

PATENT SPECIFICATION

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(54) BRANCH-OFF METHOD

(71) We, N.V. RAYCHEM S.A., a Belgian Company, of B 3200 Kessel-lo, Dieststeenweg 692, Belgium, do hereby declare the invention, for which we pray that a patent may be granted to us, and the method by which it is to be performed, to be particularly described in and by the following statement:—

This invention relates to heat-recoverable articles and their use in the formation of branch-off seals in the insulation and protection of substrates such as supply lines.

Heat-recoverable articles, especially heat-shrinkable articles, are now widely used in many areas where insulation, sealing and encapsulation are required. Usually these articles recover, on heating, towards an original shape from which they have previously been deformed, but the term "heat-recoverable", as used herein, also includes an article which, on heating, adopts a new configuration, even if it has not been previously deformed.

In their most common form, such articles comprise a heat-shrinkable sleeve made from a polymeric material exhibiting the property of elastic or plastic memory as described, for example, in U.S. Patents 2,027,962; 3,086,242 and 3,597,372. As is made clear in, for example, U.S. Patent 2,027,962, the original dimensionally heat-stable form may be a transient form in a continuous process in which, for example, an extruded tube is expanded, whilst hot, to a dimensionally heat-unstable form but, in other applications, a preformed dimensionally heat stable article is deformed to a dimensionally heat unstable form in a separate stage.

In other articles, as described, for example, in British Patent 1,440,524, an elastomeric member such as an outer tubular member is held in a stretched state by a second member, such as an inner tubular member, which, upon heating, weakens and thus allows the elastomeric member to recover.

Heat-shrinkable sleeves find many applications, especially in the connection and termination of wires, cables and pipes. However, there are other applications where it is desirable to provide a connecting, insulating

or protective heat-recoverable member for elongated objects such as cables and pipes where the ends are not accessible or, if they are accessible, where it is undesirable to disconnect or otherwise displace them. For such applications so-called "wrap-around" sleeves have been developed. Basically these are heat-recoverable sheets which can be wrapped round the substrate to form a generally tubular shape and which, in general, are provided with fastening means for holding them in the wrapped-up configuration during recovery. Typically such fastening means are mechanical in nature and comprise, for example, rigid clamps, pins or channel members which co-operate with suitably shaped moulded or extruded protuberances adjacent to the overlapping edges of the heat-recoverable sheet. Various types of fastening means are described, for example, in U.S. Patents 3,379,218 and British Patents 1,155,470; 1,211,988 and 1,346,479. In other applications, however, the sheet may be held in the wrapped-up configuration during recovery by means of an adhesive which may, in some cases, be applied on site.

Heat-recoverable sleeves and wrap-around sleeves have been successfully employed in many fields of application. However, problems may arise when two or more substrates such as supply lines, for example cables or pipes, have to be sealed at one position. This problem, which is known as "branch-off", may occur, for example, at the outlet of a heat-recoverable part. Amongst areas in which this problem is typically encountered there may especially be mentioned the outlets of the splice cases described and claimed in British Patent 1,431,167, the feed-through devices described and claimed in British Patent 1,245,119 and the duct seal devices described and claimed in British Patent Application 45725/76 (Serial No. 1594937) and corresponding German Offenlegungsschrift 2,748,894.

One effective solution for tubular sleeves has been to use moulded heat-shrinkable parts provided with preformed outlets for the individual supply lines. However, in general such moulded parts have to be made to suit a

specific application. Their versatility has been improved by the use of end caps which seal outlets which are not needed in a specific operation, as described and claimed in British Patent Application 45099/76 (Serial No. 1594693) and corresponding German Offenlegungsschrift 2,748,383, but they are nonetheless expensive and thus their use becomes economically infeasible in many routine applications.

Another, less expensive, solution which has frequently been employed is to use mastic tape to seal the gap between the supply lines so that, on recovery, a proper encapsulation is formed at the end of the heat-recoverable part. However, the use of such tape requires skill on the part of the installer and the method is not applicable to large parts. In addition, the mastic may degrade the overall performance of products which are provided with an inner lining or coating of a hot-melt adhesive.

Accordingly, the present invention provides a method of forming a branch-off seal between a heat-shrinkable sleeve and at least two substrates which comprises the steps of

(a) positioning a clip having at least two elongate legs on the heat-shrinkable sleeve at an open end thereof, with at least one of said legs inside the sleeve, so as to form at least two terminal conduits;

(b) positioning the substrates within the conduits; and

(c) applying heat so as to effect shrinkage and to form the desired seal.

It will be appreciated that steps (a) and (b) may be effected in any order or simultaneously. For example in many cases the clip will be pushed into place after the sleeve has been positioned about the substrates.

