



ELE-3COP-451

Title – Application of Loctite™ Sealants for use with TE Adaptors.

Before starting work please read this document carefully and note the guidance given.

1 Purpose and Scope

This COP describes the procedure to be used when carrying out the application of Loctite™ sealants to circular connectors for use with TE adaptors. The instructions in this document take preference over IPC/WHMA requirements, as do the drawing and any customer documentation.

2 Performance Objective

This code of practice is produced to support operators already trained in the installation of heat shrinkable and harnessing products. It identifies the installation procedure to be used when applying Loctite™ sealants to circular connectors for use with TE adaptors made from various materials and with a selection of finishes.

3 Materials and Equipment:

Connector/Adaptor to be assembled
Loctite™ 243
Loctite™ 7649 primer. (See Section 5)
Degreasing Agent Isopropyl alcohol or Isopropanol (IPA) impregnated tissue wipe.
Heavy duty tissues.
Safety glasses.

4 Health and Safety

Adhere to local Codes and Regulations relating to Safe Working practices. For the U.K. adhere to requirements of the Health and Safety at Work Act 1974 and subsequent amendments.

Adhere to the manufacturers MSDS (Manufactures Safety Data Sheet) for the use of lubricants and primers.

Assemble parts in a well ventilated area.

The use of barrier cream or rubber gloves is advisable when continually using Loctite™ Sealants.

5 Procedure

This Code of Practice is used in conjunction with ELE-3COP-452.

Thoroughly clean all surfaces where Loctite™ is to be applied using solvent and allow drying. (Surfaces should be free from all contaminates such as oil, grease etc.)

Unless otherwise stated use Loctite™ grade 243.

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Ensure that the Loctite™ is applied to the first 2 / 3 threads at the base of the connector. Refer to visual standards in this document. If excessive or insufficient adhesive is applied then clean the threads using a solvent based de-greasing agent, allow drying and then re-apply.

The use of a primer is not normally required with TE adaptors.

Loctite™ 7649 primer may be used where increased cure speed of Loctite™ 243 is required. Loctite™ recommend primer for applications when prevailing temperature is low <15°C. Users should independently evaluate the suitability of the use of primer for their application and refer to the Loctite™ technical data sheet.

6 Visual Standards



ACCEPTABLE
Loctite™ positioned on the first 2 to 3 threads



NOT ACCEPTABLE
Insufficient Loctite™ applied



NOT ACCEPTABLE
Loctite™ applied to incorrect position, must be first 2/3 threads



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Rev No	CR No	Date	Raised	Approved
6	CR06-DM-071	02/05/06	John Cronin	Ken Wallington
7	Visual Identity	06/06/11	Paul Newman	Neil Dorricott
8	SEE DMTEC	06/06/12	John Cronin	Paul Newman

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