



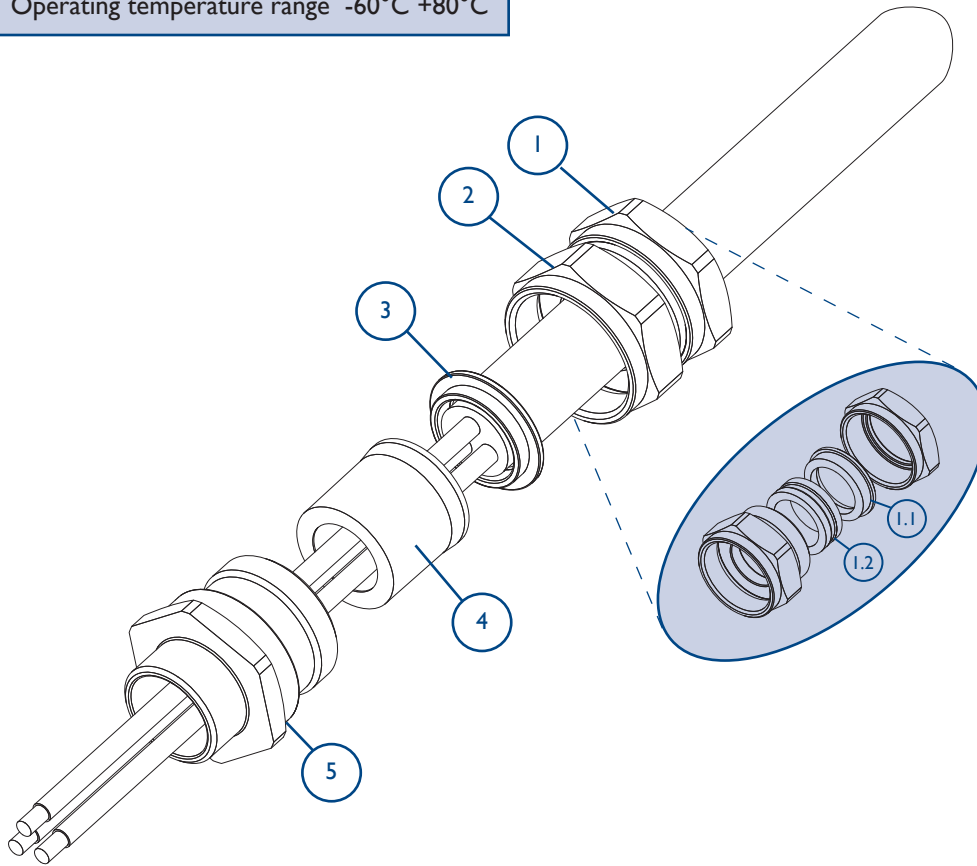
# Assembly Instructions for cable gland: ICG 623 Exd IIC/Exe II ExtD 623 Exd I/Exe I

Operating temperature range -60°C +80°C

### Certification Details

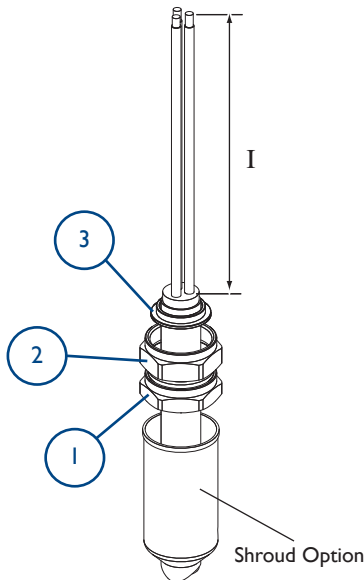
Gland Type: ICG 623 Exd IIC/Exe II/ExtD  
Baseefa06ATEX0058X  II 2 GD A21 IP66 CE  
IECEX BAS06.0015X  
CEPEL-EX-064/2001X  
GOST R No: POCC GB.ГБ05.01831  
CSA No: 1024328 (LR 78713-9)  
CNEEx07.0896X