Whilst it has been proposed to use clips and other clamping devices in connection with heat-shrinkable products, it has never before been proposed to use a clip, as in the present invention, to form two or more outlets from a heat-shrinkable sleeve and maintain them against the recovery forces of the sleeve. Thus, whilst Belgian Patent 833,916 proposes to provide clips between the outlets of a splice case, it specifically states that heat-recoverable surfaces should not come into contact with each other and, for this reason, in preferred embodiments, forms the operative part of the splice case from a heat-recoverable upper part positioned on a non-heat-recoverable lower part which is provided with a ridge or finger to prevent contact of the heat-recoverable material with itself as it passes round a cable. In addition, the material of the heat-recoverable upper part is not deformed, except around the cables, so that the clips, which are positioned between the cables, do not enclose any heat-recoverable material and thus are not subjected to any recovery forces which

might tend to deform them; this is stated to be an advantage.

Similarly, whilst German Offenlegungsschrift 2,413,623 proposes to use a U-shaped clip in conjunction with a heat-recoverable branch-off, the clip is not employed until after shrinkage and is designed to be positioned over an X-shaped insert member which is positioned inside the heat-recoverable sleeve between adjacent cables.

The method of using clips in the prior art is, therefore, completely different from the method of using them in the present invention.

In one embodiment of the present invention the clip is U-shaped and its two legs are slid over the surface of the heat-recoverable sleeve or wrap-around sleeve and another co-operating surface (which may itself be part of another heat-recoverable component), respectively to form the conduits at one end of the sleeve. It is surprising that such a clip does not "milk-off" during recovery. Of course, the clip must be sufficiently long, especially if the substrates are large, but a suitable length can readily be ascertained by simple tests, and resistance against milk-off can be increased, if desired, by providing saw-tooth or sinusoidal surfaces on the legs of the clip but, in general, this will not be necessary.

Another way in which milk-off can be avoided is to apply heat to the clip and the heat-recoverable material in the vicinity thereof before effecting total recovery. This local heating step results in a local increase in thickness of the heat-recoverable material and enhances the gripping action of the clip. In addition if, as in preferred embodiments, the sleeve or wrap-around sleeve is provided with an inner coating of an adhesive, the adhesive flows and thus ensures that a satisfactory bond is formed in the vicinity of the clip prior to recovery about the substrates. Such a local heating step may advantageously be employed with all forms of clip used in the present invention.

In further preferred embodiments of the present invention, as described in more detail hereinafter, the clip itself is constructed so as to obviate the problem of milk-off and may, for this purpose, be adjustable so as to conform to the requirements of any situation.

The clip used in the present invention is advantageously made from a thermally conductive material and/or is so constructed that it facilitates the application of heat to the heat-recoverable material in its vicinity. For example, it may be constructed as described and claimed in British Patent Application No 522557/77 (Serial No. 1597470) and corresponding German Offenlegungsschrift 2756021. However, in other instances, the heat-recoverable sleeve may be provided with internal or self-contained heating

means, in which case the clip may be made from a non-thermally conductive material.

For this and other reasons the clip is preferably made from a metal including, for example, steel, copper, brass, beryllium copper and, especially, aluminium. An aluminium clip may be made, for example, by mould injection possibly followed by a deburring operation to remove sharp edges; a steel clip may be made by stamping followed, if necessary, by a similar deburring operation. In many applications it will be desirable to protect the clip against corrosion, for example, an aluminium clip is preferably given a black anodization treatment.

The significance of the function of the clip in the transference of heat to and away from the heat-recoverable material and adhesive in its vicinity is another factor not appreciated in the prior art. Thus, whilst Belgian Patent 833,016 mentions that a clip may be made from metal, it also mentions many other non-thermally conductive materials, such as plastics, which would not, in general, be suitable in the present invention, its preferred material being a glass filled polyamide. German OS 2,413,623 does not mention the material from which the clip is made.

It will be appreciated that the configuration of the clip may be varied from application to application. For example, in some applications it may be necessary to form more than two outlets at the end of the heat-recoverable component. This may be done by providing two or more simple U-shaped clips between the outlets or, in another arrangement, a single clip may be employed, such a having three or more legs so that each adjacent pair of arms acts as a simple U-shaped clip. These, and other configurations, fall within the scope of the present invention.

In one especially preferred embodiment of the present invention the clip is formed as a trident and the central leg of the trident passes into the heat-recoverable sleeve whilst at least one of the outer legs passes outside it. In this way a layer of heat-recoverable material is pinched between the central leg and the outer leg. In such a clip the inner surfaces of the outer legs preferably taper inwardly, so that the gap between the outer legs is greater at the open end of the clip than at the base of the gap. The surfaces of the central leg are also preferably tapered so that they run substantially parallel with the inner surfaces of the outer legs. Such an arrangement facilitates the positioning of the clip on the sleeve, which is especially useful for large diameter sleeves, and, once the clip is positioned in the heat-recoverable sleeve, milking-off becomes practically impossible, especially after recovery. It will be appreciated that with such a clip the inner surfaces of the heat-recoverable sleeve do not come into contact in the vicinity of the clip and the

central leg of the clip acts to separate the two conduits which are formed. For this reason the central leg is preferably provided on each side with a layer of a hot-melt adhesive or another heat-activatable sealant, which flows during recovery to seal the gap between the conduits and thus ensures that the substrates within the conduits do not come into contact.

