Adhesives Selection Guide

Adhesives and Sealants That Accommodate a Wide Range of Applications, Materials, and Environmental Conditions

S1006

Raychem Two-Part Epoxy Adhesive

S1006 flexible high-viscosity, two-part epoxy is supplied in a bi-pack to ensure correct mixing. S1006 consists of a pale yellow epoxy resin and an amber hardener.

APPLICATION

S1006 is an excellent adhesive for many substrates including:

- Polyolefin tubing
- Heat shrink polyolefin molded parts
- Aluminum alloy adapters and connector end fittings
- Mild steel, brass and copper
- Raychem RNF-100 heat-shrink tubing
- Raychem Versafit heat-shrink tubing
- Raychem CRN heat-shrink tubing
- Raychem NT and NTFR heat-shrink tubing
- Raychem -3, -4, and -71 molded parts

TEMPERATURE RANGE

- -55°C to +135°C

PACKAGING

- **S1006 Kit 1:** 2 sachets, 15 g each
- **S1006 Kit 2:** 4 sachets, 7.5 g each
- **S1006 Kit A:** 10 sachets, 3 g each
  (Kit A is Mil-Spec certified)

SPECIFICATIONS

Raychem RT-1006
Raychem RK-6612
A-A56031

S1009

Raychem Two-Part Modified Epoxy Adhesive

S1009 adhesive is a two-part modified epoxy that provides an environmental seal that is flexible, watertight, low outgassing, and permanent in a variety of applications, including space equipment and vehicles.

APPLICATION

The adhesive is specifically formulated for use with TE polyolefin tubing, such as

- Raychem RNF-100 heat-shrink tubing
- Raychem RT-218 and RT-220 heat-shrink tubing
- Raychem Versafit heat-shrink tubing
- Raychem CRN heat-shrink tubing
- Raychem NT and NTFR heat-shrink tubing
- Raychem -3, -4, and -71 molded parts

S1009 adhesive also bonds well to PVC tubing.

TEMPERATURE RANGE

- -55°C to +135°C

PACKAGING

- **S1009 Kit A:** 10 sachets, 3 g each

SPECIFICATIONS

Raychem RT-1009

S1125

Raychem Chemical and Heat-Resistant Adhesive

S1125 high performance adhesive has been developed to match the superior chemical and heat resistance properties of DR-25 heat-shrinkable tubing and -25 heat-shrinkable molded parts. The adhesive forms the third member of the System 25 product trio and has low outgassing.

APPLICATION

Although developed for Raychem System 25 cable harnessing products range, S1125 is an excellent adhesive for many other substrates including:

- Raychem RNF-100 heat-shrink tubing
- Raychem Versafit heat-shrink tubing
- Raychem CRN heat-shrink tubing
- Raychem Convolex and HCTE convoluted tubing
- Raychem -3, -4, -12 and -100 molded parts
- Raychem System 100 components
- Aluminum alloy adapters and connector fittings

TEMPERATURE RANGE

- -55°C to +150°C

PACKAGING

- **S1125 Kit 1:** 5 sachets, 10 g each + accessories
- **S1125 Kit 4:** 5 sachets, 10 g each
- **S1125 Kit 5:** 1 sachet, 10 g
- **S1125 Kit 8:** One 50 ml dual syringe + 3 mixing nozzles, 5 mixing sticks, 5 abrasive, and 1 installation leaflet

SPECIFICATIONS

Raychem RT-1011
Raychem RK-6619
DIN VG-95343
NASA SP-R-022A

S1184

Raychem Highly Conductive Termination Adhesive

Raychem S1184 highly conductive silver-loaded termination adhesive has been developed to terminate Raychem moulded shapes. Its excellent conductivity enables very high shielding levels of Raychem screened molded shapes, multicore cables, braided cables and adaptors to be combined to form efficient, totally screened harness systems.

