

# DE-ICERMAN

## Splice/Tee Connection Kit

# DSTK







## User Manual

The DSTK Connection Kit is for use with all versions of DSR-PFP & DSR-RGS heating cables for connecting cables together in a splice or Tee configuration. The kit contains materials for two splice (or tee) connection.

## TOOLS REQUIRED



## KIT CONTENT

					
Heat shrink tubes Ø6 (3.2inch/80mm) Qty 2	Heat shrink tubes Ø12 (1.2inch/30mm) Qty 6	Heat shrink tubes Ø19 (5.5inch/140mm) Qty 2	Heat shrink tubes Ø16 (4inch/100mm) Qty 2	Insulated bus wire crimp Qty 4	Uninsulated ground braid crimp Qty 4

Component approvals and performance are specifically tied to the use of De-Icerman specified parts. Do not substitute any parts.

### ATTENTION:

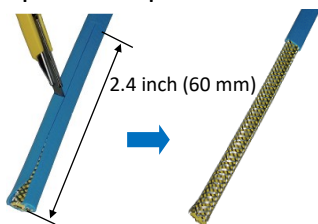
- The maximum permissible steady state Current is 30A.
- The rated voltage is 240V.
- The maximum continuous exposure temperature is 85°C.
- Temperature at the point of connection to branch circuit conductors may exceed 60 °C.

**Warning:** All heating cables shall have metal screen for working with branch circuit ground-fault protection to minimize the danger of fire if the heating cable is damaged or improperly installed.

### STEP

# 1

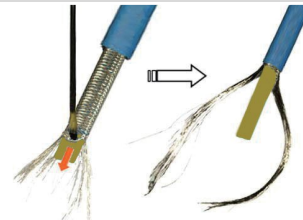
For heating cable without outer jacket, skip Step 1, and proceed to step 2.



- Slightly cut the outer jacket of the cable 2.4 inch (60mm) from the top of cable.
- Remove the outer jacket from heating cable.

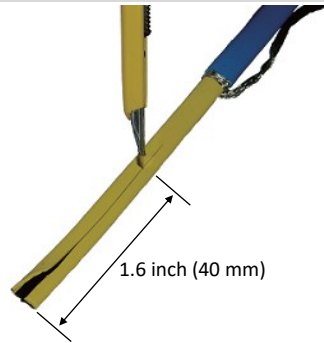
### STEP

# 2



- Unbraid the braid with a screw driver or any tapered tool from the top of cable. Do not break the braiding wires.
- Disperse the braiding wires to two strands. Align and twist the two strands of braiding wires.

### STEP 3



- Straighten and twist the two strands into one.
- Slightly cut the inner insulation of the cable 1.6 inch (40mm) from the top of cable.
- Remove inner insulation from heating cable.

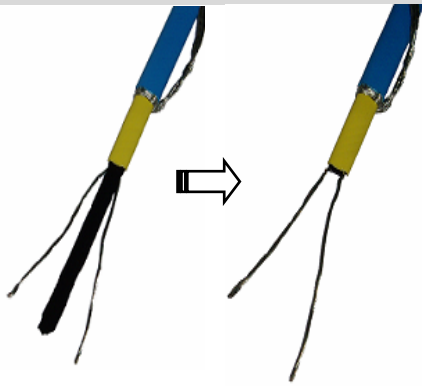
### STEP 4



- Shave the core material (Black) from the outside of each bus wire.

