
ELE-3COP-375

Title - Braid termination using a Band Strap Adaptor.

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 a Band Strap adaptor. 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 to ensure that a cable shield is terminated reliably and consistently using a Clamping Band designed to give a high conductivity, 360° joint to shields terminated to Band Strap circular adaptor or any other conductive back fitting machined with the correct Band Strap profile.

3 Materials and Equipment:

Appropriate TE Band Strap adaptor. (Clamping band supplied with adaptor. Clamping band BND-1425S is used for entry sizes 03 to 28,
Shield to be terminated
Scissors or small side cutters
Glenair Hand Banding Tool 600-058

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 shield/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.

- a) Measure screen resistance of the prepared cable, end to end and record result.
- b) After installing the adaptor and the Band Strap component on first end, measure from the cable shield 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.

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This procedure applies to single and double layers of Band Strap compatible shield.

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

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

Expand the shield diameter by gently compressing from the end until it slides over the Band Strap adaptor profile. See Figure 1.

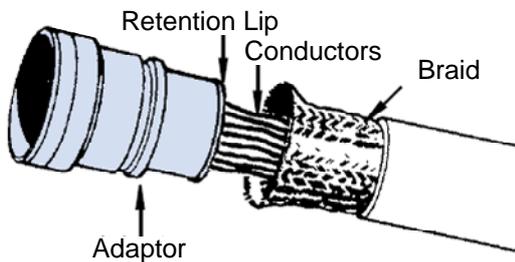


Figure 1

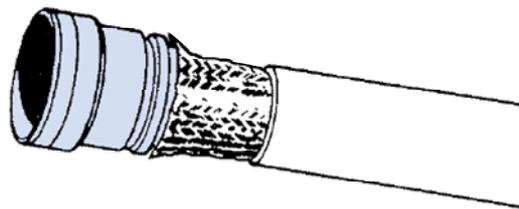


Figure 2

Push the shield forward over the retention lip until it fully covers the Band Strap profile and bottoms on the shoulder provided. See Figure 2.

Due to connector/adaptor circumference, it may be necessary to prepare the band around the cable or retention area. Roll the band through the buckle slot twice. (Bands must be double-coiled.) See Figure 3

Pull on band until Mark (>I) is within approximately .250 inch (6.4mm) of buckle slot. The band may be tightened further if desired.

NOTE: Prepared band should have (>I) Mark visible approximately where shown in Figure 3.

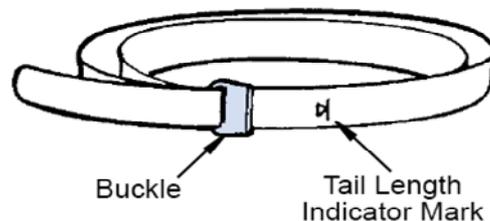


Figure 3

To free the tool handles, move holding clips to the centre of the tool. Squeeze the gripper release lever and insert the band into the front end opening of the tool. The circular portion of looped band must always face downward. See Figure 4.

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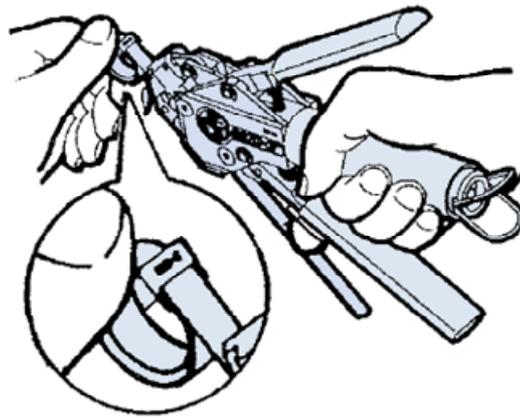


Figure 4

Aligning the band and tool with the shield termination area, squeeze the black Pull-Up handle repeatedly using short strokes until it locks against the tool body. (This indicates the band is compressed to the tool calibrated tension.) NOTE: If alignment of band and shield is unsatisfactory, tension on band can be relaxed by pushing on slotted release lever on top of tool. Make adjustments as necessary and again squeeze black pull-up handle. See Figure 5. Complete the clamping process by squeezing the grey cut-off handle. See Figure 6