APPLICATION

Raychem S1184 two part epoxy adhesive is designed to make termination which can withstand high temperatures and aggressive solvents and fuels. When mixed and installed in conjunction with Rayaten heat-shrinkable parts, S1184 will continue to cure at room temperature reaching full cure after 24 hours. Pot life after mixing is approximately 1 hour.

TEMPERATURE RANGE

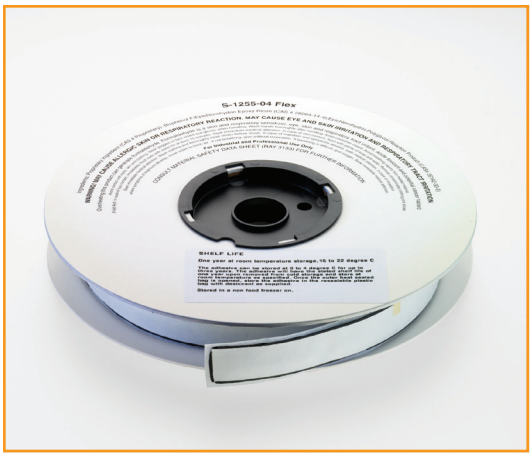
- -55°C to +150°C

PACKAGING

- **S1184 Kit 1:** Two 10 ml syringes

SPECIFICATIONS

Raychem RK-6627



S1255-04

Raychem Adhesive Tape

S1255-04 one-part epoxy tape has been developed to match the superior chemical and heat resistance properties of TE's Raychem System 200, 300, 780 and 790.

APPLICATION

Developed originally to match the +200°C temperature performance of Raychem System 200 components. S1255-04 also offers resistance to the effects of nuclear, biological and chemical agent exposure and decontamination when used with other compatible components.

- Raychem System 200 fluoroelastomeric tubing and molded parts
- Raychem System 300 fluoropolymer tubing and -55 molded parts
- Raychem System 780 fluoroelastomeric tubing and molded parts
- Raychem System 790 fluoropolymer tubing and molded parts
- NBCCS resistant

TEMPERATURE RANGE

- -55°C to +200°C

PACKAGING

- 3/4 in. x .020 in. x 100 ft. roll
  (20 mm x 0.5 mm x 30 m)

SPECIFICATIONS

Raychem RT-1255
Raychem RT-1014

S1264

Raychem NBCCS* Adhesive

S1264 high performance adhesive has been developed to match the superior chemical and heat resistance properties of TE's Raychem System 770. The adhesive material has been hardened to withstand the damaging effect of NBC contamination and decontamination washdowns.

APPLICATION

S1264 adhesive is suitable for use in wire harness systems requiring resistance to the effects of nuclear, biological and chemical agent exposure and decontamination when used with other NBC compatible components. S1264 will adhere to

- Raychem DR-25 heat-shrink tubing
- Raychem -25 molded parts
- Raychem FDR cable jackets
- Raychem RT-770 tubing and -770 molded parts
- Raychem RT-780 tubing and -780 molded parts

TEMPERATURE RANGE

- -55°C to +150°C

PACKAGING

- **S1264 Kit 1:** 1 sachet, 10 g
- **S1264 Kit 8:** One 50 ml dual syringe, 5 mixing sticks, 5 abrasive, and 1 installation leaflet

SPECIFICATIONS

Raychem RT-1012

*Nuclear, biological, chemical contamination survivable

S1017

Raychem Hot-Melt Adhesive Tape

S1017 is a general purpose, hot-melt adhesive supplied in tape form for easy application to cable substrates. S1017 can also be supplied coated onto molded parts as /42. A tough yet flexible adhesive, it is suitable for bonding polyolefins, vinyls and neoprenes, and metals such as steel and aluminum.

