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Raychem

Specification	**RT-1050/1**
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THERMOFIT® ADHESIVE AND SEALANT
THERMOFIT S-1017

Thermofit S-1017 thermoplastic adhesive was developed for use with Thermofit heat-shrinkable products where the molded part or tubing is precoated with adhesive on the bonding area. This adhesive is tough and flexible and bonds to polyolefins, vinyls, neoprene, lead, and many other metals such as steel and aluminum.

PROPERTY	UNIT	REQUIREMENT	METHOD OF TEST
PHYSICAL			
Visual		Pass	Section 4.3.1.1
Specific Gravity		0.95 ± .05	Section 4.3.1.2 ASTM D 792
Viscosity, at 191° C	centiposie	9000 ± 3000	Section 4.3.1.3.2 ASTM D 1084 Method B
Softening Point	C	120 ± 10	E28
Low Temperature Impact Brittleness	C	-20 max	4.3.1.7, ASTM D 746
Blocking (Cohesive @ 55° C)		Pass	4.3.1.8 ASTM D 1146
Adhesive Peel*	Pounds/inch width		Section 4.3.1.9
Polyethylene		20 minimum	
Lead		5 minimum	
Neoprene		10 minimum	
PVC		30 minimum	
Steel		15 minimum	
CHEMICAL			
Water Absorption	Percent	1.0 maximum	Section 4.3.2.1 ASTM D 570
Corrosive Effect 16 hours at 121° C *(250° F)*		Pass	Section 4.3.2.2 ASTM D 2671 Method B
Environmental Stress-Cracking 48 hours at 50° C		Pass	Section 4.3.2.3 ASTM D 1693
Environmental Stress-Cracking of Substrate 30 days at 50° C		Pass	Section 4.3.2.4 ASTM D 1693
Fungus Resistance		Rating of 1 or less	Section 4.3.2.5 ASTM G 21

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Solvent and Fluid Resistance Weight change after 24 hours at 23° C *(74° F):* Detergent Solution (#12) Hydraulic Fluid (MIL-H-5606) Lube Oil (Mil-L-7808) ASTM Oil (#49)	Percent	3 maximum 10 maximum 5 maximum 15 maximum	Section 4.3.2.6 ASTM D 543
ELECTRICAL			
Volume Resistivity	ohm-cm	10^{10} min	Section 4.3.3.1 ASTM D 257
Dielectric Strength	volts/mil	500 min	Section 4.3.3.2 ASTM D 149

Molding temperature for 4.2.1.1 shall be 149° C (*300 °F).*
Acceptance Tests: Visual, Viscosity, Peel (Steel)

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