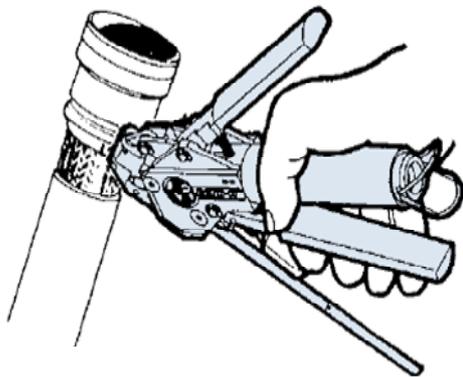


Figure 5

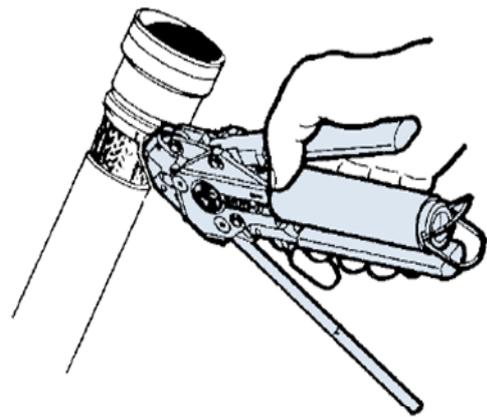


Figure 6

Remove excess band from tool and dispose and inspect shield termination. See Figure 7.

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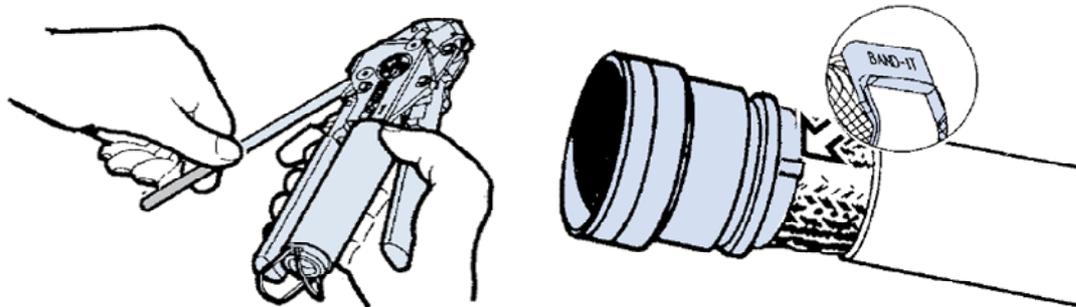


Figure 7

Inspection

Ensure strands are not scraped, nicked severed or otherwise damaged.
 Strands are not flattened, untwisted, buckled, kinked or otherwise deformed.
 Ensure the clamping band is tight and that there are no sharp edges.

6 Replacement Parts

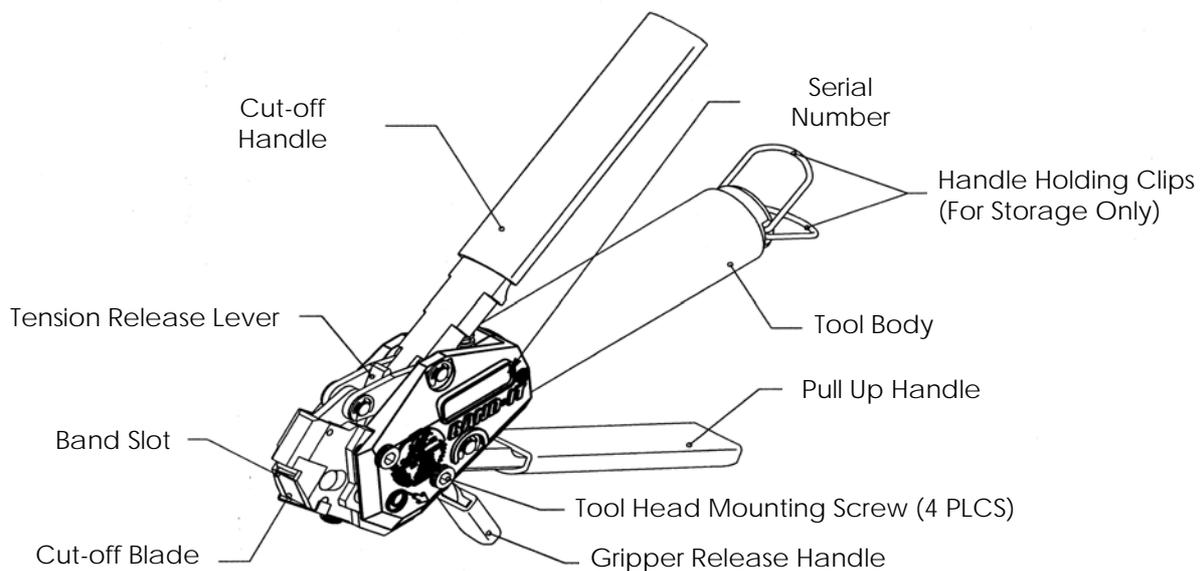


Figure 8

To replace cut-off blade bend retaining clip down just enough to free mounting pin. Remove pin and blade. Inspect opposite end of blade, if used, replace with new one. Install blade with unused edge pointing toward knife. Re-install mounting pin. See Figure 9.