The sides of the central leg are, therefore, preferably roughened or contoured to facilitate adhesion and, also, to ensure the adhesive remains in the area of the clip on heating. An especially preferred clip has a waffled pattern on the surfaces of the central leg.

The outer legs of the clip are preferably provided with a thermochromic indicator. The reason for this is that when heat is applied to the clip, there may be a temperature difference of as much as 20°C between the outer legs and the central leg. The use of a thermochromic indicator (such as, for example, a system using the melting of white polypropylene powder in a suitable binder) ensures that the operator applies sufficient heat to cause the hot-melt adhesive on the central leg to melt and flow.

The clip may, of course, be provided with other means for indicating that a desired temperature has been reached. For example, a resilient member such as a spring having an indicator element attached thereto, may be held in a biased position by a hot-melt adhesive so that, when the adhesive melts, the spring resiliently recovers causing the indicator element to move and thus signify that the desired temperature has been achieved.

Similarly, the clip may be provided with means for indicating that pressure seal has been safely achieved. In one preferred embodiment means are provided for indicating both that the desired temperature has been achieved and that there are no leaks in the seal at the outlet(s) of, for example, a pressurized splice case. In such an embodiment an indicator element may be held in a fixed position by a hot-melt adhesive but may be caused to move when the adhesive melts by the pressure built up inside the sealed joint; if the indicator does not move, either the adhesive has failed to melt, i.e. the required temperature has not been reached, or else the pressure has failed to reach the required level because of a leak in the seal formed on recovery. In a simple device of this sort, the hot-melt adhesive (or another thermofusible material) may itself act as the indicator, being extruded from the clip when the pressure builds up inside the joint.

Thus a clip for use in the method described above typically comprises at least two elongate legs and at least one central leg, the outer legs and the central leg forming channels for the insertion of heat-recoverable

sheet material between the outer legs and the central leg, at least part of the surface of the central leg being provided with a heat-activatable adhesive or sealant and, as described above, this part of the surface of said central leg preferably being roughened or contoured.

In certain applications, especially in the formation of branch-offs from pressurized splice cases, it may be advantageous for the inner edges of both outer legs and the edges of the central leg to lie in a mutually parallel arrangement.

However, in many applications, as described before, it will be preferable for the inner edges of the outer legs and the edges of the central leg to taper inwardly towards the closed base of the clip. Such a clip has certain advantages. First of all, the tapering of the inner edges of the outer legs and the edges of the central leg provides two sloping channels, so that when the clip is slipped on to the sleeve it is virtually locked in position. It will be appreciated, however, that once again, on shrinkage the heat-recoverable material thickens and further tightens the clip to the sleeve. Another advantage is that by correct choice of the angle defined by the outer legs and correct choice of the maximum width of the central leg, it is possible to tailor the clip to conform with the substrates. In this respect it may also be preferable for the central leg to be longer than the outer legs. In this way the required seal between the branch conduits formed is facilitated.

Once the hot-melt adhesive has flowed to fill the gap between the conduits, it will not be possible to remove the clip without causing the sleeve to become the disbonded from the substrates. Thus there is no danger of the clip slipping off and leaving the branch-off division liable to failure by peel.

It will be appreciated that such a clip may be adapted to multi-outlet branch-off arrangements

and, in some instances, it is even possible to construct a clip which is adjustable according to the direction required by the conduits. In some multi-outlet clips it may be appropriate to form the central leg as a solid or hollow generally conical member co-operating with a plurality of outer legs. Similarly, as in the simple U-clips, the base of the gaps in the trident clip may be cut away to provide extra strength, in which case the thickness of the adhesive coating must be such as to provide sufficient material to fill these gaps on recovery. A typically range of hot-melt adhesive thickness on each side of the central leg is from 2 to 5 mm, but the thickness may, if desired, be varied along the length of the leg, it being greater at the open end of the clip than at the base. As mentioned above, the surface of the central leg is preferably rough or is corrugated or waffled

to provide a seat for the adhesive and also to ensure that, on recovery, adhesive is not forced away from the central leg but, rather, is forced into the surface irregularities.

The strength of the clips used in the present invention is enhanced when they are made from flat stock, that is to say, when the width of the legs extending above and below the heat-recoverable sleeve is greater than their thickness in contact with the sleeve. Typically, the width will be from 1.5 to 3 times the thickness.

In some especially preferred embodiments of the present invention, one or more of the legs of the clip, especially the central leg, may be used to fulfil a secondary function. For example, the central leg may be hollow and act as an inlet or outlet for compressed air, as in a pressurised splice case, or for jelly, epoxy resins or foam materials, etc.. The leg may, of course, be provided with a valve for such a purpose. In some of these embodiments the leg may itself act as a substrate. For example, a branch-off may be made from a single cable using such a clip specifically to provide an inlet valve.

