
ELE-3COP-556

Title – Marker and Protection sleeve preparation and 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 carrying out the installation of heat shrinkable marker and protection sleeves. 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 installing a heat shrinkable marker and protection sleeve using a hot air gun. The aim is to recover the marker sleeve whilst maintaining its legibility.

3 Materials and Equipment

Appropriate Marker Sleeve

Appropriate Protection Sleeve

Scissors or Guillotine

Rule / Tape Measure

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 moulded part. This also includes hot air guns with temperature displays.

Reflector PR26

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.

A knife should never be used for cutting tubing as this can easily cause personal injury.

5 Procedure

Ensure the marker sleeve legend is correct to drawing.

It is good practice to protect marker and protection sleeves using tissue cloth and paper tape during cable assembly to prevent contamination or damage.

Trim Marker Sleeve to length specified on relevant documentation or if no marker sleeve length is specified, as detailed below.

Trim Marker Sleeve so that approximately one character print width of unmarked sleeve is left either side of the legend, if this cannot be achieved due to the position of the legend then trim the marker sleeve so that the legend is central (See Fig 1 and 2).

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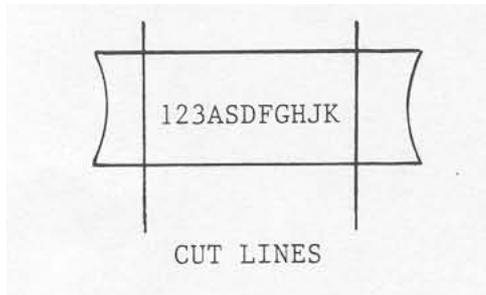


Figure 1

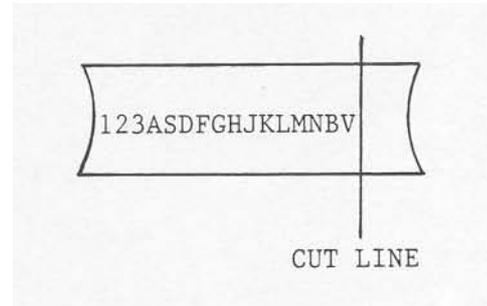


Figure 2

Unless otherwise specified, trim Protection Sleeve so that it is 10mm longer than the Marker Sleeve.

Position Marker Sleeve as specified on drawing or 50mm from a moulded part and recover using Hot Air Gun (CV1981) and Reflector PR26.

Position Protection Sleeve centrally over the Marker Sleeve and recover using Hot Air Gun (CV1981) and Reflector PR26. Making sure that there is no scorching or freeze marks.

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

Always allow the hot air gun to stabilize at the required temperature and setting for two minutes before commencing calibration and installation. Setting of the gun should be carried out on a regular basis, frequency will depend on usage.

For installation temperatures refer to the appropriate product data sheet.

It is recommended that the heat gun is set daily using a Calibrated thermocouple 25 mm from the end of the reflector.

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

6 Inspection Requirements

There shall be no scorching of marker or protection sleeve.

There shall be no smudging of legend.

The marker sleeve and protection sleeve shall be cut clean and free from nicks or splits.

Marker sleeve text should be of even height and free of distortion.

Check that the label is legible.

7 Visual Standards

The following visual standards should be observed.

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ACCEPTABLE



NOT ACCEPTABLE
Split Protection Sleeve



NOT ACCEPTABLE
Protection Sleeve Not Central



NOT ACCEPTABLE
Unevenly Trimmed Tubing



NOT ACCEPTABLE
Insufficient Heat. Protection Sleeve
Under Recovered



NOT ACCEPTABLE
Smudged Text

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NOT ACCEPTABLE
Illegible Text



NOT ACCEPTABLE
Insufficient Heat Protection Sleeve
Under Recovered

Rev No	CR No	Date	Raised	Approved
3	CR06-DM-071	03/05/2006	John Cronin	Ken Wallington
4	CR09-DM-018	14/12/2009	Paul Newman	Neil Dorricott
5	Visual Identity	07/06/11	Paul Newman	Neil Dorricott

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