CA5005-00

Manufacturing Method
WHITE HEAT SHRINK WIRE MARKERS

GENERAL

Rev. 0 of this document (CA5005-00) utilized clear heat shrink (PD0016-##) over standard SIS wire markers. This process is now obsolete. **Rev. 1** (and later) versions of this standard utilizes computer-driven white heat shrink markers (PD5002-##).

PURPOSE

Certain customers require Switchboard Insulation System (SIS) type wiring, marked with number-coded white heat shrink labels. The heat shrink type prevents markers from inadvertently coming loose. Markers are white with black text for ease of reading inside dark enclosures.

PART NUMBERS

A small selection of white heat shrink labels (PD5002-##) is available for use with computer-driven printers. Wide selections of printed markers (size and number-code) are required per job, based upon unit model number, ac input voltage, type and size of enclosure, features, and options. Refer to standard (CB0009-00) for wire size. Select part numbers of heat shrink markers based upon the following table.

WIRE SIZE	HEAT SHRINK PART No	MARKER DIAMETER	MARKER WIDTH
#18-12 AWG	PD5002-01	0.188in	1.00in
#12-6 AWG	PD5002-04	0.375in	1.00in
#8-1 AWG	PD5002-02	0.500in	1.00in
1/0-4/0	PD5002-03	1.00in	1.00in

PREPARATION

Start the *Easy-Mark* wire mark labeling software at the Engraver / Wire Marker computer station. Based upon charger job wiring requirements, open files, enter, and print PAIRS of white heat shrink wire markers (PD5002-##).

APPLICATION

After crimping all lugs, slip 0.50in white heat shrink markers (PD5002-##) over wires near terminations, one (1) on each end. Warm white markers with heat gun until strips are shrunk securely onto ends of wires.