

PROCEDURE

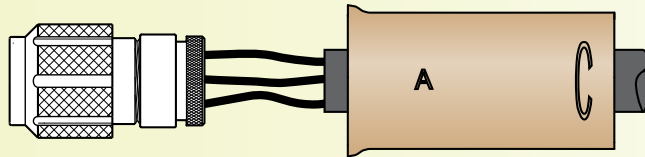
The following general instructions are applicable to all Glenair heatshrink boots. Specific instructions for surface preparation, the use of adhesive and specific conditions for each molding material are given in the relevant sections following these general instructions.

APPLICATION NOTE

When preheating of a connector or adaptor is required because of size then care should be taken not to damage any insulation or plastic material on either the connector or the wire insulation. Heat should only be applied to metal areas. **DO NOT PREHEAT COMPOSITE PARTS.**

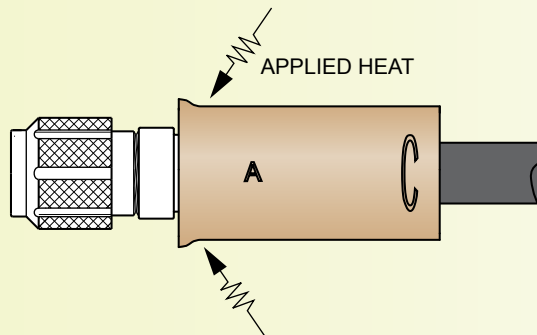
STEP 1: PLACE BOOT ON CABLE

Position the boot so that the lipped "A" end is toward the adapter and the "C" end is toward the cable .



STEP 2: APPLY HEAT TO ADAPTER END OF BOOT

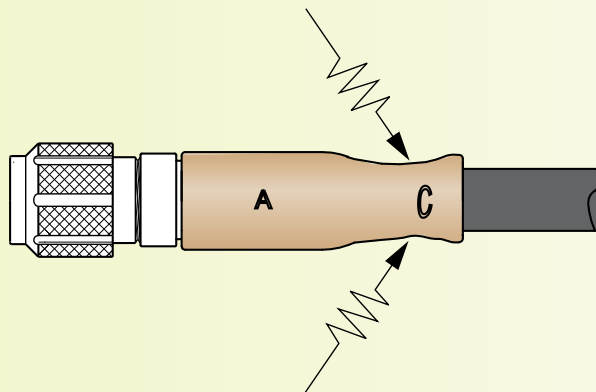
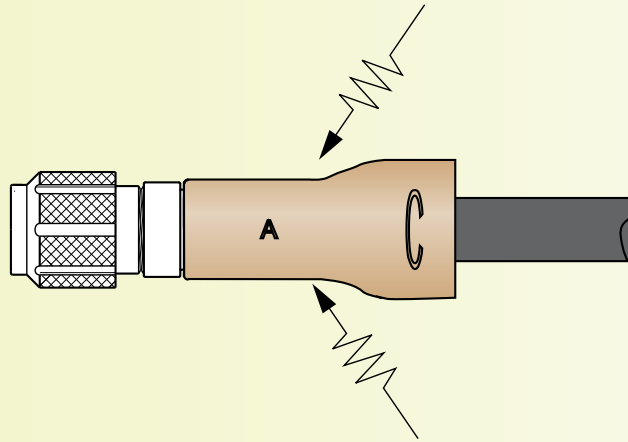
Position the boot so that the lipped "A" end will recover into the groove of the adapter. Apply heat evenly around the boot at the adapter end. Ensure the boot is fully recovered and the lip fits into the groove of the adapter. This will take approximately 30 seconds for a size 04 or 05 boot, less for smaller parts and longer for larger boots.



STEP 3: CONTINUE APPLY HEAT TOWARD THE "C" END OF BOOT

Great care must be taken to ensure the boot is not scorched or blistered or otherwise damaged during this process. The development of a high gloss is an indication that the part is reaching too high a temperature.

Continue to heat down the body of the boot towards the "C" end. Apply heat in brush-like strokes, ensuring the last part to recover is the "C" end. A feature of the Glenair boots is that, unlike other boots, they resist the tendency to fold over at the "C" end.

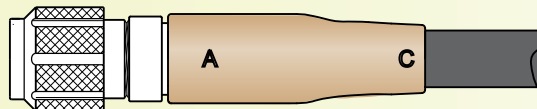


STEP 4: AFTER BOOT IS FULLY RECOVERED, APPLY FURTHER HEAT TO "A" END

After the boot is fully recovered, apply additional heat to the "A" and "C" ends to ensure adhesive melting and good adhesion. Typically this post heating will require 90-150 seconds depending on size. Care should be taken to avoid damaging the boot with excessive heat. Allow the parts to fully cool before handling.

CAUTION

The recovered parts will remain hot for some time and will be capable of burning skin if touched. Molten adhesive may also cause burns and adhere to exposed skin.



STEP 5: INSPECTION OF INSTALLED HEATSHRINK BOOT

1. The boot should be free of blisters, scorch marks and essentially free from distortion.
2. Any excessive adhesive should be removed.
3. The boot lip should be seated into the adapter groove, and the boot should be properly oriented.
4. A small fillet of adhesive should be visible between the boot and the cable jacket.
5. The termination should be subjected to a 90° flex test in each of the four planes around a mandrel with a diameter equal to 6X the cable diameter. Note: this is a flex test and not subjected to a tensile force. The joint should not be flexed until the boot has fully cooled and the adhesive cured.

