
ELE-3COP-610

Title – Preparation of Cable Jackets for the Installation of Adhesive Lined Tubing.

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 cable jackets prior to the installation of adhesive lined heat shrinkable tubing. 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 in the preparation of cable jackets prior to the installation of adhesive lined heat shrinkable tubing.

3 Materials and Equipment:

Appropriate cable jacket.
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 installation should be carried out in a well ventilated area. Always wear heat resistant safety gloves when handling hot plastics and adhesives. 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 a cable jacket and adhesive lined heat shrinkable tubing, degrease the cable jacket in the area where the adhesive lined heat shrinkable tubing will recover onto the cable using Isopropyl alcohol.

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 bond length requirement.



Figure 1

Care should be taken not to handle or contaminate the abraded and clean surface.

This part of the cable preparation is very important in ensuring a strong bond to the adhesive lined heat shrinkable tubing

6 Procedure - Installation

Refer to relevant installation procedure for the specific adhesive lined heat shrinkable tubing.

7 Inspection Requirements

The surface of the cable jacket should be abraded 360° in the area where the adhesive lined heat shrinkable tubing will recover onto the cable.

Any print on the cable jacket should be removed in the area where the adhesive lined heat shrinkable tubing will recover onto the cable.

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Ensure sufficient cable jacket has been abraded to incorporate the bond area. The area where the adhesive lined heat shrinkable tubing will recover onto the cable must be free from loose particles and fingerprints.

8 Visual Standards

Refer to Figure 1

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3	HSG	15/03/91	Trevor Holiday	Malcolm Scott
4	CR09-DM-018	23/07/10	Paul Newman	Neil Dorricott
5	Visual Identity	07/06/11	Paul Newman	Neil Dorricott

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