To replace knife remove blade as described above. Remove snap ring and pivot pin 1. Line up pivot pin 2 with access hole on tool head and slide out sideways. Remove knife and replace with new one. Reinstall all parts in reverse order. Actuate cut-off handle to verify correct installation of components. See Figure 9.

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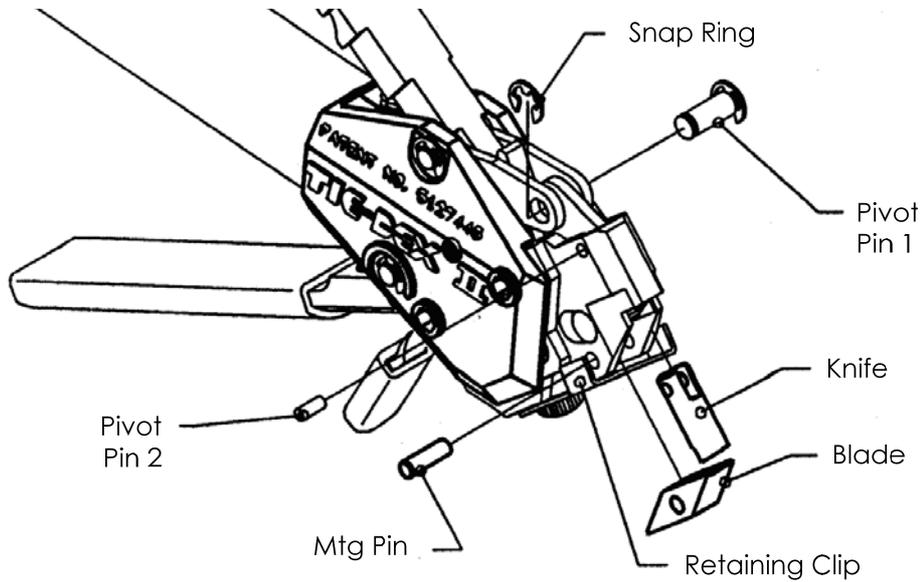
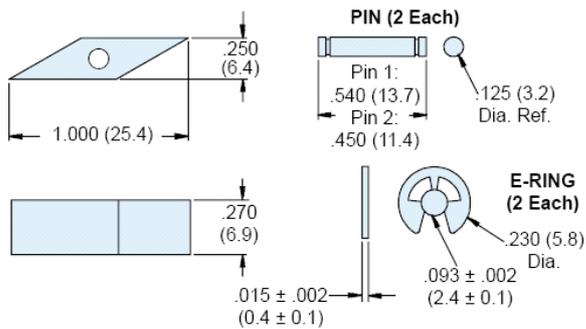


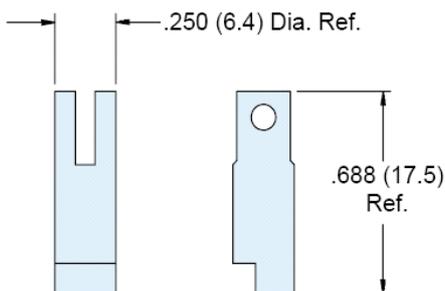
Figure 9



600-056 Cut-off Blade Kit

The 600-056 Cut-off Blade Kit consists of the blade, two E-rings and one pin, providing all parts needed to replace the cut-off blade on the 600-058 Hand Banding Tool.

BAND-IT™ part number A40699.



600-062 Cutter Knife

The 600-062 Cutter Knife for Serial Numbers up to 16589 replaces the cutter knife on the 600-058 Hand Banding Tool.

BAND-IT™ part number A40788.

Use 600-062-1 Cutter Knife for Serial Numbers 16590 and above.

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Rev No	CR No	Date	Raised	Approved
1	Initial	24/05/02	Dominic Hammond	Ken Wallington
2	CR06-DM-071	19/04/06	John Cronin	Paul Newman
3	DMTEC	23/02/10	Paul Newman	Neil Dorricott
4	Visual Identity	06/06/11	Paul Newman	Neil Dorricott

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