FlexNap™ Overmold Repair Guide

1. General

1.1 This procedure describes the process for repairing a FlexNap overmold closure which has a split, puncture, or gouge.

1.2 If this procedure is reissued, a summary of changes will appear in this paragraph.

2. Precautions

2.1 General Precautions

WARNING: *The wearing of* ***safety glasses*** *while performing this procedure is strongly recommended to protect the eyes from accidental injury when handling sealants and chemicals.*

2.2 Chemical Precautions

RTV Sealant

WARNING: *Avoid contact with eyes. Do not handle contact lenses with sealant on hands. IN CASE OF EYE CONTACT, immediately flush with clean water for 15 minutes and seek medical attention.*

Avoid contact with skin and clothing. Wash thoroughly after handling. IN CASE OF SKIN CONTACT: Immediately flush/wash skin with soap and plenty of water. Remove contaminated clothing and shoes.

Avoid breathing vapor. Use with adequate ventilation to reduce vapors below discomfort level. IN CASE OF BREATHING DISCOMFORT: Move to fresh air. Sealant release acetic acid (vinegar-like odor during cure.

Keep away from heat, sparks, and flame. IN CASE OF FIRE Use water spray (fog) Co2, dry chemical or foam.

Consult the product's Material Safety Data Sheet (MDS) for spill cleanup instructions.

Isopropyl Alcohol

WARNING: *Flammable. Flash point 59° F. Can cause irritation to eyes on contact. In case of eye contact, flush eyes with water for at least 15 minutes. Inhaling fumes may induce mild narcosis. In case of ingestion, consult a physician. Use with adequate ventilation.*

3. Tools and Materials

3.1 The following tools and materials are required to complete this procedure:

- Dow Corning® 737 RTV flowable sealant
- Scissors
- Side cutters (diagonal cutting pliers)
- 3M® Scotch® 130C Linerless Rubber Splicing Tape - 2 in.wide.
- 3/4-in. Scotch® 1700 vinyl electrical tape
- Sandpaper (medium grit)
- Permanent marker
- Alcohol wipes
- Tape measure
- Spatula
- Marker
- 3 ml syringe
- Syringe tip (green)

4. Repair Procedure

4.1 Before beginning a repair, carefully evaluate the extent of the closure damage. Remove any loose hanging pieces of polyurethane with side cutters. Be careful not to further damage the closure (Figure 1)

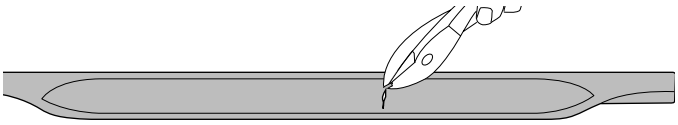

Figure 1

4.2 Measure and mark 4 inches (10 cm) from both sides of the center of the damaged area (Figure 2.

Note: *Depending on the location of the damaged area, you may prepare some of the cable jacket(s) as well as the overmold closure.*

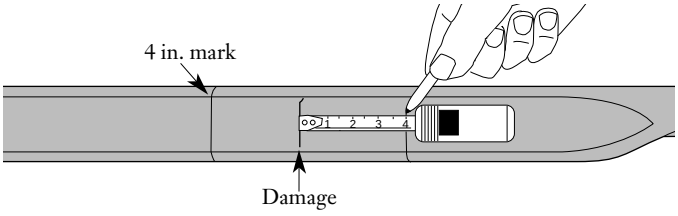

Figure 2

4.3 Carefully scuff the eight-inch area marked in Step 4.2 with a piece of medium-grit sandpaper. Take care to scuff *around* the closure, do not sand lengthwise along the closure (Figure 3

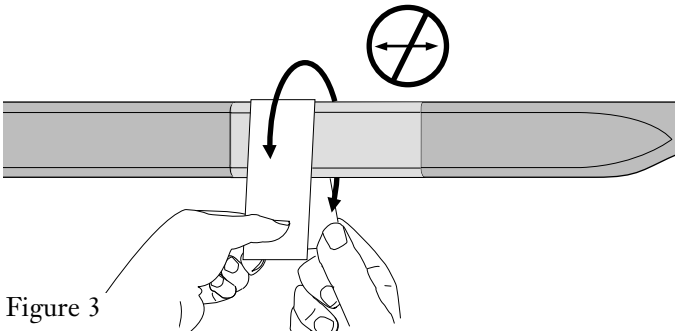

Figure 3

4.4 Using an alcohol wipe, remove as much dirt and sandpaper residue as possible from the damaged area and inside the marks made in Step 4.2 (Figure 4).