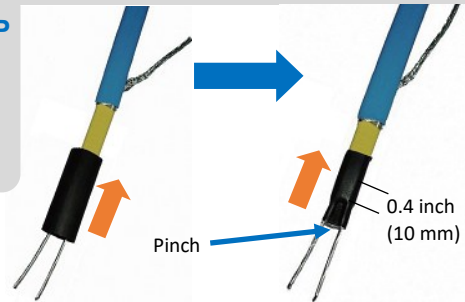
**Warning: Do not damage the bus wires.**

### STEP 5



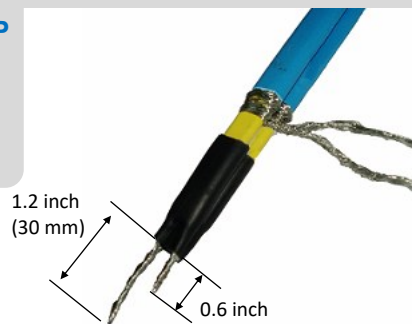
- Peel back bus wires from the core material, and remove the remaining core material.

### STEP 6



- Slide  $\text{Ø}12$  (1.2inch/30mm) shrinkable tube into place as shown.
- Heat the shrinkable tube with heat source until the glue comes out from both ends.
- Pinch the tube between two wires and hold for at least 10 seconds with pliers.
- Repeat step1 through step 6 for other heating cables.

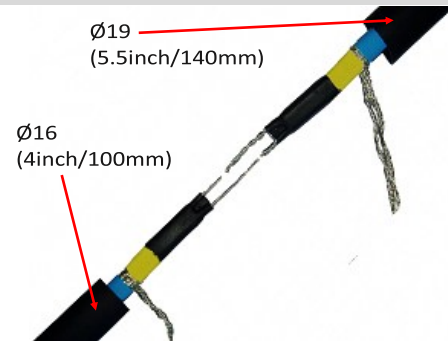
### STEP 7



- For Tee connection, two of the heating cables need to be stacked together first.
  - ▶ Skip this step, if you have only two cables for splice connection
- Before splice (or tee) connecting, cut off 0.6 in (15 mm) from one of the bus wires of all cables

**Warning: Bus wires will be shorted if they contact each other. Keep bus wires separated.**

### STEP 8



- Slide a  $\text{Ø}16$  (4inch/100mm) heat shrink tube from the single heating cable side.
- Slide  $\text{Ø}19$  (5.5inch/140mm) heat shrink tube from the two heating cables side or another heating cable
- Place grounding braids of all heating cables on the same side.

## STEP 9



- Insert both conductors into an insulated crimp terminal and clamp each set of bus wires as shown.

Crimp Tools Recommended:  
**Model:KST2000G**  
(Crimper size use : 2mm<sup>2</sup>)(K.S.T Terminals Inc.)



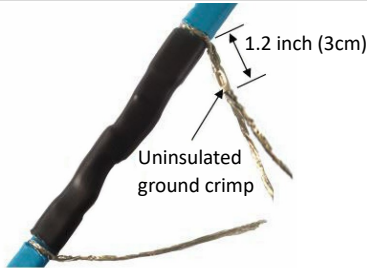
## STEP 10



- Slide the Ø16 (4inch/100mm) heat shrink tube over the connection section.
- Heat the shrinkable tubes with heat source by moving continuously from side to side.

**Warning: Shrinkable tube must wrap around only the insulation section, never cover any part of the Grounding braids.**

## STEP 11



- Combined the braids of the two stacked cables at 1.2inch (30mm) away from the edge of the outer jacket, sliding an uninsulated ground braid crimp onto them.
- Cut and discard the remaining braids, which is out from the uninsulated ground braid crimp.

Crimp Tools Recommend:  
**Model:IZUMI 5N18**  
(Crimper size use : 1.5~8mm<sup>2</sup>)(IZUMI Products Company)



## STEP 12



- Insert the longer grounding braid into the Ø6 (3.2inch/80mm) heat shrink tube.
- Connect all grounding braids from both sides with an uninsulated ground braid crimp.

## STEP 13



- Move heat shrink tube until it covers the uninsulated crimp.
- Heat the shrinkable tubes with heat source by moving continuously from side to side until the glue comes out from both ends.

## STEP 14



- Slide the Ø19 (5.5inch/140mm) heat shrink tube over the bus wire connect section.
- Heat the shrinkable tube with heat source until the glue comes out from both ends.

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