APPLICATION

Raychem -3 and -4 molded parts

TEMPERATURE RANGE

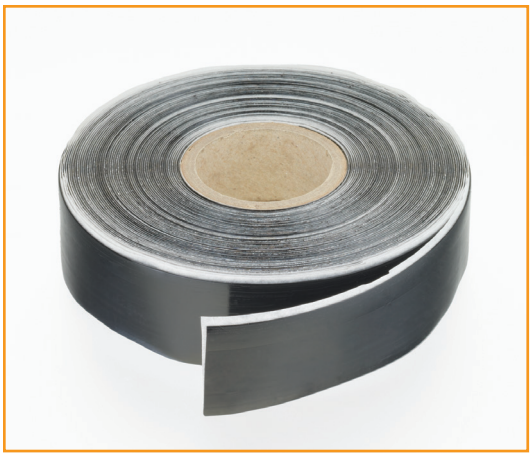
- -40°C to +105°C

PACKAGING

- 1 in x .010 in. x 50 ft roll
  (25.4 mm x 0.3 mm x 15.2 m)

SPECIFICATIONS

Raychem RT-1050/1



S1030

Raychem Hot-Melt Adhesive Tape

S1030 tape is a non-flame-retarded polyolefin-based hot-melt adhesive tape. The product is recommended for high flexibility at temperatures as low as -80°C. The tape is often pre-applied to molded parts; its pre-coat designation is /180.

APPLICATION

S1030 is recommended for marine applications where salt water is a threat. The adhesive is very user-friendly, exhibiting excellent flow when heated under normal installation conditions. It is not recommended where aggressive solvents may be present or for terminations under in-service flexural stress at temperatures above 40°C.
With good adhesion to a wide range of substrates, S1030 hot-melt adhesive tape is recommended for use with polyurethane materials and for the following TE products:

- Raychem System 100 Zerohal tubing, cable jackets, and -100 molded parts
- Raychem System 25 molded parts
- Raychem DR-25, RNF and RW-175 heat-shrink tubing,
- Raychem FDR-jacketed cable

TEMPERATURE RANGE

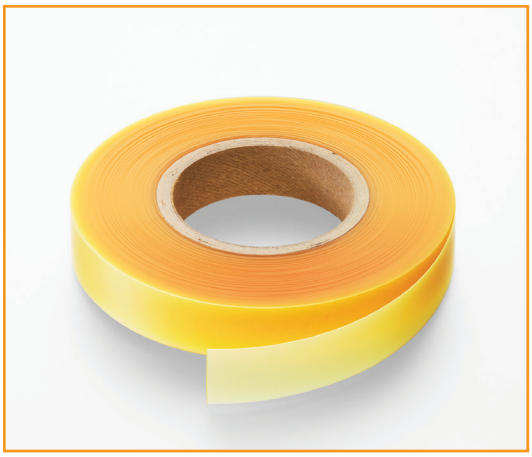
- -80°C to +80°C

PACKAGING

- 3/4 in. x 0.010 in. x 33 ft. roll
  (20 mm x 0.3 mm x 10 m roll)

SPECIFICATIONS

Raychem RT-1050/6
Raychem RK-6017



S1048

Raychem Hot-Melt Adhesive Tape

S1048 is a hot-melt adhesive that can be supplied coated onto molded parts as /86. It is generally used as a high-strength hot-melt adhesive.

APPLICATION

S1048 will adhere extremely well to most cable jacket materials, such as ZHTM, DR-25, FDR or RNF, as long as enough heat has been applied at the installation stage to ensure complete flow and wetting of the adhesive to a substrate.

- Raychem ZHTM low-fire-hazard, zero-halogen heat shrink tubing, cable jackets and -100 molded parts
- Raychem DR-25 jackets and tubing
- Raychem FDR jackets and tubing
- Raychem RNF jackets and tubing
- PVDF jackets and tubing