In other embodiments, the clip may be provided with means for ensuring that electrical continuity is maintained between, for example, shielded cables positioned within the conduits. Such means may comprise, for example, jaws or similar members positioned on one or more of the legs of the clip and adapted to receive and grip tags cut from or attached to the shielding of the cables.

Whilst, in general, it is not contemplated that the clips will be used in conjunction with other members it is possible that in some cases it may be advantageous to provide a co-operating insert member and/or to use the method of the present invention in conjunction with other methods including, for example, the mastic tape method referred to above. In certain instances it may also be advantageous to use the clip to connect the heat-recoverable sheet material to another component. For example, a plurality of clips may be used to form branch-offs around a distribution box or to form a large number of branch-offs from a single splice case by using a further heat-recoverable component such as a cap positioned internally of the heat-shrinkable sleeve. Such embodiments are explained in more detail hereinafter.

It will be appreciated that the heat-recoverable sleeve may be a wrap-around sleeve and/or may comprise a closed end, i.e. it may be an end-cap, or may be part of a larger article, for example a larger heat-recoverable article, and that, in any case, the present invention is not in any way limited to the size or configuration of the heat-recoverable component. For example, the heat-shrinkable sleeve may be formed from two (or more) sheets of heat-recoverable material. All that

is necessary for the purposes of the present invention is that the heat-shrinkable component has a hollow terminal portion within which the substrates are positioned.

5 When the clips are used in conjunction with a wrap-around sleeve it may be advantageous to form the clip so that it can co-operate with the fastening means of the wrap-around device. In some instances it
10 may even be possible to form the clip as part of said fastening means.

Whilst, the clip will be held securely in position by the heat-recoverable sleeve and, in some embodiments, may be made adjustable so that the gap between the legs can be altered according to the thickness of the sleeve so as further to facilitate the formation of a secure grip upon recovery, it may, in certain applications, be advantageous to
15 provide the clip with one or more members which co-operate with the substrates externally of the heat-recoverable sleeve so as to facilitate the correct positioning of the clip. For example a clip may be provided with a ring member which is adapted to surround a
20 pressure transducer externally of a heat-shrinkable splice case joint. In another embodiment a clip may be provided with metal straps which can be fastened around heavy cables as they leave a joint so as to provide strain relief for the joint.

The heat-recoverable material may be any of the polymers known from the art to be useful for the production of heat-recoverable
25 articles. Generally the sheet material will be of constant composition throughout; however laminates of two different polymers bonded or fused together may be used in certain instances. Amongst suitable polymers
30 there may be mentioned, for example, polyolefins, especially polyethylene, copolymers of ethylene and vinyl acetate, copolymers of ethylene and ethyl acrylate; chlorinated and fluorinated polymers, especially polyvinyl
35 chloride, polyvinylidene fluoride and polymers incorporating units from vinylidene fluoride, hexafluoroethylene and chlorotrifluoroethylene; and rubbers such as ethylene/propylene rubber, chlorinated rubbers, e.g. Neoprene, and silicone rubbers which may be
40 used in a blend with a crystalline or glassy polymer such as an olefin polymer. All of the above materials may, if desired, be cross-linked for example by irradiation and/or
45 chemical means.

As mentioned above, the internal surface of the heat-recoverable component will, in general, be provided with a coating of an adhesive or a sealant such as a hot-melt
50 adhesive or a mastic. Especially suitable hot-melt adhesives include, for example, polyamides, ethylene/vinyl acetate copolymers and terpolymers (with or without incorporated waxes) and polyesters. Such materials are
55 described, for example, in British Patent

1,440,810 and German OS 2,709,717. Also suitable are curable adhesives which melt and flow on heating but which will not afterwards be hot-meltable. There may also be mentioned epoxy resins and conventional
60 mastics such, for example, as these based on butyl and isobutylene rubbers modified with suitable materials known in the art. Obviously the use or otherwise of such materials and their type, if chosen, will depend upon the particular requirements in any given case.

In most applications the force exerted on the clip will lie in the range of from 5 to 15 kg, depending on the diameter of the substrate and the wall thickness and the degree of unresolved recovery of the sleeve. It will be appreciated in this latter respect that, as compared with the mastic tape method, the heat-recoverable sleeve will be required to
65 shrink less and, therefore, have a smaller expansion ratio, because the clip forces the sleeve to conform to the circumstances of the cables in the central region, whereas in the mastic tape method the sleeve does not come into contact with the cables in this region. Of course, the degree of expansion required for the sleeve is lower when a trident clip is used than when a simple U-clip is employed.

It will be appreciated that the present invention provides a very simple method of making a satisfactory branch-off, thus removing any need for skillful installation and providing a consequent decrease in cost. The elongate legs of the clip ensure that a seal is formed from the edge of the heat-recoverable materials to the ends of said legs, thereby satisfactorily separating the substrates throughout that region.

