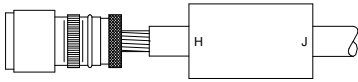


# HellermannTyton

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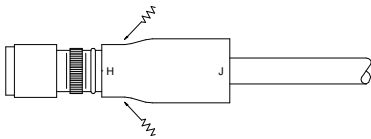
## Installation Instructions for Hot Melt Tape Adhesive – HMT200A

When recovering Hellermann heatshrink shapes individually it is recommended that a hot air gun is used at a setting to give a temperature of between 230°C (446°F) and 250°C (482°F), when measured 25mm from the nozzle.



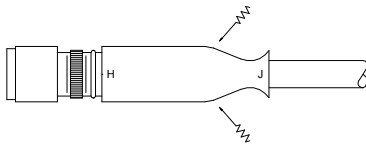
### Step 1 –

- Degrease the bonding area on the cable jacket and the Connector with Hellermann Tis-Wipe.
- Abrade cable area with 100 grit paper.
- Dry wipe with tissue.



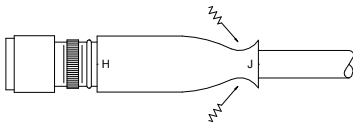
### Step 2

- Wrap the connector evenly with the adhesive tape.
- Apply heat evenly on the shape at the connector end first.
- Locating the rib into the groove



### Step 3

- After 'H' end is recovered wrap the cable with the adhesive tape.
- Continue to apply heat further back to recover the remainder of shape



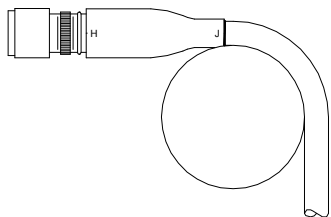
### Step 4

- Apply heat to 'J' end to complete recovery.
- Remove any excess adhesive immediately



### Step 5

- The assembly can be moved once the shape has cooled to ambient temperature.
- Bend testing can be carried out once the shape has cooled to ambient temperature.



### Step 6

- Standard bend test for bond integrity-see diagram
- Bend cable at 'J' end around a mandrel 6x diameter of cable.
- For example, a cable with an overall outer jacket diameter of 10mm would be bent 90° around a mandrel of at least 60mm in diameter

Hellermann recommend the use of suitable protective wear when recovering heat shrinkable shapes i.e. insulating gloves and overalls.

Always recover shapes in a well-ventilated area, do not breathe in any fumes or vapours that may be produced.  
Always allow to cool to ambient temperature to avoid skin burns.