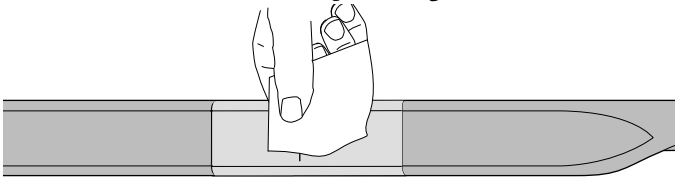

Figure 4

4.5 After ensuring that the green syringe tip is secured to the 3 ml syringe, remove the syringe's plunger and fill the syringe with enough 737 RTV sealant to seal any damage to the closure (Figure 5). Replace the plunger in the syringe.

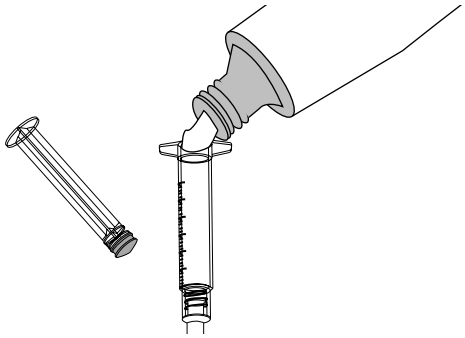

Figure 5

4.6 If the closure is split, gently bend the closure to expose the split (Figure 6). *Be careful not to inflict any further damage.*

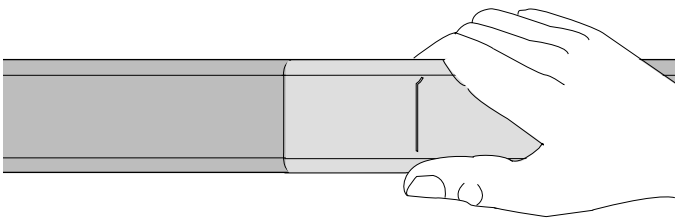

Figure 6

4.7 Insert the syringe tip into the split and fill the split with RTV (Figure 7). Relax the closure and let the excess RTV squirt out of the split. Some of the excess RTV will need to be removed with a spatula. Only leave a small bead of RTV in the split joint. Also be careful not to get RTV on overmold surfaces other than the damaged area itself (Figure 8).

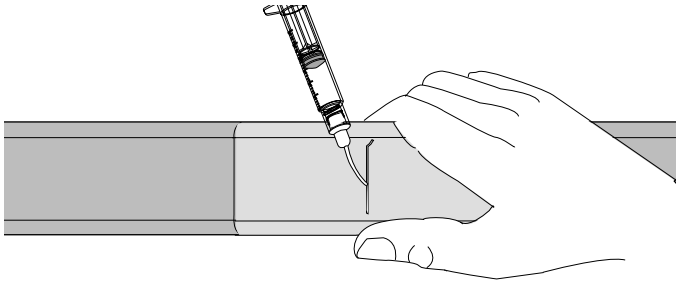

Figure 7

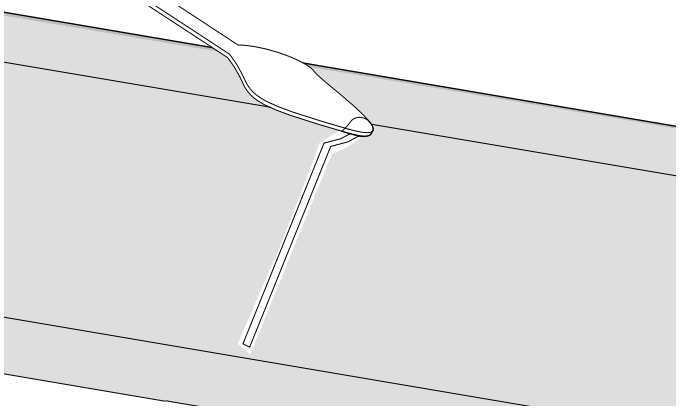

Figure 8

4.8 Let the RTV dry to a skin (usually around 10 to 15 minutes).

4.9 . If the closure has a puncture or large gouge, fill in the area with RTV to a small dome shape (Figure 9).