Various embodiments of the present invention will now be described, by way of example only, with reference to the accompanying drawings, in which (figures 1 to 6 being absent)

Figure 7 shows a preferred form of trident clip of use in the present invention;

Figure 8 shows the use of the trident clip in forming a branch-off;

Figure 9a and 9b show a modified trident clip designed to form a 3-way branch-off;

Figure 10 illustrates a further modification for forming an asymmetric branch-off;

Figure 11 illustrates a clip for forming a 4-way branch-off;

Figure 12 illustrates a clip forming an 8-way branch-off;

Figures 13a and 13b illustrate an adaptable clip for forming a 3-way branch-off;

Figures 14a and 14b illustrate a clip which can act as an inlet valve;

Figures 15a and 15b illustrate the use of a clip to provide a branch-off for an inlet or outlet valve;

Figures 16a and 16b show a preferred form of trident clip;

Figures 17a to 17e show the use of a further form of clip in conjunction with a heat-recoverable sleeve and a distribution box to form a multi-outlet termination;

5 Figures 18a to 18c show a somewhat similar multi-outlet termination;

Figure 19 shows a clip provided with a temperature indication device;

10 Figures 20a to 20c show a clip provided with a combined pressure and temperature indication device;

Figures 21a to 21c illustrate the use of a clip provided with means for facilitating electrical continuity;

15 Figures 22a and 22b show a clip suitable for use with a pressure transducer;

Figures 23a and 23b show a clip designed to provide strain relief to a formed joint;

20 Figures 24a and 24b show a self-adjusting clip for use in the present invention; and

Figure 25 shows a further form of clip for use with a pressurized splice case joint.

Referring now to the drawings, in Figure 7 there is shown a trident clip 31 for use in the present invention. The inner surfaces of the outer legs 32 and 33 and the surfaces of the central leg 34 are tapered so as to define an angle α . The surfaces of the outer legs and the central leg run substantially parallel to form two sloping channels 35 and 36, each of which is cut away at the bottom for increased strength by stress distribution.

30 The central leg 34 is provided on each side with a hot-melt coating 37 and the surfaces of the outer legs are provided with a coating 38 of a thermochromic indicator.

40 Typical dimensions for the clip are as follows: thickness, 5mm; width of central leg, 11mm decreasing to 5.5mm; gap between legs, 1 to 2mm according to sleeve material wall thickness.

45 Figure 8 shows the clip 31 in position on a heat-shrinkable sleeve 39 to form two branch-off conduits 40 and 41. As can be seen, in the recovered position, the central leg 34 forms a separating barrier between the conduits.

50 Figures 9a and 9b show an adapted trident clip 42 designed to form a three-way branch-off, the central leg 43 being formed as a part of Y-shaped cross-section.

Figures 10, 11 and 12 show various clips 44, 45 and 46, respectively, for forming other multi-outlet branch-offs.

55 Figures 13a and 13b show an adjustable three-way branch-off clip. In this clip two of the outer legs 47 and 48 are rotatably mounted on an extended part of the inner leg 49, whereas outer leg 50 is fixed to said inner leg 49. Such a clip can be adjusted according to the nature of the branch-off required.

60 In Figure 14a there is shown the use of a trident clip 51 to provide an inlet for pressurised air within a cable splice 52. In this embodiment, as shown in Figure 14b, the

central leg 53 of the trident clip 51 is hollow and is provided with a valve 54 and an inlet duct 55. The central leg 53 of the clip 51 acts as a substrate in the branch-off from cable 56.

70 In Figure 15a there is shown how trident clips 57 and 58 may be employed with a wrap-around splice 59 to form a branch-off inlet and outlet at the ends thereof. In this case the inlet and outlet are provided with separate devices 60 and 61 (as shown in Figure 15b) which form the substrates in the branch-off from cables 62 and 63, respectively.

80 Figures 16a and 16b show a further form of preferred trident clip 64 for use in the present invention. This clip 64 has the preferred features that the central leg 65 extends beyond the ends of the outer legs 66 and 67 and that the side surfaces of the central leg 65 are waffled to provide a suitable base for adhesive, as discussed previously.

85 In Figures 17a to 17e there is shown how the present invention may be employed to form branch outlets from a heat-recoverable sleeve and a further co-operating component.

90 In Figure 17a there is shown a distribution box 68 provided on its external surfaces with hot-melt adhesive 69. This distribution box is designed to distribute pairs of cables from a large incoming cable to a large number of outgoing smaller cables.

95 The adhesive coatings 69 are pre-cut to remove strips which are slightly wider than the thickness of the clips 70 (as shown in Figure 17b). The box 68 is then inserted within a large diameter heat-recoverable sleeve 71 and the outgoing cables 72 are arranged around the surface of the distribution box 68. As is shown in Figures 17c and 17d the clips 70 are then positioned between the cables 72 and over the external surface of the heat-recoverable sleeve 71 and the internal surface of the distribution box 68. The assembly so produced may then be heated to cause recovery of sleeve 71 and flow of the adhesive 69 to produce the completed distribution box shown in Figure 17e. As indicated, some of the branch-offs may be occupied by devices 73 provided with caps 74 for future use.

