



SERIES 77 Heat Shrink Boots



Installation Temperatures and Shrink Boot Adhesive Shelf Life



Heat Shrinkable Boot Installation Temperatures

Heat Shrink Boots are usually installed with a hot air gun. The temperature that the material must reach to cause the boots to shrink is given below. It should be noted that excess temperatures can cause the material to blister and smoke. Excessive temperature do not cause the boots to shrink faster, the rate determining step is the thermal transfer through the body of the part. Boots with large thick sections require more time for the boot to reach shrink temperature. Applying hotter than recommended air will cause damage to the boot.

MATERIAL	MINIMUM TEMPERATURE	RECOMMENDED TEMPERATURE
Type 1	135°C (275°F)	175°C (350°F)
Type 2	120°C (250°F)	150°C (300°F)
Type 3	120°C (250°F)	150°C (300°F)
Type 5	135°C (275°F)	175°C (350°F)
Type 6	135°C (275°F)	150°C (300°F)
Type 7	120°C (250°F)	150°C (300°F)
Type 8	135°C (275°F)	175°C (350°F)
Type 9	70°C (160°F)	100°C (210°F)

Heat Shrink Boot Adhesive Shelf Life

Glenair offers a range of adhesives to be used with the Series 77 Shrink Boots and these are a pre-coated 150°C epoxy adhesive type "R", three pre-coated hot melt adhesives "W1", "W2" and "W3" and a two part epoxy "779-001".

Shelf life has been determined because types "R", "W1" and "779-001" adhesives meet the requirements of German VG standards to which the systems have been qualified to. The "R" pre coated adhesive is qualified to VG 95343-18 and this specifies a 3 year shelf life for the adhesive coated heat shrink boot.

The "W1" pre coated adhesive is qualified to VG 95342-29 and this specifies 5 year shelf life for the adhesive coated heat shrink boot.

The two part epoxy "779-001" meets the requirements of VG 95345-15 and this specifies 2 year shelf life.

"W2" pre coated adhesive meets the requirements of the EN 62328 that gives a minimum life of 2 years, however Glenair testing shows it will meet the 5 years shelf life of "W1" adhesive.

"W3" pre coated adhesive is qualified to the TACOM Part No 12287273 but this does not specify shelf life. Glenair testing shows the material exceeds 5 years shelf life.

As such all adhesive pre-coated heat shrink boots using "R", have a 3 year shelf life. Boots coated with "W1", "W2" and "W3" have a 5 year shelf life as does the "W4" tape. The two part epoxy 779-001 has an 18 months shelf life.

The times given for each material are from when the customer receives the pre coated parts or the adhesive. The parts may have other codes on the packaging indicating dates when the parts were either packed or manufactured. However this does not change the shelf life specified by Glenair which applies from when the parts are shipped. During any holding time the parts are held, the storage conditions are strictly controlled.