Gland Type: 623 Exd I/Exe I  
Baseefa08ATEX0329X  IM 2 IP66 CE  
IECEX BAS08.0115X



1. Backnut
- 1.1 Rear Compression Spigot
- 1.2 Rear Seal
2. Middle Nut
3. Pot Cap
4. Rubber Pot
5. Entry

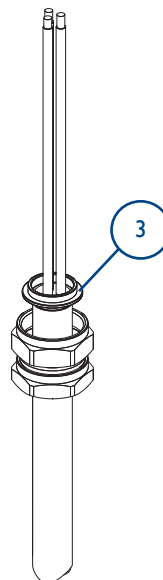
### Cable Preparation



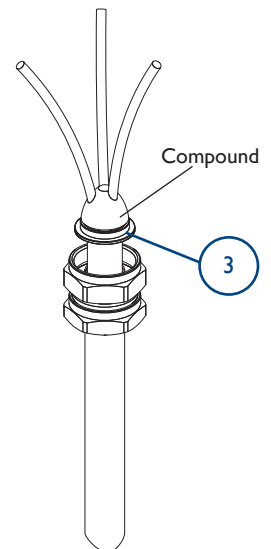
**A**  
Strip Cable to suit equipment as shown above, removing all cable fillers.  
Length I to suit equipment.  
If required, fit shroud.

See Notes re. Drain Wires.

### Gland Preparation

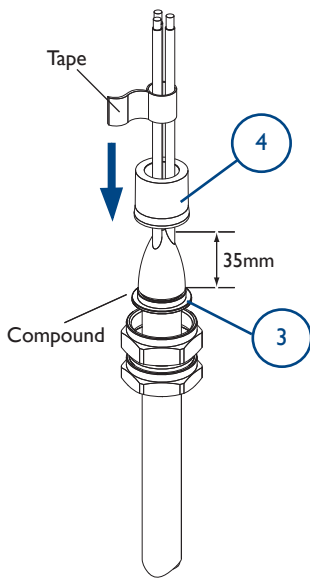


**B**  
Position rear of pot cap ③ level with prepared face of cable insulation, ensuring that the cap remains concentric to cable at all times.



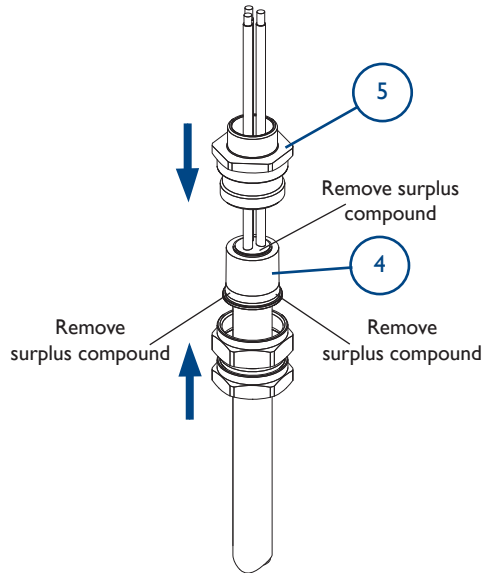
**C**  
Spread the cable cores out for the compound packing. Pack the compound between the cores as shown.

See notes overleaf and Fig. 7 for compound preparation.



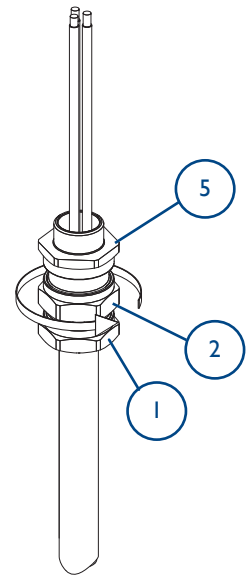
**D**

With all gaps and voids filled, bring the conductors back together and pack more compound around the outside of the conductors. Tape the conductors together to prevent disturbance of the compound seal. Pass the rubber pot ④ over pot cap ③ and remove any surplus compound from the top of rubber pot ④ and joint faces as indicated.



