
ELE-3COP-609

Title – Preparation of Non Screened Moulded Parts prior to installation.

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 for the preparation of non screened moulded parts prior to installation. 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 for the preparation of non screened moulded parts prior to installation to provide a suitable contamination free surface for bonding with adhesive. This procedure excludes moulded parts with pre installed adhesives.

Note

Best results will be obtained if 10% unresolved recovery (grip) for all outlets of the moulded part is available. Please check for compliance with this requirement before assembly. Unresolved recovery is defined as the difference between the installed diameter and the fully shrunk (recovered) diameter as given on the SCD expressed as a percentage of the fully shrunk diameter. For example a moulded part fully shrunk with a diameter of 10mm and an installed diameter of 11mm has a 10% unresolved recovery.

3 Materials and Equipment:

Appropriate moulded part.
100 grit Emery Cloth or equivalent.
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.
The use of solvents should be carried out 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.

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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.

5 Procedure - Preparation

To ensure the best possible bond between a non screened moulded part and an adaptor/cable jacket, degrease the inner area of the moulded part at each end thoroughly (Approximately 30mm) using Isopropyl alcohol.

Abrade the inner area of the moulded part at each end thoroughly (Approximately 30mm) with 100 grit emery cloth.

Moulded parts with pre-coated adhesives should not be degreased or abraded, refer to ELE-3COP-559 for /225 and ELE-3COP-608 for /42, /86 and /180.

Remove loose particles from the abraded area at both ends of the moulded part using a dry tissue.

DO NOT use a solvent wipe.



Moulded Part Abrasion

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

6 Inspection Requirements

Ensure sufficient area of abrasion to the moulded part has been carried out.
Ensure the abraded area is free from loose particles.



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