
ELE-3COP-652

Title – Attachment of Cord to Cable

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 securing of cord to the cable of a harness assembly. 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 securing a protection cover using cord to the cable of a harness assembly. The requirement of this procedure is to provide a suitable attachment that will not separate the cord from the harness assembly.

3 Materials and Equipment:

150/8 Olive Glace Cord

SCL ¼ -0 Tubing

Heat Gun CV1981 or equivalent. Other hot air guns may be used but these must be capable of delivering the temperatures required for installation of the tubing. This also includes hot air guns with temperature displays.

Reflector PR26.

Degreasing Agent Isopropyl alcohol or Isopropanol (IPA) impregnated tissue wipe.

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.

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.

5 Procedure - Preparation

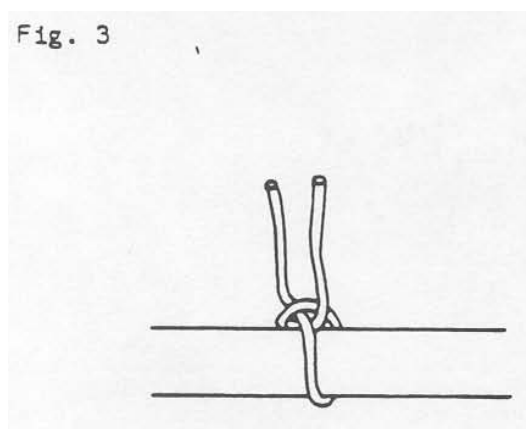
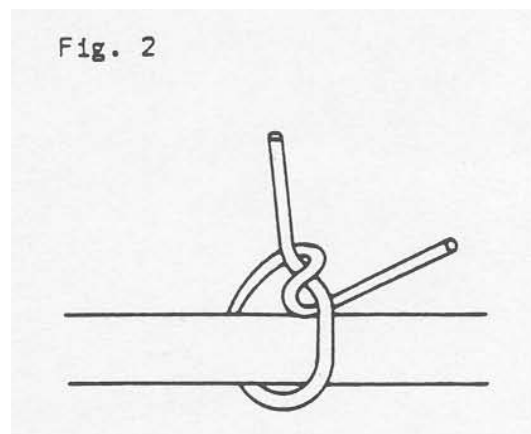
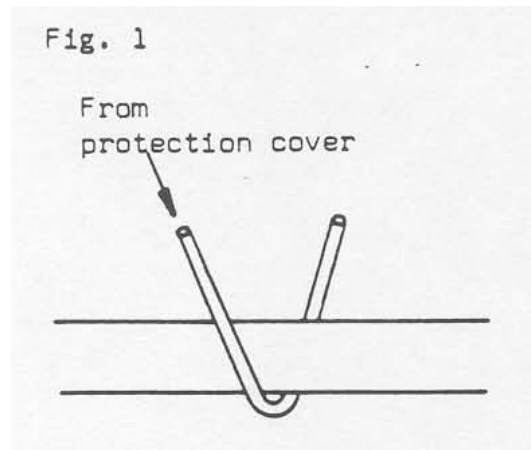
The length of the Olive Glace Cord should be 400mm with straight moulded parts and 350mm with angled moulded parts unless otherwise stated.

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Feed on 20mm of SCL 1/4 -0 tubing

Wrap the Olive Glace Cord around cable of harness assembly as shown in Figures 1, 2 and 3.

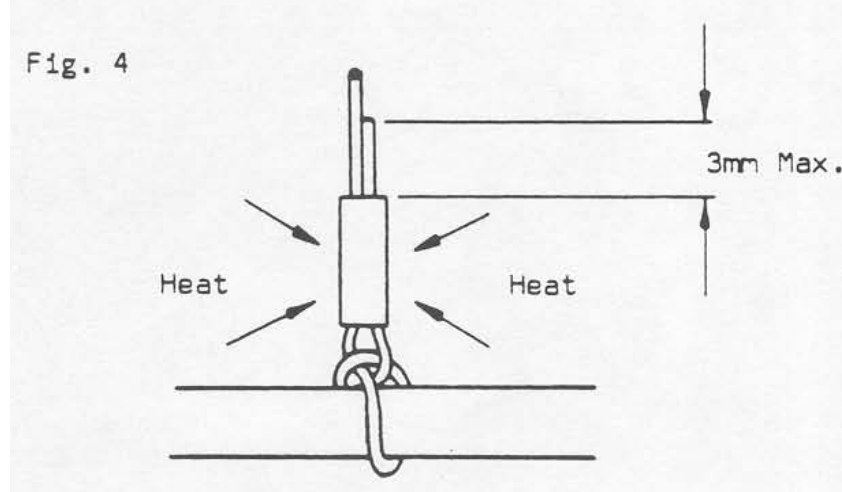


Position the 20mm of SCL 1/4 -0 tubing and apply heat until the adhesive inner flows ensuring that the cord is not damaged. See Figure 4.

NOTE ; Allow assembly to cool before inspection.

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6 Inspection Requirements

Ensure Olive Glace Cord is not damaged or distorted.

Apply a sharp tug on the Olive Glace Cord to ensure there is no separation from the SCL tubing.

Rev No	CR No	Date	Raised	Approved
1	Initial	14/12/89	Trevor Holiday	Malcolm Scott
2	CR09-DM-018	06/06/11	Paul Newman	Neil Dorricott

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