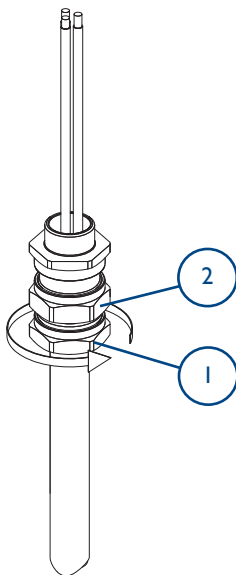
**E**

Replace the entry ⑤ over the rubber pot ④ ensuring that compound does not cover end of rubber pot ④



**F**

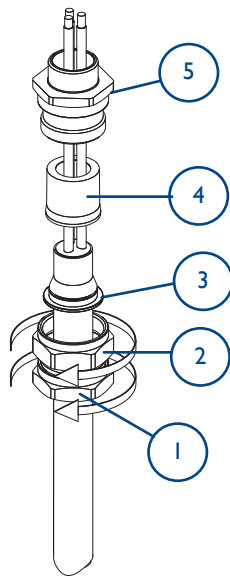
Locate and hand tighten the sub-assembly ① and ② to the entry ⑤.



**G**

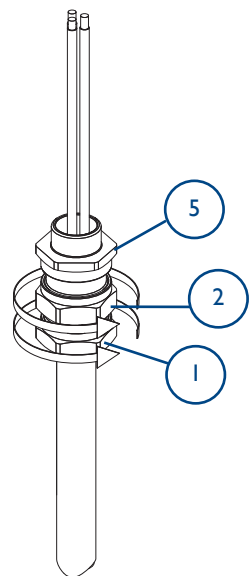
To further locate and support the compound and rubber pot assembly, while holding the middle nut ② with a spanner/wrench, tighten the backnut ① until the seal grips the cable to prevent movement of the cable gland.

**IMPORTANT NOTE: The conductors must not be moved for a minimum of four hours.**



**H**

Allow the compound to cure. (See Fig. 7 for Curing Times). Untighten firstly the backnut ① from ② and secondly the middle nut ② from the entry ⑤. The rubber pot ④ may be removed for inspection to ensure that the packing is satisfactory. Add further compound if necessary.



**I**

Re-assemble rubber pot ④ and the entry ⑤. Hand tighten the sub-assembly ① and ② to the entry ⑤ and add half a turn to ② with a spanner/wrench. Tighten the backnut ① to form a seal around the cable, then tighten a further half to three quarters of a turn using a spanner/wrench. Ensure that the middle nut ② does not rotate when tightening the backnut ①. Locate the shroud over the cable gland if applicable.

## EPOXY COMPOUND PREPARATION

When handling this material, the gloves supplied must be worn. The epoxy compound is supplied in the form of a two part package. These should be mixed into the ratio of 1:1 until both colours have blended into one, without any streaks. Rolling and folding is the most satisfactory method of obtaining an even blend. Once mixed, the compound must be used within 30 minutes. After this time it will begin to stiffen. The compound should be kept at an ambient temperature of no less than 20°C prior to using. At lower temperatures it becomes difficult to mix. Should any compound come into contact with the skin it should be cleaned off with skin cleaner and not allowed to dry on the skin. Only compound for immediate terminations should be mixed.

The mixing and installation of the compound at an ambient temperature below 4°C is not recommended due to extended curing period

**The following instructions are the various BASEEFA approved methods of passing drain wires etc. through the compound barrier and should be followed if permitted by cable installation specifications.**

