
ELE-3COP-366

Title – Positioning of a Tinel Lock™ ring onto a Tinel Lock™ Adaptor prior to full 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 when positioning a Tinel-Lock™ ring onto a Tinel-Lock™ adaptor where the Tinel-Lock™ ring is a tight fit over the braid for adaptor entry sizes 04 to 08 inclusive. 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 positioning a Tinel-Lock™ ring onto a Tinel-Lock™ adaptor to ensure that the braid is terminated reliably and consistently. Tinel-Lock™ rings are designed to give a high conductivity, 360°, high pressure, gas-tight joint to braids terminated to adaptors or any other conductive back fitting machined with the correct Tinel-Lock™ profile. Using this method, assembly of double optimised braids with a Tinel-Lock™ 'A' ring can be achieved without risk of damage to the adaptor or the insulation inside the Tinel-Lock™ ring

3 Materials and Equipment:

TE Adaptor and Tinel-Lock™ ring.
Braid to be terminated.
Scissors or small side cutters.
Tinel-Lock™ Ring Tool 09/2017/00X (Refer to Table 1).

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.

5 Procedure

To ensure system performance a limitation of 2.5 milliohms maximum has been placed on the final installed cable braid/adaptor/connector interface. This measurement is impractical to achieve after production due to an insulating jacket covering the screen and extending under the lip at the moulded part, therefore the following system of test/measurement should be carried out during the cable assembly stage.

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- a) Measure screen resistance of the prepared cable, end to end and record result.
- b) After installing the adaptor and Tinel-Lock™ component on first end, measure from the cable braid to the connector body and record result. Ensure that this value is less than the value recorded in (a) above + 2.5 milliohms.
- c) After fitment of second and subsequent ends, measure and record result. Ensure that the value is less than the result recorded in (b) above + 2.5 milliohms.

This procedure applies to single and double layers of Tinel-Lock™ compatible braid.

Strip the cable jacket to the required length to expose cable braid.

Cut braid to required length and ease away from the wires beneath taking care to ensure that the weave of the braid is maintained.

Expand the braid diameter by gently compressing from the end until it slides over the adaptor Tinel-Lock™ profile.

Push the braid forward until it fully covers the Tinel-Lock™ profile and bottoms on the shoulder provided.

Slide the Tinel-Lock™ ring tool onto the cableform. Locate the Tinel-Lock™ ring into the recess of the tool with the weld of the Tinel-Lock™ ring positioned in the rebate of the tool. See Figure 1

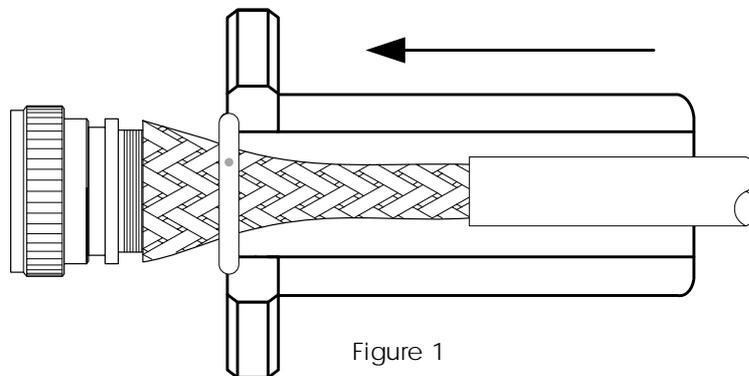


Figure 1

Ease the Tinel-Lock™ ring onto the shoulder of the Tinel-Lock™ adaptor by using gentle pressure stopping short of the shoulder provided and ensuring that it is perpendicular to the axis of the adaptor. Tinel-Lock™ rings may be eased into place in a rocking or walking motion. This helps nest the strands of braid neatly, do not use a brute force straight push. See Figure 2.

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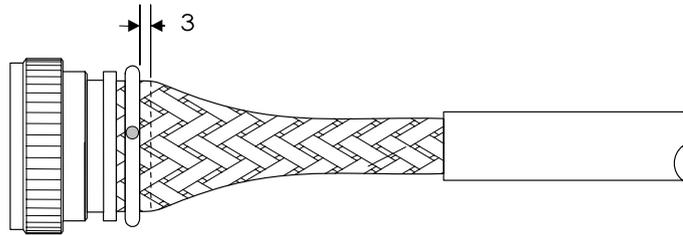


Figure 2

Tinel-Lock™ Ring Tool	Tinel-Lock™ Ring Size
09/2017/001	04
09/2017/002	05
09/2017/003	06
09/2017/004	07
09/2017/005	08

Table 1

For full Tinel-Lock™ installation procedure refer to document ELE-3COP-359

6 Inspection Requirements

Refer to document ELE-3COP-359.

7 Visual Standards

Refer to document ELE-3COP-359.

Rev No	CR No	Date	Raised	Approved
1	Initial	03/01/91	M F Nicholls	Paul White
2	CR09-DM-018	26/07/10	Paul Newman	Neil Dorricott
3	Visual Identity	06/06/11	Paul Newman	Neil Dorricott

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