



SERIES 77 Shrink Boots



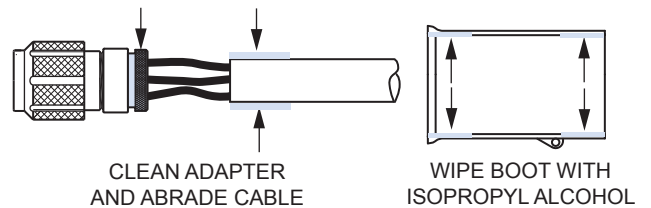
Heat Shrink Boot with 'U' Two Part Epoxy Adhesive Installation Guide

INSTALLATION OF HEAT SHRINK BOOTS WITH USER-INSTALLED TWO PART EPOXY ADHESIVE

Glenair two part epoxy is compatible with all Glenair material Type 1 thru 9. Part number 779-001 duo syringe, 779-002 dispensing gun and 779-003 mixing nozzle are recommended. Epoxy complies with BS G 198 Type U, EC 62329 and VG 95343 Part 15, SAE AS5258 Code 4, and approved to TACOM 12347278 Rev B. Only adhesives that meet the requirements of these specifications are recommended.

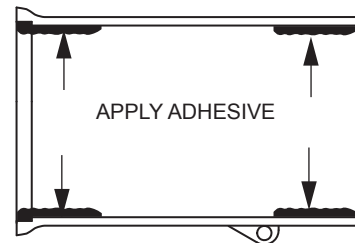
Surface Preparation

1. Prepare the inside of the boot in the areas where it will adhere to the adapter and cable jacket by degreasing with 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.



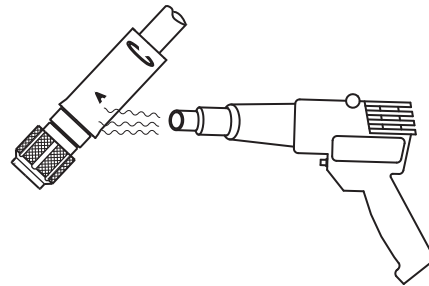
Adhesive Application

1. Prepare adhesive in accordance with the instructions supplied with the adhesive.
2. Apply adhesive to both the "A" and "C" ends of the boot. It is recommended to dispense the adhesive directly onto the surface of the boot. Smooth out the adhesive using a suitable wooden mixing stick.



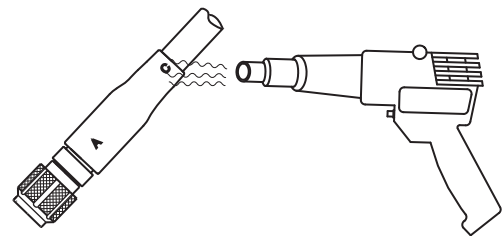
Installation

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.



Post Installation

1. Remove any excess adhesive using a dry tissue.
2. Apply a few seconds of additional heat to the "C" end to force a small amount of adhesive to flow and form a fillet between the boot and cable jacket. If necessary smooth fillet with a wooden mixing stick.



Curing Schedule

12 hours at room temperature, 2 hours at 70°C (158°F), 1 hour at 85°C (185°F), 30 minutes at 150°C (302°F).