TEMPERATURE RANGE

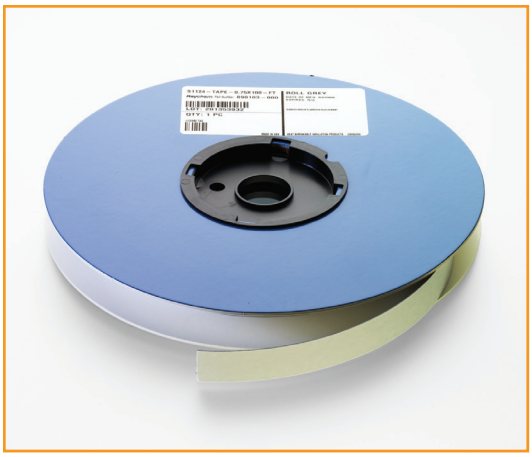
- -55°C to +120°C

PACKAGING

- 1 in. x .026 in. x 100 ft. roll
  (25.4 mm x 0.66 mm x 30 m roll)

SPECIFICATIONS

Raychem RT-1050/3
Raychem RK-6626 for /86 pre-coat
VG95343 for /86 pre-coat on -100 molded parts



S1124

Raychem Elastomeric Adhesive Tape

S1124 is a flexible adhesive based on elastomeric polymers. This adhesive was developed for use with heat-shrinkable products, NT, NT-MIL, NTFR and elastomeric polymer blend (EPB) molded parts. This adhesive provides good bonds to metals, such as steel and aluminum when bond line is heated to 150°C during installation. S1124 can also be supplied coated onto molded parts as /164.

APPLICATION

S1124 tape is well suited for military ground vehicle electrical harness sealing due to its temperature and fluid resistance characteristics.

- Raychem NR, NTFR, and NT-MIL heat-shrink tubing
- Raychem EPB (-51) molded parts

TEMPERATURE RANGE

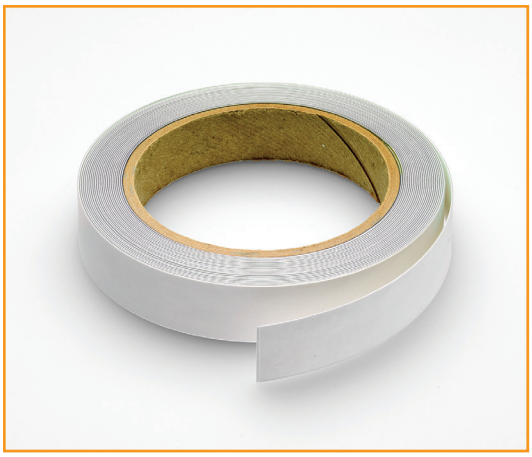
- -55°C to +135°C

PACKAGING

- 3/4 in. x .018 in. x 100 ft. roll
  (20 mm x 0.46 x 30 m)

SPECIFICATIONS

Raychem RT-1050/13



S1260

Raychem High Temperature Hot Melt Tape Adhesive

S1260 tape is a flexible, high temperature adhesive based on an environmentally resistant, modified fluoropolymer. The tape can be used with fluoropolymer insulation systems such as RT-555, RW-200 and -12 molded parts to provide sealing in high-temperature applications.

APPLICATION

S1260 high-temperature, hot melt, tape adhesive can be used to sustain cable properties in ground defense and aerospace applications. It can be used for fast, permanent field repairs to high temperature wire and cable with fluoropolymer and fluoroelastomer insulation. It can also be used for sealing high-temperature heat-shrink components to backshells. The tape adhesive has an operating temperature range from -55°C to +200°C and resists solvents and fluids commonly found in aerospace and defense applications.

TEMPERATURE RANGE

- -55°C to +200°C

PACKAGING

- 3/4 in. x .013 in. x 25 ft. roll
  (20 mm x 0.33 mm x 7.6 m)

SPECIFICATIONS

Raychem RT-1050/29

S1297

Raychem Hot-Melt Adhesive Tape

S1297 is a hot-melt adhesive designed for use with TE's heavy-duty boots and cable entry seals. It is suitable for bonding to various cable jacket substrates including polyethylene, PVC, polychloroprene, and metals such as steel and aluminum.