100 The distribution box 68, preferably made from a strong thermally conductive metal, may be provided with grooves on its internal surface to assist location of the clips. The heat-recoverable sleeve 71 may, of course, be a wrap-around sleeve and may be internally coated to reduce water vapour penetration. At its other end it is shrunk about the large incoming cable 75.

105 The box 68 may have different geometries such as circular, elliptical, star-shape etc. and various different forms of clip 70 may be used.

Figures 18a to 18c show a somewhat similar multi-outlet branch-off arrangement for use with a pressurized splice case. As shown in Figure 18a the splice case 80, which may be formed from two metal half shells, is protected and insulated by a wrap-around heat-shrinkable sleeve 81 provided with a conventional fastening means 82. Ingoing cable 83 is to be spliced to form four outlet cables 84 and, in accordance with the invention, a seal is formed at the inlet using a trident clip 85 which provides a conduit for a pressure valve 86. The seal at the inlet is formed as described previously. At the outlet there is provided a heat-shrinkable cap 87 which has a hot melt adhesive coating on its external surface. As shown, the cap is provided with four trident clips 88 in accordance with the present invention. The cap 87 and the clips 88 co-operate with the outlet end of heat-shrinkable sleeve 81 and the arrangement before recovery is shown in Figure 18b. It will be seen that the cap, the sleeves and the clips between them form four conduits for the outgoing cables 84. When the assembly shown in Figure 18b is complete the heat-recoverable sleeve 81 is caused to shrink by using a conventional torch and the heat-shrinkable cap 87 is preferably caused to shrink by means of a so-called "hot pack", i.e. a pyrotechnic type heating device, which is pre-installed within it. The recovered assembly is shown in Figure 18c.

Such an arrangement is especially useful in the formation of multi-outlet branch-offs from pressurized splice cases where the expansion rate of the heat-recoverable sleeve is kept as low as possible, usually at about 1.3 in order to keep the wall thickness of the sleeve to a maximum and to reduce unresolved recovery to a minimum, thereby obviating the rupture of the sleeve under pressure.

In Figure 19 there is shown a trident clip, the central leg 91 of which is provided with a temperature indication device, which comprises an indicator rod 92 positioned within the leg 91 and a load spring 93 which is held in compression within chamber 94 by being embedded in a thermofusible material (not shown). When the desired temperature is reached the thermofusible material melts and the spring 91 recovers resiliently to move the rod 92 to the position shown by the dotted lines, thus indicating that the desired temperature has been reached.

Figures 20a to 20c show a clip 100 which is provided with means for indicating that both a desired temperature and a desired pressure have been attained within heat-shrinkable sleeve 101. As shown in Figure 20b the central leg 102 of clip 100 is provided with a chamber 103 in which is positioned a ball valve 104. Also positioned within chamber 103 and in a channel 105 which connects the

chamber to the closed end of the clip 100 is a thermofusible material 106.

The positioning of the clip 100 within a pressurized splice case joint 107 is shown in Figure 20c. When the desired temperature is reached the thermofusible material 106 melts and, provided that a correct seal is achieved, the pressure within the joint 107 causes the ball valve 104 to move along the chamber 103 thereby forcing a volume of molten thermofusible material out from the end of the clip, the volume extruded being approximately equal to the volume originally positioned in chamber 103. The operator can thus be sure not only that has the correct temperature been reached but also that there are no leaks in the seal formed at the joint.

Figures 21a to 21c show a trident clip 110, the central leg of which is provided on each side with jaw members 111. These are designed to accommodate and grip strips 112 cut from the aluminium shielding foil of telecommunication cables 113, as shown in Figure 21c, and thus ensure electrical continuity between the cables 113 and electrical bond line 114 which is attached to the central leg of clip 110.

Figures 22a and 22b show a further form of clip 116 and its use in the formation of a joint at the end of a pressurized splice case provided with a pressure transducer. As shown, the clip 116 is provided with a locating ring 117 which is designed to fit around the pressure transducer container 118. If desired, the ring 117 could be formed as a cap for the container 118.

Figures 23a and 23b show trident clip 120 which is provided with two straps 121 and 122 which are designed to be fastened around cables 123 and 124, respectively, as they leave a splice joint 125. This arrangement not only serves properly to locate the cables and the clip at the joint, but also provides strain relief to the system and ensures that movement of the cables externally of the joint does not cause damage. It is, therefore, especially appropriate for use with heavy duty cables or service pipes, etc..

In Figures 24a and 24b there is shown clip 130 which is designed so as to be self-adjusting in that the gaps between the central leg 131 of the external legs 132 and 133 may vary according to the thickness of the heat-recoverable sleeve. For this purpose the central leg 131 is constructed from two parts, a U-shaped member 135 being slidably mounted on a central member 136 and, initially, held in an extended position against the force of a tension spring 137, the whole assembly being embedded in a hot-melt adhesive 138 to prevent recovery of the tension spring. When, in operation, clip 130 is heated the hot-melt adhesive 138 fuses and the tension spring recovers causing the U-shaped member 135 to move along the

central member 136 towards the base of the clip, as shown by the dotted lines. In doing so the gap between the legs is reduced, thereby ensuring that the heat-recoverable sleeve material positioned therein is firmly gripped.

