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# ELE-3COP-603

## Title – Preparation of Cable Jackets and Adaptors for the Installation of Moulded Parts

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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 out the preparation of Cable Jackets and Adaptors for the installation of moulded parts. The instructions in this document take preference over IPC/WHMA requirements, as do the drawing and any customer documentation.

It is good working practice that where trained operators have not installed this product for over 6 months, a sample installation should be carried out by the operator to refresh installation practice. Performance of the sample can be checked using the inspection standards described within this document.

### 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 preparing a Cable Jackets and Adaptor for the installation of Moulded parts. The requirement of this procedure is to provide a suitable contamination free surface for bonding with adhesive.

### 3 Materials and Equipment:

100 grit Emery Cloth or equivalent.  
Degreasing Agent isopropyl alcohol or isopropanol (IPA) impregnated tissue wipe.  
Heavy duty tissues.  
Appropriate adaptor  
Appropriate tubing or cable jacket

### 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. Use solvents in a well ventilated area. The use of suitable protective gloves and barrier cream is recommended when using solvents. Avoid prolonged repeated skin contact with solvents and always wash hands after using solvents. Care should be taken to wear safety glasses when using and handling chemical solvents. If eyes do become contaminated, flush with water and obtain medical assistance immediately.

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#### 5 Procedure - Preparation

To ensure the best possible bond between the moulded part and an adaptor, degrease the adaptor end where the H end of the moulded part will recover onto the adaptor with isopropyl alcohol or isopropanol (IPA) impregnated tissue wipe.

As adaptors are normally plated, NEVER abrade the adaptor.

To ensure the best possible bond between the moulded part and the cable jacket:-

Degrease the cable jacket using Isopropyl alcohol, ensuring that the abraded section extends a minimum of 20mm beyond the recovered length of the substrate to be bonded.

Abrade the cable jacket thoroughly in the same area with 100 grit emery cloth. The whole surface of the cable jacket should be abraded removing any print on the cable jacket.

Remove loose particles from the abraded area using a dry tissue. **DO NOT** use a solvent wipe.

Ensure sufficient cable jacket has been abraded to incorporate the strip length requirement.



This part of the cable preparation is very important in ensuring a strong bond to the moulded part.

#### 6 Inspection Requirements

Ensure sufficient cable jacket has been abraded to incorporate the strip length requirement.

Ensure any print on the cable jacket section abraded has been removed.

Ensure the abraded area is free from loose particles.



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