APPLICATION

CES, CSGA cable entry seals, SST-FR

TEMPERATURE RANGE

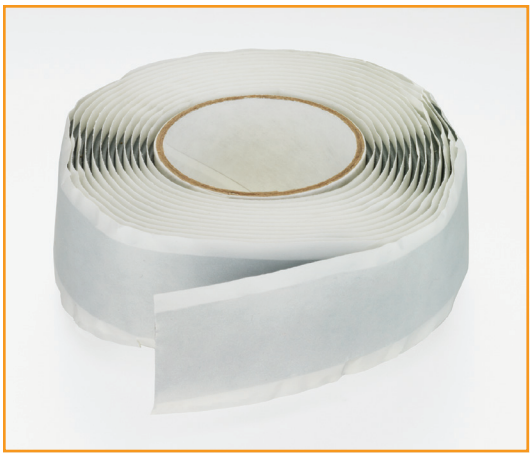
- -20°C to +90°C

PACKAGING

- 1 in x .010 in. x 10 ft roll
  (25.4 mm x 0.3 mm x 3 m)

SPECIFICATIONS

Raychem RW-2019



S1278

Raychem General-Purpose Cold-Applied Sealant Tape

S1278 is a cold-applied butyl sealant designed for use with TE's heavy-duty breakout molded parts to offer excellent water sealing and weatherproofing. Specify S1278 when fire retardantancy is required.

APPLICATION

General purpose sealant and filler/potting medium for cable breakouts.

TEMPERATURE RANGE

- -40°C to +121°C

PACKAGING

- **S1278-01:** 1 in. x .062 in. x 25 ft. roll (25.4 mm x 1.57 mm x 7.6 m)
- **S1278-02:** 3-3/4 in. x .125 in. x 10 ft. roll (95 mm x 3.18 mm x 3 m)

SPECIFICATIONS

Raychem RW-2020

TE manufactures Raychem adhesives and sealants to accommodate a wide range of applications, materials, and environmental conditions. Raychem adhesives include both thermosets and thermoplastics. Thermosets are curable two-part epoxies or crosslinked elastomers. Thermoplastics are hot-melt adhesives that flow when heated and set when cooled. They reflow when reheated to simplify component repair. TE also manufactures Raychem products that include a thermoplastic adhesive or a mastic-type sealant for water holdout applications. The sealants adhere to non-oily substrates and can be removed where re-entry is necessary.

Selection Guide

To determine the adhesive or sealant most compatible with a Raychem part, you must know the part's product type.

Use the Adhesive/Sealant Selection Table on page 17 to determine a Raychem part's product type and the adhesive/sealant compatible with that type.

Use the Adhesive/Sealant Product Characteristics Table (pages 15 and 16) to be sure the adhesive or sealant has the product characteristics your application requires.

To use the Selection Table, follow these four steps:

1. Under "Substrate Category," find the product material and product name/part number for the Raychem part.
2. Across the top of the table, find the part's product type and dash number.
3. At the intersection of the substrate category (product material/name/part number) and the product type (by designated dash number) you will find the part number for the most compatible adhesive for the Raychem part.
4. See the Adhesive/Sealant Product Characteristics Table to verify the characteristics of the adhesive/sealant you selected.

Note: Users should independently evaluate the suitability of the product for their application. Before ordering, check with TE for most current data.

