
ELE-3COP-732

Title – Connector Access using Moulded Part Roll Back Method.

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 heating and rolling back a moulded part in order to gain access to the rear of a connector. 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 gaining access to the rear of a connector using the roll back method, without breaking adhesive bonds when a moulded part has been used in conjunction with a spin coupling adaptor.

3 Materials and Equipment:

Connector/Adaptor assembly

Glenair Strap spanner TG70

Dummy receptacle

Heat Gun CV1981 or equivalent

Reflector PR26

Relevant connector tooling – extraction/insertion (if applicable)

Soldering Iron (if applicable)

For full material and equipment requirements refer to ELE-3COP-452, Installation and Torque Tightening of Standard and Type 2 Adaptors

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.

DO NOT HANDLE HOT REFLECTORS without using heat resistant gloves.

Always wear heat resistant safety gloves when handling hot plastics and adhesives.

5 Procedure

Secure the connector into position on the mating receptacle.

Always ensure that the air vent on the rear of the hot air gun is open and that it is dust free.

Set the hot air gun to 230°C to 250°C and allow the hot air gun to stabilize at the required temperature and setting for two minutes before commencing.

Please refer to the Manufacturers guide for Hot Air Gun Calibration and maintenance.

Apply heat to the moulded part as shown in Figure 1 ensuring even distribution of the heat around the complete circumference of the body at the cable end until it becomes soft and pliable.

ELE-3COP-732

Title – Connector Access using Moulded Part Roll Back Method.

Using a strap spanner, release and fully un-screw the connector adaptor. (See Figure 2). Holding the cableform in one hand, pull the adaptor back towards the cable away from the connector, folding the larger diameter of the moulded part over the smaller diameter as per Figure 3.

Ensure the moulded part has been adequately heated before attempting to “roll” back the moulded part. Note keyway position.



Figure 1



Figure 2



Figure 3



Figure 4

Once access has been gained to the rear of the connector any repair or modifications can be carried out using the appropriate connector tooling. (See Figure 4).

Upon completion of modifications carefully apply heat to the moulded part as shown in Figure 5 ensuring even distribution of the heat around the complete circumference until it becomes soft and pliable. Take care not to apply excessive heat which may scorch the moulded part.

Holding the cableform in one hand, pull the adaptor back towards the connector away from the cable, apply addition heat if necessary. (See Figure 6).

Secure and tighten the adaptor applying Loctite™ if applicable. Refer to ELE-3COP-452 for full details on the installation and torque tightening of adaptors.

Apply further heat until moulded part has returned to original shape and all marks and distortions have been removed.

ELE-3COP-732

Title – Connector Access using Moulded Part Roll Back Method.



Figure 5



Figure 6

6 Inspection Requirements

The Moulded Part must be free from fingerprints and scorch marks.
 A full insulation and continuity test should be carried out.
 Check for damage to the connector after torque tightening.
 Check by hand that adaptor is tight.
 Ensure that the connector keyway is re-positioned /aligned as per drawing or original position prior to roll back.

7 Visual Standards

Not applicable

Rev No	CR No	Date	Raised	Approved
2	CR06-DM-071	04/05/06	John Cronin	Ken Wallington
3	CR09-DM-018	04/02/09	Paul Newman	Neil Dorricott

All of the above information is believed to be reliable. Users, however, should independently evaluate the suitability of each product for their application. TE makes no warranties as to the accuracy or completeness of the information and disclaims any liability regarding its use. TE's only obligations are those in the Standard Terms and Conditions of Sale for these products and in no case will TE be liable for any incidental/ indirect or consequential damages arising from the sale, resale, use or misuse of the product. TE Specifications are subject to change without notice. In addition TE reserves the right to make changes in materials or processing, without notification to the Buyer, which do not affect compliance with any applicable specification.