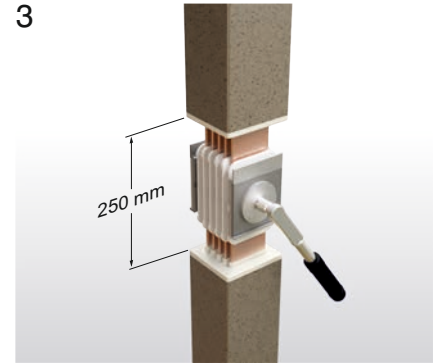
7
Please check the installation manual to get extra information.



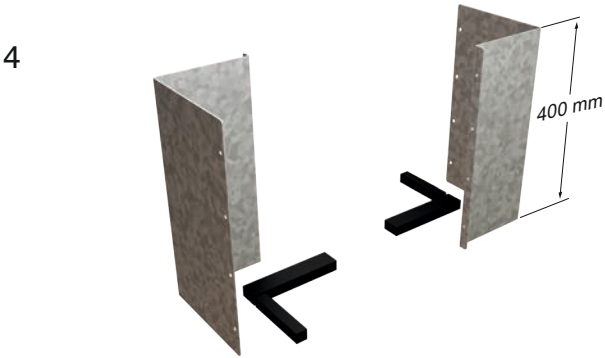
1 Conductors must be cleaned using a cloth to remove dust and damp. Then install and fix the joint block.



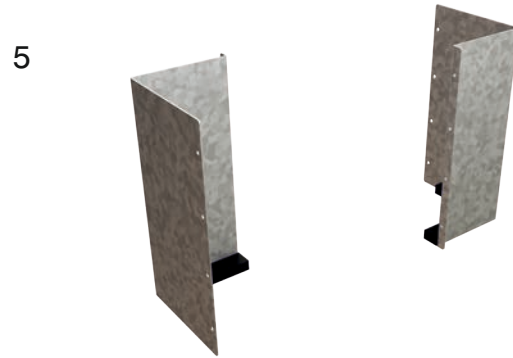
2 The second busbar is introduced and installed to the joint block.



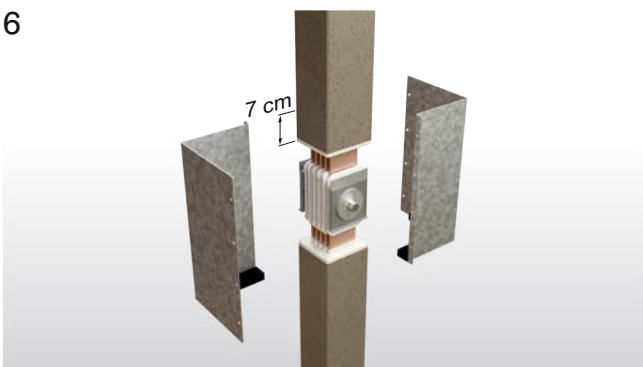
3 After checking the three parts for correct alignment, and the distance between the two busbar lengths is 25cm tighten the joint to 83 Nm using a torque wrench.



4 Assemble the casting moulds and place rubber sealing strips into the shaped returns.



5 Before the casting mould is fitted, Apply de-moulding agent wax to all surfaces of the inside of the casting moulds and wait until wax is totally dry. This is imperative to enable removal of the casting moulds after setting.



6 The casting mould plates must be fitted approximately 7 cm from busbar end.



7 Gaskets must be located only bottom part of the mould plates. By this way resin can be poured from top side.

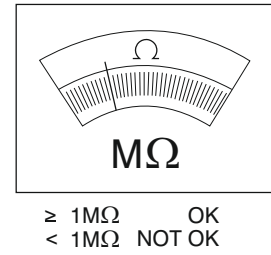
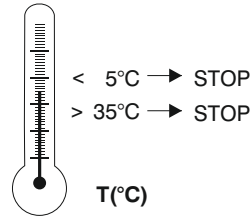
Please check the installation manual to get extra information.

►► Preparation of Joint Casting Material

Megger test must be done at joint and the result must be higher than 1mOhm

Resin (A), Hardener (B) and fillers; must be stored at least one day over ($> 20\text{ }^{\circ}\text{C}$).

Ambient temperature of job side must be $5^{\circ}\text{C} < T_{\text{amb}} < 40^{\circ}\text{C}$

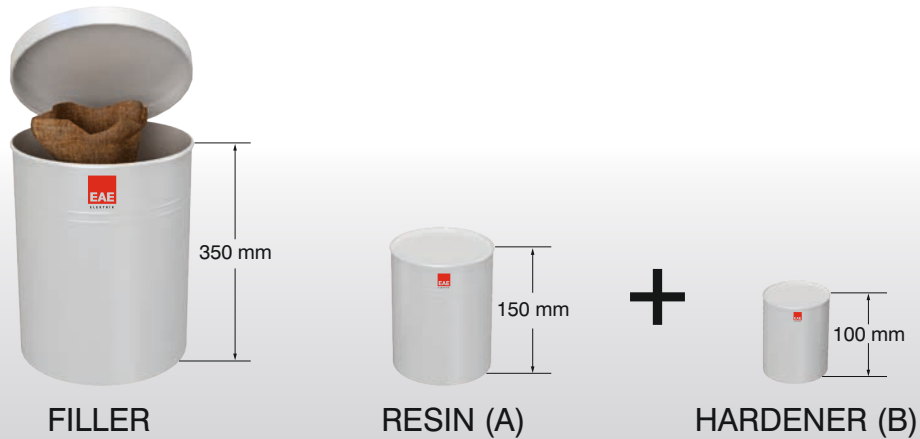


Preparation of Cast Resin Mixture

FILLER

RESIN(A)

HARDENER (B)

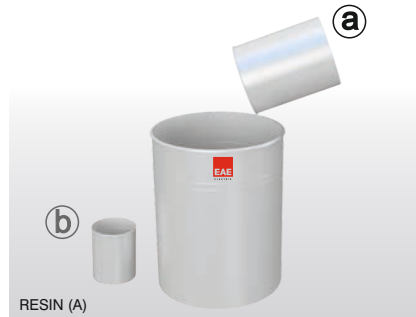


1



Filler removed from the plastic bucket and fillers have to be absolutely dry

2



Resin and hardener are mixed in plastic bucket.

3



4



Mix resin and hardener thoroughly with stirrer at least 1 minute.

5



Add fillers and mix until homogeneous; at least 5 minutes. Then application must be done within 30 minutes.

►► Casting Vertical and Horizontal Installation

Horizontal Application

- The prepared cast resin mix can be poured in once the casting mould has been fitted.
- The cast resin mix requires a setting time of 7-8 h under normal ambient conditions..
- If one bucket of resin is not enough for the joint; the second one must be prepared and applied immediately.



Vertical Application

- The prepared cast resin mix can be poured in once the casting mould has been fitted.
- The cast resin mix requires a setting time of 7-8 h under normal ambient conditions..
- If one bucket of resin is not enough for the joint; the second one must be prepared and applied immediately.



Note: In the vertical application the moulding plates should be supported from the bottom to ensure that the plates are secure.