

# Splicing Instructions for grease-filled crimps

\*Instructions for B-”Type” grease-filled crimps on back

**REQUIRED SPLICING TOOLS:**  
Utility knife, electrical tape, side cutters, sealant-filled crimps, crimping tool, wire markers

1. Securely tape together the leadwire from the cable to the corresponding leadwire from the switch. **See Figure A**

Make sure the leadwires are properly marked above the tape before splicing procedures begin.

2. Trim the leadwire ends to leave approximately six inches of each leadwire extending from the tape. **See Figure A**
3. With a utility knife, strip into the black outer leadwire casings about one inch from the ends to locate the nylon ripcord inside.
4. Pull the ripcord toward the tape, splitting the outer casing approximately four to five inches down the cable. **See figure B**

Peel back the split section of casing to expose the colored conductor wires inside. Trim off both the split casing and the ripcord.

**NOTE:** *If there are only seven conductors in the leadwire, skip to instruction number 7.*

5. The conductors are wound into matching groups of colors EXCEPT each group will have one color (center wire) not found in the others. This conductor is the constantan or “group designator” wire and identifies the group to which it belongs (white, brown, and orange groups, etc.)

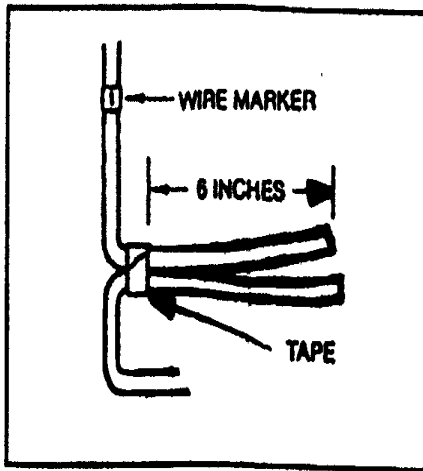


Figure A

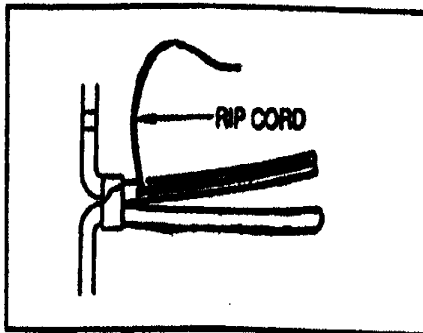


Figure B

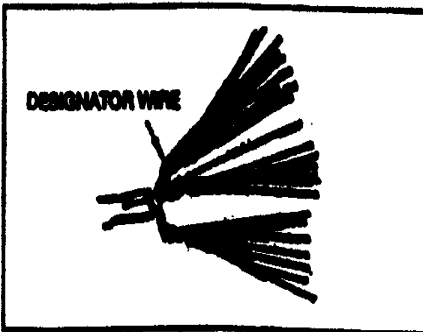


Figure C

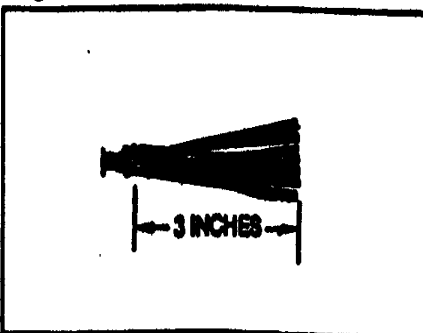


Figure D

Untwist and separate the conductors into groups according to their designator wire one group at a time.

6. Locate each designator wire and tie it around its group to make the groups easily identified. **See Figure C**

With each group identified by designator wires, the individual conductors are ready to be spliced color-to-color, group-to-group. Start by isolating two matching designator groups to avoid confusion.

7. Holding two matching groups together, first trim the colored conductors to leave about three inches extending from the cable outer casing.
8. Insert two conductors of the same color, one from the cable leadwire and one from the switch into the crimp. **See back of this sheet.**

Insert the crimp into the crimping tool, as shown, **see back of this sheet**, and squeeze the tool until it releases. Splice all the conductors color-to-color before moving to the next group or cable.

After making all splices, recheck the connections for accuracy. After all groups and cables are spliced, tape the crimped wires together.



