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# ELE-3COP-576

## Title – CUT AND WRAP OPERATION FOR MARKER SLEEVES

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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 Marker sleeve repairs using the “Cut and Wrap” method. 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 procedure to be used when carrying out “Cut and Wrap” procedure on a sealed system harness.

### 3 Materials and Equipment:

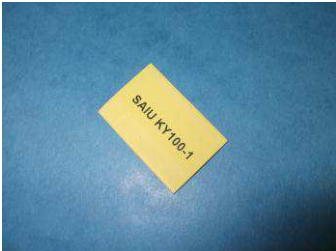
Sharpe Knife  
Suitably sized mandrill (Cable size)  
Super Glue  
Heat Gun

### 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.

### 5 Procedure – Cut and Wrap Process

1. Cut the marker size to size as per ELE-3COP-556



2. Find a suitably sized mandrill that is slightly LARGER than the cable size that you will carry out the Cut and Wrap.



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3. Recover the marker Sleeve onto the slightly oversized mandrill



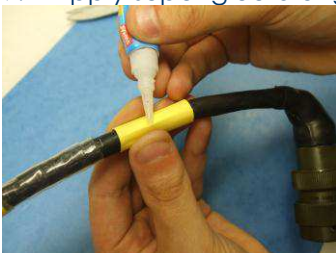
4. Remove the Marker sleeve by cutting on the opposite side of the text.



5. Lift the RT Clear sleeving from around the marker sleeve that you intend to replace. Take care not to damage the heat shrink tubing. Extra care should be taken when lifting marker sleeves on ZHTM products.
6. Place the marker into position as per the manufacturing drawing requirements.



7. Wrap the marker sleeve as tight as possible around the cable. The tighter it can be wrapped the better, as less heat will be required to recover the marker sleeve and reduce the risk of peeling off.
8. Hold the cable as shown above, ensure that seam of the cut marker is facing towards you.
9. Apply super glue along the full length of the marker sleeve seam.



10. Push the seam together using a ruler, there should be evidence of glue along the full length of the seam.



11. Clean away any excess glue and leave to cure.

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12. If the Marker sleeve needs to be recovered slightly, always apply the heat to the opposite side to the seam. Never apply heat directly onto the seam.
13. Replace the RT (Clear Sleeving) back over the Cut and Wrap marker sleeve.



### 7 Visual Standards



ACCEPTABLE



NOT ACCEPTABLE  
Split Protection Sleeve



NOT ACCEPTABLE  
Protection Sleeve Not Central



NOT ACCEPTABLE  
Unevenly Trimmed Tubing



NOT ACCEPTABLE  
Insufficient Heat. Protection Sleeve  
Under Recovered



NOT ACCEPTABLE  
Smudged Text



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Rev No	CR No	Date	Raised	Approved
1	Initial	13/08/2013	John Cronin	Martyn Reed

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