Finally, Figure 25 shows a further form of clip 140 for use with pressurized splice cases. As shown this clip 140 has three legs of equal length which will, in general, be longer than the clip shown, for example, in Figure 5. In addition, the width of the central leg 141 is constant throughout its length and is kept as small as practicable, e.g. at about 5mm, in order to facilitate the formation of a good seal between the heat-recoverable sleeve and the cables in the vicinity of the clip. Both sides of central leg 141 are provided with a layer of a hot-melt adhesive.

Other modifications falling within the scope of the present invention will be apparent to those skilled in the art.

Attention is drawn to our co-pending Application No. 631/78 (Serial No. 1604981) from which this Application has been divided and to Application No. 8105180 (Serial No. 1597470) which has also been divided from Application No. 631/78.

Attention is also drawn to our co-pending Application No. 79.11714, (Serial No. 2,019,120).

WHAT WE CLAIM IS:—

1. A method of forming a branch-off seal between a heat-shrinkable sleeve and at least two substrates, which comprises the steps of

(a) positioning a clip having at least two elongate legs on the heat-shrinkable sleeve at an open end thereof, with at least one of said legs inside the sleeve, so as to form at least two terminal conduits;

(b) positioning the substrates within the conduits; and

(c) applying heat so as to effect shrinkage and to form the desired seal.

2. A method as claimed in claim 1, wherein the heat-shrinkable sleeve is an integral tubular sleeve.

3. A method as claimed in claim 1, wherein the heat-shrinkable sleeve is a wrap-around sleeve.

4. A method as claimed in any one of claims 1 to 3, wherein the heat-shrinkable sleeve is provided with an inner coating of a heat-activatable adhesive or sealant.

5. A method as claimed in any one of claims 1 to 4, wherein the conduits are formed by the clip pinching a layer of the heat-shrinkable sleeve to another substrate.

6. A method as claimed in claim 5, wherein said substrate is a distribution box.

7. A method as claimed in claim 5, wherein said substrate is another heat-recoverable component.

8. A method as claimed in claim 7, wherein the heat recoverable component is a

heat-shrinkable cap.

9. A method as claimed in any one of claims 1 to 8, wherein the clip fulfils a secondary function.

10. A method as claimed in any one of claims 1 to 9, wherein the clip is provided with means for indicating that a desired temperature has been reached during step (c).

11. A method as claimed in claim 10, wherein the clip is provided with a thermochromic indicator.

12. A method as claimed in claim 10, wherein the clip is provided with a temperature indication device comprising a thermofusible material which, when it melts, enables an indicator element to move and signify the attainment of the desired temperature.

13. A method as claimed in any one of claims 1 to 12, wherein the clip is provided with means for indicating that a desired level has been attained within the joint formed between the heat-shrinkable sleeve and the substrates.

14. A method as claimed in any one of claims 1 to 13, wherein the clip is provided with means for ensuring electrical continuity between the substrates.

15. A method as claimed in any one of claims 1 to 14, wherein the clip is provided with means for providing strain relief to the joint formed between the heat-shrinkable sleeve and the substrates.

16. A method as claimed in claim 15, wherein said means comprises members which grip and/or locate the substrate(s) externally of the joint.

17. A method as claimed in any one of claims 1 to 16, wherein part of the clip forms one of the substrates.

18. A method as claimed in any one of claims 1 to 17, wherein the assembly formed in steps (a) and (b) is heated locally in the vicinity of the clip in order to facilitate proper positioning of the clip during recovery in step (c).

19. A method as claimed in any one of claims 1 to 18, wherein one clip is used to form three or more terminal conduits.

20. A method as claimed in any one of claims 1 to 19, wherein two or more clips are used to form a multi-outlet branch-off.

21. A method as claimed in any one of claims 1 to 20, wherein the clip is provided with means so that it may be adjusted according to the thickness of the heat-shrinkable sleeve.

22. A method as claimed in claim 21, wherein the clip is self-adjusting.

23. A method as claimed in claim 22, wherein the gap between the legs of the clip is variable and regulated by a resilient member.

24. A method as claimed in claim 23,



central member 136 towards the base of the clip, as shown by the dotted lines. In doing so the gap between the legs is reduced, thereby ensuring that the heat-recoverable sleeve material positioned therein is firmly gripped.

5 Finally, Figure 25 shows a further form of clip 140 for use with pressurized splice cases. As shown this clip 140 has three legs of equal length which will, in general, be longer than
10 the clip shown, for example, in Figure 5. In addition, the width of the central leg 141 is constant throughout its length and is kept as small as practicable, e.g. at about 5mm, in order to facilitate the formation of a good
15 seal between the heat-recoverable sleeve and the cables in the vicinity of the clip. Both sides of central leg 141 are provided with a layer of a hot-melt adhesive.