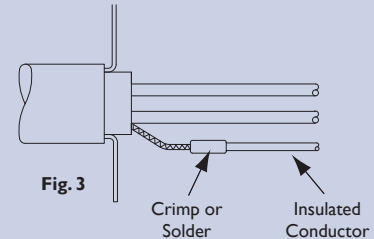
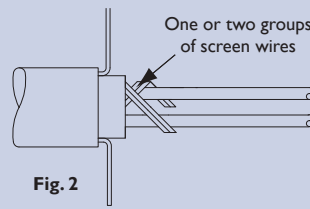
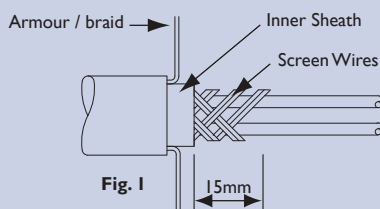
### DRAIN WIRE PREPARATION

#### 1.0 INSULATING DRAIN WIRES WITH HEAT SHRINK OR COLD SHRINK TUBING

- 1.1 Fold back the armour / braid and bend it to right angles from the inner sheath.
- 1.2 Remove foils and tape level with the outer sheath, exposing the drain wires and insulated conductors. Cut back a further 10mm of inner sheath.
- 1.3 Pass 100mm length of heat shrink or cold shrink tubing over the drain wire until it comes into contact with the foils, then shrink the tubing evenly down onto the drain wire so that no air pockets occur.
- 1.4 To insulate the joint between the foils and the tubing a suitable piece of 10mm long shrink tubing or neoprene stretch tubing or a 10mm wide lap of PVC tape may be used.
- 1.5 After completing 1.1 to 1.4 on each drain wire, lay the armour / braid parallel to the cable, if applicable, then carry out instruction B.

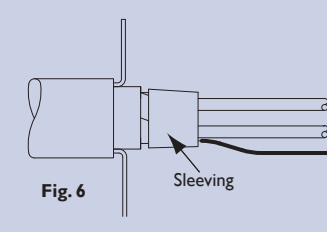
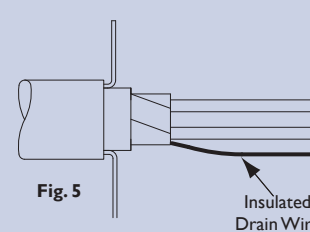
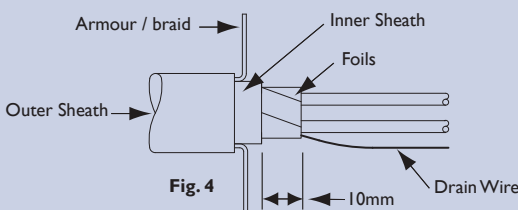
#### 2.0 INSULATING DRAIN WIRES / SCREENS WITH SEPARATE INSULATED CRIMPED CONDUCTORS OR SOLDERED CONNECTION

- 2.1 Fold back the armour / braid and bend to right angles from the inner sheath.
- 2.2 Remove a further 15mm of inner sheath (See Fig. 1).
- 2.3 Unravel one or two groups of wires from the screen wires, then remove the remainder of the screen wires (See Fig. 2).
- 2.4 Twist the group of screen wires into a pigtail and cut to 15mm long.
- 2.5 Crimp an insulated conductor to the pigtail with a suitable insulated butt ferrule (or soldered connection), leaving enough length of the insulated conductor to enable the remote end to be connected to the earth terminal in the equipment. (See Fig. 3). Note: There shall be a minimum of 10mm of compound on both ends of the crimped / soldered joint.
- 2.6 To insulate the joint between the screen wires and the insulated conductor, place one lap of PVC insulating tape over the exposed metallic joint.
- 2.7 After completing 2.1 to 2.6 on each drain wire, lay the armour / braid parallel to the cable. Then carry out instruction B.



#### 3.0 INSULATING DRAIN WIRES WITH INSULATING VARNISH OR PAINT

- 3.1 Fold back the armour / braid and bend it at right angles from the inner sheath.
- 3.2 Remove the foil and tape level with the inner sheath exposing the drain wires and conductor pairs.
- 3.3 Cut back a further 10mm of inner sheath (See Fig. 4).
- 3.4 Spray or paint the drain wires with insulating varnish or paint, then leave to dry (See Fig. 5)
- 3.5 To insulate the foil ends a suitable piece of 10mm long shrink tubing or neoprene stretch tubing or a 10mm wide lap of PVC tape may be used (See Fig. 6).
- 3.6 After completing 3.1 to 3.5 on each drain wire, lay the armour / braid parallel to the cable. Then carry out instruction B.