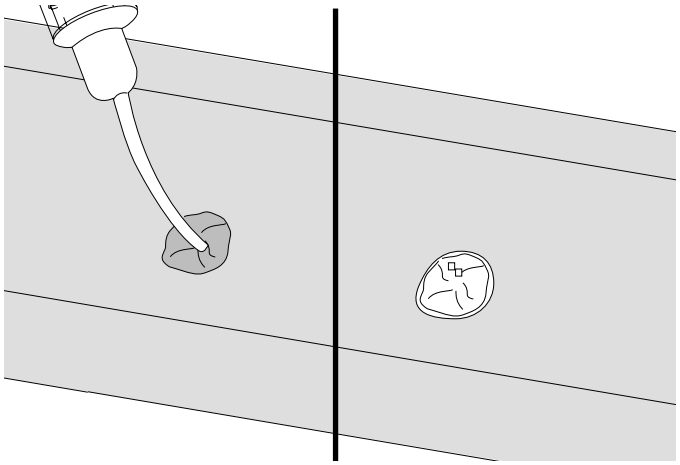

Figure 9

4.10 Again, let the RTV dry to a skin (usually around 10 to 15 minutes).

4.11 Starting at one of the 4-inch marks, firmly apply the end of the 130C splice tape to the closure. Stretching the 130C splice tape to approximately half its original size, apply a single layer of 130c tape, tacky side up, to the other mark by using a wrapping motion.

Try to achieve a smooth void-free lay of the tape and maintain a half-width overlap. Wrap the tape tightly in damaged area (Figure 10).

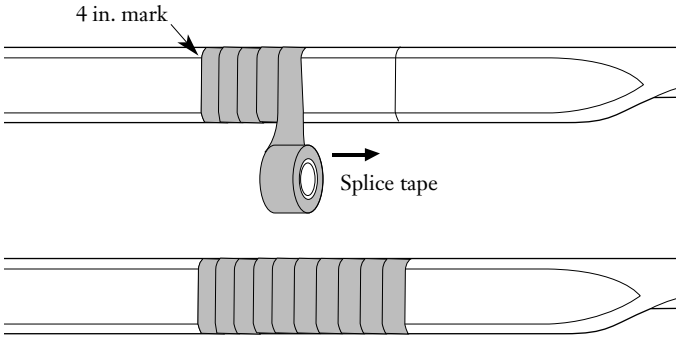

Figure 10

4.12 Starting approximately 1 inch from 130C tape, apply a double layer wrap of 3/4-inch vinyl electrical tape beginning from the end opposite the end where the wrap of 130C tape was started.

Complete one single layer first down the seam and return back wrapping in the opposite direction. Again, try to maintain a flat lay of the tape, and use a half-width overlap (Figure 11).

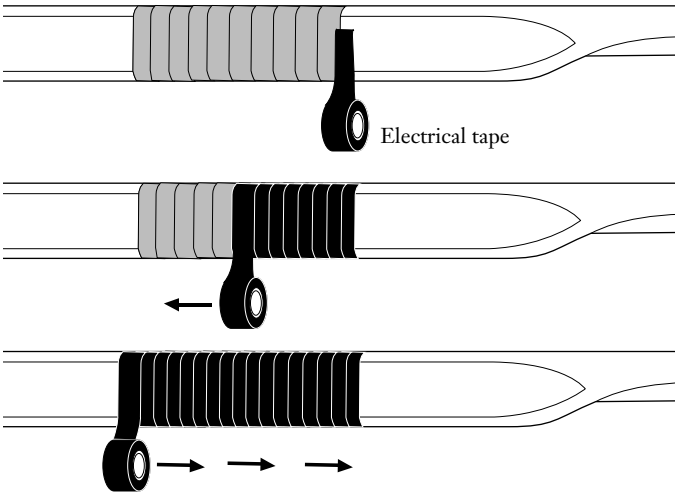

Figure 11

4.13 The closure repair is now complete.

Special Note: Fiber Optic Training Program

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Corning Cable Systems LLC
PO Box 489
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http:www.corning.com/cablesystems