Adhesive/Sealant Product Characteristics Tables

Product Type	Precoat Designation	Type	Operating Temperature Range	Product Designation	Available Form/ Packaging
			Thermosets		
S1006	—	Epoxy/polyamide two-part paste	-55°C to 135°C [-67°F to 275°F]	S1006 Kit 1	Two 15-gram packs
				S1006 Kit 2	Four 7.5-gram packs
				S1006 Kit A	Ten 3-gram packs
S1009	—	Epoxy/polymercaptan two-part paste	-55°C to 135°C [-67°F to 275°F]	S1009 Kit A	Ten 3-gram packs
				S1009 Kit 8	50-ml dual syringe
S1125	—	Epoxy/polyamide two-part paste	-55°C to 150°C [-67°F to 302°F]	S1125 Kit 1	Five 10-gram packs
				—	—
				S1125 Kit 4	Five 10-gram packs
				S1125 Kit 5	One 10-gram pack
				S1125 Kit 8	50-ml dual syringe
S1184	—	Two-part electrically conductive epoxy/polyamide	-55°C to +150°C [-67°F to +302°F]	S1184 Kit 1	Two 10-ml syringes
S1255-04	—	One-part epoxy tape adhesive	-55°C to 200°C [-67°F to 392°F]	S1255-04	Tape [3/4 in. x .020 x 100 ft.]
S1264	—	Epoxy/polyamide two-part paste	-55°C to 150°C [-67°F to 302°F]	S1264 Kit 1	One 10-gram pack
				S1264 Kit 8	50-ml dual syringe
	/225	Precoated latent-curing epoxy/polyamide	-75°C to 150°C [-103°F to 302°F]	Precoat only on -25 molded parts	—
			Thermoplastics		
S1017	/42	Hot-melt/polyamide	-40°C to 105°C* [-40°F to 221°F]	S1017	Tape [1 in. x .010 in. x 50 ft.]
S1030	/180	Hot-melt/polyolefin	-80°C to 80°C [-112°F to 176°F]	S1030	Tape [3/4 in. x .010 in. x 33 ft.]
S1048	/86	Hot-melt, high performance	-55°C to 120°C [-67°F to 257°F]	S1048	Tape [1 in. x .026 in. x 100 ft.]
S1124	/164	Hot-melt, elastomeric polymer	-55°C to 135°C [-67°F to 302°F]	S1124	Tape [3/4 in. x .018 in.x 10 ft.]
S1260	—	High temperature hot melt fluoropolymer tape adhesive	-55°C to +200°C [-67°F to +464°F]	S1260	Tape [3/4" x .013 in. x 25 ft.]
S1297	/97	Hot-melt/ polyamide adhesive	-20°C to 90°C [-4°F to 194°F]	S1297	Tape [1 in. x .010 in. x 10 ft.]
			Sealants		
S1278	—	Cold-applied butyl sealant	-40°C to 121°C [-40°F to 250°F]	S1278-01	Tape [1 in. x .062 in. x 25 ft.]
				S1278-02	Tape [3-3/4 in. x .125 in. x 10 ft.]

*Passes cold bend at -40°C [-40°F] per RT-4204.

For full details on installation procedures and curing conditions, please refer to the applicable TE Code of Practice or installation document.

Adhesive/Sealant Product Characteristics Tables (Continued)

Product Type	Pot Life at 23°C [73.4°F]	Curing Conditions	Shelf life* at or below 23°C [74°F]	Specifications**	Comments
Thermosets					
S1006	1 hr	96 hr at 20°C [68°F] min. or 1 hr at 120°C [248°F]	1 year Kit 1, 2 2 years Kit A	RT-1006 RK-6612 A-A-56031***	General purpose harnessing adhesive. Not used on fluoroelastomers, silicone or PVDF
S1009	20 min.	24 hr at 20°C [68°F] min. or 1 hr at 95°C [203°F] 45 min. at 120°C [248°F]	2 years 1 year Kit 8	RT-1009	General purpose harnessing adhesive. Not used on fluoroelastomers or silicone
S1255-04	—	50 min. at 150°C [302°F] +3°C/-0°C [+37.4°F/-32°F]	1 year	RT-1014 RT-1255	One-part epoxy tape used with fluoroelastomer harness systems
S1125	—	24 hr at 20°C min. or 1 hr at 85°C [185°F]	18 months	RT-1011 RK-6619 VG-95343	Good fluid-resistant epoxy used with System 25
S1264	90 min.	24 hr at 20°C min. or 1 hr at 85°C [185°F]	18 months	RT-1012	Tested to NBC requirements
/225	90 min.	Cure during installation of molded parts	36 months	VG-95343 RK-6630	Precoated epoxy system for System 25
S1184	1 hr	24 hr at 20°C min. or 1 hr at 80°C [185°F] or 20 mins at 135°C [275°F]	6 months in original packaging	RK-6627 RT-1084	Conductive epoxy adhesive for screened terminations
Thermoplastics					
S1017	—	120°C [248°F]	5 years	RT-1050/1	General purpose harnessing adhesive Standard precoated adhesive for -3 and -4 molded parts
S1030	—	120°C [248°F]	5 years	RT-1050/6 RK-6017	Good low-temperature flexibility Available as a preinstalled tape for molded parts
S1048	—	160°C [320°F]	5 years	RT-1050/3 RK-6626	Requires high temperature to achieve bonding. High service temperature for hot melt
S1124	—	150°C [302°F]	5 years	RT-1050/13	Requires reflowing in an oven at 150°C [302°F] for 90 minutes. Designed to bond to -51 molded parts.
S1260	—	340°C [644°F]	5 years	RT-1050/29	Requires high temperature to achieve bonding. Highest service temperature for hot melt
S1297	—	100°C [212°F]	5 years	RW-2019	General purpose harnessing adhesive Standard precoated adhesive in Sigmaform molded parts, CSGA cable entry seals, and SST-FR heat-shrinkable tubing
Sealants					
S1278	—	N/A	12 years	RW-2020	General purpose sealant and cable breakout area filler