### Epoxy Compound Cure Time Vs. Temperature

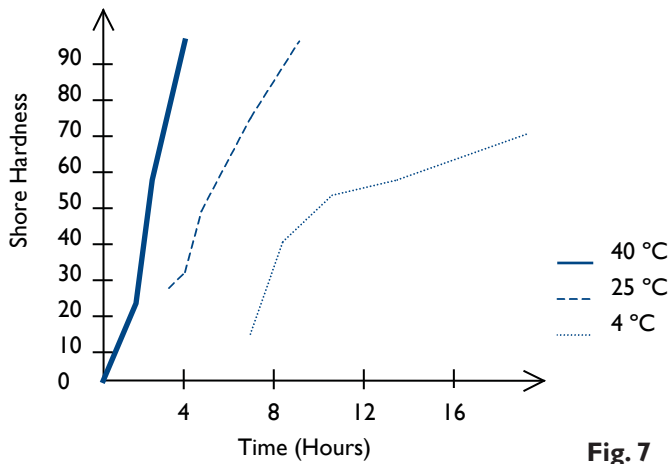


Fig. 7

- The compound may be adversely affected by some solvent vapours. If such vapours are likely to be present in the vicinity of the cable gland in service, suitable precautions may be necessary. (Contact Hawke's Technical Dept).
- The compound cures at a Shore D hardness of 85, when it can be handled. The compound when fully cured is suitable for use at a temperature range of -60°C to +80°C.

CABLE GLAND SELECTION TABLE												
Size Ref.	Entry Thread Size		Cable Acceptance Details							Max Length	Hexagon Dimensions	
			Inner Sheath/Cores			Outer Sheath						
	Metric	NPT	Max. Over Cores	Max. Inner Sheath	Max. No. of Cores	Standard Seal		Alternative Seal (S)				
						Min.	Max.	Min.	Max.			
O <sub>s</sub>	M20	½"	8.0	8.0	6	3.0	8.0	---	---	66	24.0	27.7
O	M20	½"	8.9	10.0	6	7.5	11.9	---	---	66	24.0	27.7
A	M20	½" - ¾"	11.0	12.5	10	11.0	14.3	8.5	13.4	63	30.0	34.6
B	M25	¾" - 1"	16.2	18.4	21	13.0	20.2	9.5	15.4	68	36.0	41.6
C	M32	1" - 1¼"	21.9	24.7	42	19.0	26.5	15.5	21.2	70	46.0	53.1
C2	M40	1¼" - 1½"	26.3	29.7	60	25.0	32.5	22.0	28.0	72	55.0	63.5
D	M50	1½" - 2"	37.1	41.7	80	31.5	44.4	27.5	34.8	87	65.0	75.1
E	M63	2" - 2½"	47.8	53.5	100	42.5	56.3	39.0	46.5	90	80.0	92.4
F	M75	2½" - 3"	59.0	65.3/66.2	120	54.5	68.2	48.5	58.3	92	95.0	109.6

#### SCHEDULE OF LIMITATIONS:

1. These glands are suitable for use within an operating temperature range of -60°C to +80°C.
2. When the gland is used for increased safety, the entry thread shall be suitably sealed to maintain the ingress protection rating of the associated enclosure.

#### ACCESSORIES:

Before cable gland assembly or stripping of the cable gland assembly, consideration should be given to any cable gland accessories that may be required, such as: -

- Shroud, to offer additional corrosion protection.
- Locknut, to secure cable glands into position.
- Sealing washer, to offer additional ingress protection of the enclosure at the cable gland entry.
- Serrated washer, to dampen any vibrations that may loosen the locknut or cable gland assembly.