20 Other modifications falling within the scope of the present invention will be apparent to those skilled in the art.

25 Attention is drawn to our co-pending Application No. 631/78 (Serial No. 1604981) from which this Application has been divided and to Application No. 8105180 (Serial No. 1597470) which has also been divided from Application No. 631/78.

30 Attention is also drawn to our co-pending Application No. 79.11714, (Serial No. 2,019,120).

WHAT WE CLAIM IS:—

1. A method of forming a branch-off seal between a heat-shrinkable sleeve and at least
35 two substrates, which comprises the steps of

(a) positioning a clip having at least two elongate legs on the heat-shrinkable sleeve at an open end thereof, with at least one of said legs inside the sleeve, so as to form at least
40 two terminal conduits;

(b) positioning the substrates within the conduits; and

(c) applying heat so as to effect shrinkage and to form the desired seal.

45 2. A method as claimed in claim 1, wherein the heat-shrinkable sleeve is an integral tubular sleeve.

50 3. A method as claimed in claim 1, wherein the heat-shrinkable sleeve is a wrap-around sleeve.

4. A method as claimed in any one of claims 1 to 3, wherein the heat-shrinkable sleeve is provided with an inner coating of a heat-activatable adhesive or sealant.

55 5. A method as claimed in any one of claims 1 to 4, wherein the conduits are formed by the clip pinching a layer of the heat-shrinkable sleeve to another substrate.

60 6. A method as claimed in claim 5, wherein said substrate is a distribution box.

7. A method as claimed in claim 5, wherein said substrate is another heat-recoverable component.

65 8. A method as claimed in claim 7, wherein the heat recoverable component is a

heat-shrinkable cap.

9. A method as claimed in any one of claims 1 to 8, wherein the clip fulfils a secondary function.

10. A method as claimed in any one of claims 1 to 9, wherein the clip is provided with means for indicating that a desired temperature has been reached during step (c).

11. A method as claimed in claim 10, wherein the clip is provided with a thermochromic indicator.

12. A method as claimed in claim 10, wherein the clip is provided with a temperature indication device comprising a thermofusible material which, when it melts, enables an indicator element to move and signify the attainment of the desired temperature.

13. A method as claimed in any one of claims 1 to 12, wherein the clip is provided with means for indicating that a desired level has been attained within the joint formed between the heat-shrinkable sleeve and the substrates.

14. A method as claimed in any one of claims 1 to 13, wherein the clip is provided with means for ensuring electrical continuity between the substrates.

15. A method as claimed in any one of claims 1 to 14, wherein the clip is provided with means for providing strain relief to the joint formed between the heat-shrinkable sleeve and the substrates.

16. A method as claimed in claim 15, wherein said means comprises members which grip and/or locate the substrate(s) externally of the joint.

17. A method as claimed in any one of claims 1 to 16, wherein part of the clip forms one of the substrates.

18. A method as claimed in any one of claims 1 to 17, wherein the assembly formed in steps (a) and (b) is heated locally in the vicinity of the clip in order to facilitate proper positioning of the clip during recovery in step (c).

19. A method as claimed in any one of claims 1 to 18, wherein one clip is used to form three or more terminal conduits.

20. A method as claimed in any one of claims 1 to 19, wherein two or more clips are used to form a multi-outlet branch-off.

21. A method as claimed in any one of claims 1 to 20, wherein the clip is provided with means so that it may be adjusted according to the thickness of the heat-shrinkable sleeve.

22. A method as claimed in claim 21, wherein the clip is self-adjusting.

23. A method as claimed in claim 22, wherein the gap between the legs of the clip is variable and regulated by a resilient member.

24. A method as claimed in claim 23,



wherein the resilient member is initially embedded in a thermofusible material so as to render it inoperative prior to heating in step (c).

- 5 25. A method as claimed in any one of claims 1 to 24, wherein the clip is made from a thermally conductive material.

26. A method as claimed in claim 25, wherein the clip is made from aluminium.

- 10 27. A method as claimed in claim 25, wherein the clip is made from steel or beryllium copper.

- 15 28. A method as claimed in any one of claims 1 to 27, wherein the leg or legs of the clip positioned inside the sleeve is (are) provided with a heat-activatable adhesive or sealant thereon.

29. A method as claimed in any one of claims 1 to 28, wherein the clip is a U-clip.

- 20 30. A method as claimed in claim 29, wherein the inner edges of the legs of the clip are serrated or are sinusoidally shaped.

- 25 31. A method as claimed in claim 1, substantially as described herein with reference to Figures 7 to 17 of the drawings.

32. A method as claimed in claim 1, substantially as described herein with reference to Figures 18 to 25 of the drawings.

- 30 33. A branch-off joint whenever made by a method as claimed in any one of claims 1 to 32.

- 35 34. An assembly which comprises a heat-shrinkable sleeve having at least two substrates emerging from an end thereof and a clip having at least two elongate legs positioned on the sleeve so as to form two conduits for said substrates, one of said legs being positioned within the sleeve.

- 40 35. An assembly as claimed in claim 34, which comprises one or more of the features specified in any one of the claims 2 to 30.

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