*Shelf life from date of manufacture.
**For specific adhesion properties, see product specification sheets.
***Only S1006 Kit A conforms to A-A-56031.

For full details on installation procedures and curing conditions, please refer to the applicable TE Code of Practice or installation document.

Adhesive/Sealant Selection Table

Substrate Category	Product Name Examples	Molded Part Material Dash Number										
		-3	-4	-12	-25	-50	-51	-55	-71	-100	-125	-130
Polyolefin	RNF-100	S1006	S1006	—	—	—	—	—	S1006	—	—	S1006
	Versafit	S1009	S1009	—	—	—	—	—	S1009	—	—	S1009
	CRN	S1017	S1017	—	—	—	—	—	S1017	—	—	S1017
	BSTS	S1030	S1030	—	—	—	—	—	S1030	—	—	—
	SST	S1048	S1048	—	—	—	—	—	S1048	—	—	—
	HR	S1297	S1297	—	—	—	—	—	S1297	—	—	—
Fluoro-polymer**	PVDF	S1009	S1009	—	S1125	—	—	—	S1009	—	S1009	—
		S1048	S1048	—	—	—	—	—	S1048	—	S1048	—
		S1125	S1125	—	—	—	—	—	S1125	—	S1125	—
	RT-555	—	—	S1260	—	—	—	S1260	—	—	S1260	—
	HCTE	—	—	S1255-04	S1125	—	—	S1255-04	—	—	—	—
	Convolex	—	—	—	S1125	—	—	—	—	—	—	—
Vinyl	PVC	S1006	S1006	—	—	—	—	—	S1006	—	—	—
		S1009	S1009	—	—	—	—	—	S1009	—	—	—
			S1017	—	—	—	—	—	S1017	—	—	—
Elastomer***	DR-25	S1048	S1048	—	S1125	S1125	S1125	—	—	—	—	—
	NT	S1006	S1006	—	—	—	S1124	—	S1006	—	—	—
		S1009	S1009	—	—	—	—	—	S1009	—	—	—
		S1017	S1017	—	—	—	—	—	S1017	—	—	—
	NTFR	—	—	—	S1125	—	S1124	—	—	—	—	—
	SFR*	—	—	—	—	—	—	—	—	—	—	—
	SRFR*	—	—	—	—	—	—	—	—	—	—	—
	RW-200	—	—	S1260	—	—	—	S1260	—	—	S1260	—
	VPB	—	—	—	—	S1125	—	—	—	—	—	—
			—	—	—	S1255-04	—	—	—	—	—	—
Zerohal	XFFR	—	—	—	—	—	—	—	—	S1030	—	—
	ZHTM	—	—	—	—	—	—	—	—	S1030	—	—

*GE RTV 108 used with SFR and SRFR.
**E.g. PFA, FEP, PTFE
***E.g. Polyurethane, Neoprene

Substrate Category	Product Name Examples	Molded Part Material Dash Number		
		-770	-780	-790
Nuclear Fluoropolymers	RT770	S1264	—	—
	RT780	—	S1255-04	—
	RT790	—	—	S1255-04

Substrate Preparation Procedures

Preparation of the substrate depends on the part to be bonded. Following are two preparation procedures. The first applies to plated metals and adapters; the second applies to polymer molded parts, cable jackets, and tubing materials.

