

Service temperature  
range -55°C to +120°C



Raychem S1005 thermosetting, low viscosity, two-part epoxy polyamide adhesive is supplied in polythene bottles and can be mixed by volume or weight. One bottle contains Part A, the pale yellow epoxy and the other bottle contains Part B, the polyamide hardener which is amber.

Raychem S1006 thermosetting, flexible high viscosity, two-part epoxy polyamide adhesive is supplied in a bi-pack to eliminate mixing ratio errors, S1006 consists of an epoxy resin that is pale yellow and a polyamide hardener which is amber.

S1005/S1006 are excellent adhesives for many substrates including Raychem polyolefin tubings, Raychem moulded parts and adaptors, aluminium alloy standard connector end fittings and other metals including mild steel, brass and copper.

**Two-part epoxy adhesive**

Typical properties		Performance	Test methods
Mechanical	Lap shear strength		
	Aluminium to aluminium	8KN	RK66 11/RK66 12 Clause 3.1.1
	RNF-100 RNF-100	210N	RK66 11/RK66 12 Clause 3.1.2
Chemical	Fluid resistance		
	Hydraulic fluid DTD 900/488 1C	Excellent	Lap shear strength after immersion in fluid for 24 hours at +23°C
	Hydraulic fluid H-5 15	Excellent	
	Water	Excellent	
<b>Specifications</b>	S1005 RK66 11	S1006 RK66 12	

**Installation**

**Surface preparation** The moulded part and cable jacket should be thoroughly degreased using a suitable solvent e.g. Isopropanol following the handling instructions supplied by the solvent supplier. After degreasing, the surfaces should be carefully abraded using a 100 grit abrasive cloth. Dust and other debris from abrasion should be wiped away with a dry tissue. Connectors or adaptors should only be degreased and not abraded.

**Mixing S1005** S1005 adhesive is supplied in two parts A and B. Part A, the epoxy, is pale yellow and Part B, the polyamide hardener, is amber in colour. Care should be taken not to interchange the bottle caps. Measure out one Part A and two Parts B by volume, or two Parts A and three Parts B by weight, taking care that only clean containers are used. Mix the two components thoroughly; any air stirred into the mixture will be eliminated during the shrinking process. After mixing, apply thin uniform layer of adhesive to the substrates.

**Mixing S1006** S1006 is supplied with the epoxy resin and the hardener pre-weighed in two sachets separated by a dividing rail. To mix, slide off the dividing rail and knead the contents until a homogenous translucent pale yellow colour is obtained. After mixing, carefully cut open one corner of the bi-pack. Apply a thin, uniform layer of adhesive to the substrates. For best results adhesive mixed in the dual packs should be squeezed into a separate disposable dish and mixed with a spatula before application to substrates.

**Heating** Apply heat to the heat-shrinkable tubing / moulded part (refer to the Code of Practice No. 605 for full instructions) and when fully recovered, remove any excess adhesive using Isopropanol or similar solvent.

**Handling** For normal handling purposes, the adhesive will be sufficiently cured after 24 hours at room temperature. However, cure cycles above 60°C are recommended as these result in great bond strengths and the joint should not be severely flexed until one of the following cycles has been completed.

- 4 hours at 60°C
- 1 hour at 95°C
- 24 minutes at 120°C

**Pot life** Once mixed S1005/S1006 has a pot life of up to 2 hours depending on the ambient temperatures.

**Shelf life** In excess of 12 months, when stored in the original unopened packaging at or below 23°C.

**Handling precautions** Irritant and dangerous for the environment while in its uncured state. Part B contains Triethylenetetramine. Irritating to eyes and skin. Risk of serious damage to eyes. May cause sensitisation by skin contact. Toxic to aquatic organisms; may cause long-term adverse effects in the aquatic environment

In case of contact with eyes, rinse immediately with plenty of water and seek medical advice. After contact with skin, wash immediately with plenty of water and soap. Wear suitable gloves and eye/face protection. Avoid release to the environment. Refer to safety data sheet. These are available via [www.raychem.com/corporate/partners.asp](http://www.raychem.com/corporate/partners.asp).

**Ordering** S1005: 1 kit contains 2 bottles. 178ml Part B pale yellow  
89ml Part A amber

S1006 Kit 1: 1 kit contains 2 sachets: 15g each  
S1006 Kit 2: 1 kit contains 4 sachets: 7.5g each

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