



SERIES 77 Shrink Boots



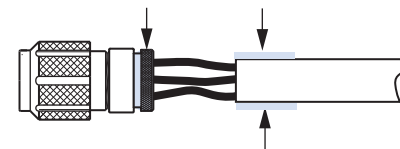
Heat Shrink Boot with 'R' Pre-Coat Adhesive Epoxy Installation Guide

INSTALLATION OF HEAT SHRINK BOOTS WITH 'R' PRE-COATED, HOT MELT EPOXY ADHESIVE

The following instructions apply to Type 1, 2 and 5 material heat shrink boots with 'R' epoxy. These boots are pre-coated at the factory.

Surface Preparation

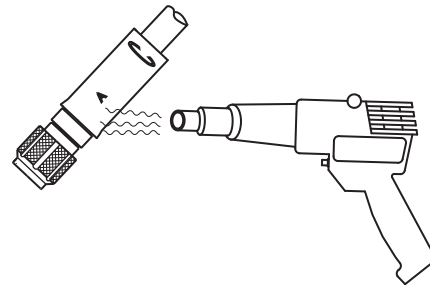
1. No preparation of the heat shrink boot is required.
2. Degrease the adapter using isopropyl alcohol or IPA impregnated wipes.
2. Abrade the cable jacket thoroughly with 100 grit emery cloth in the region where the part will recover. Remove loose particles with a dry tissue.



CLEAN ADAPTER
AND ABRADE CABLE

Installation

1. Set heat gun temperature to 230-250°C (446°-482°F), measured at 25mm (1") from the nozzle exit.
2. Allow the heat gun 2 minutes to stabilize.
3. Recover boot in accordance with the general installation procedures, except as follows:
 - Do not apply hot air directly onto the adhesive lining of the boot as this may cause premature curing of the epoxy.
 - After the boot has been recovered remove any excess adhesive with a tissue.
 - Apply a post heat period of 2 minutes to both the "A" and "C" end to ensure full cure of the adhesive.



Post Installation and Inspection

1. Allow the part two hours before the inspection stage; however, once the part has cooled the harness can be handled with care.
2. Joints should be inspected per the General Installation Guide.
3. When inspecting boots with Type R epoxy pre-coat, it is acceptable to see a slight opening on the extreme edge of the cable to a maximum of 1mm (.040").