For full details on installation procedures and curing conditions, please refer to the applicable TE Code of Practice or installation document.

Note:

- Avoid contamination of the prepared surface. If using primer, apply it according to the manufacturer's instructions and allow it to dry.
- Epoxy adhesives may cause skin and eye irritation. Be sure to observe the handling instructions.
- When using hot-melt adhesives on substrates with high heat-sink capacity (such as connector backshells), preheat the substrate until it is hot to touch, then apply the adhesive tape and shrink the molded part in place.

Caution:

The use of cleaning solvent is described in the preparation of various components for adhesive bonding. Please observe the solvent manufacturer's safety recommendations. Several Raychem epoxy adhesives and solvent base primers are also described in some cases. For specific handling precautions, please consult the appropriate Raychem material safety data sheet for the adhesive being used.

Installation Guide

Installation Procedures

Preparation of the substrate depends on the part to be bonded.

Following are two preparation procedures. The first applies to plated metals and adapters; the second applies to polymer molded parts, cable jackets, and tubing materials.

Bonding between molded parts, plated metals and adapters

To ensure the best possible bond between a molded part and plated materials and adapters, degrease the end of the molded part which will recover onto the plated metal or adaptor with isopropyl alcohol or isopropanol (IPA) impregnated tissue wipe. NEVER abrade plated metals and adapters.

Where preheating of the plated metal or adapter is judged to be necessary for large and high heat sink terminations, care must be taken to ensure the connector insulation and primary wire insulation are not damaged. Ensure heat is directed to the metal area and all other areas are avoided. TE cannot be held responsible for damage caused during the preheating of plated metals or adapters.

Bonding between molded parts, cable jackets and tubing materials

To ensure the best possible bond between the molded part, cable jacket or tubing, degrease the cable jacket in the area where the molded part will recover onto the cable using Isopropyl alcohol. (approximately 30 mm). Abrade the cable jacket thoroughly in the same area with 100 grit emery cloth. The whole surface of the cable jacket should be abraded, removing any print on the cable jacket. Remove loose particles from the abraded area using a dry tissue. DO NOT use a solvent wipe.

Ensure sufficient cable jacket has been abraded to incorporate the strip length requirement. Degrease the inner area of the molded part at each end thoroughly (approximately 30 mm) using Isopropyl alcohol. Abrade the inner area of the molded part at each end thoroughly (approximately 30 mm) with 100 grit emery cloth. Remove loose particles from the abraded area using a dry tissue. DO NOT use a solvent wipe.

Installation of heat shrink molded parts

For the installation of the wide range of TE heat shrink molded parts including straight, 45°, 90° and transitions, refer to the appropriate Code of Practice Installation Procedures.

Installation of adhesives

For details of installation of the wide range of TE adhesives including epoxy, hot melt, tapes and pre-installed options, refer to the appropriate Code of Practice Installation Procedures.

These Codes of Practice include information such as recommended tooling, installation temperatures, curing cycles and visual standards.

Health and safety

Adhere to local Codes and Regulations relating to Safe Working practices.

The installation should be carried out in a well ventilated area. Always wear heat-resistant safety gloves when handling hot plastics and adhesives. 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. For specific handling precautions please consult appropriate TE material safety data sheet for adhesive being used.

Storage Conditions

It is recommended that Raychem brand adhesives should be stored in the original unopened containers, out of direct sunlight and at temperatures not exceeding 25°C, unless otherwise noted. These are guidelines only and test data cannot be provided to validate these.