



Tyco Electronics Corporation
300 Constitution Drive
Menlo Park, CA 94025 USA

Raychem

Specification
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Replaces:

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Issue 1

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

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)