# HellermannTyton

Installation Instructions for VG 95-343 Part 18 Shapes

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. (N.B. products with wall thickness greater than 1.5mm may need higher temperature settings, up to 300°C (572°F))
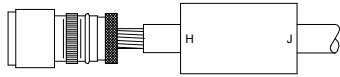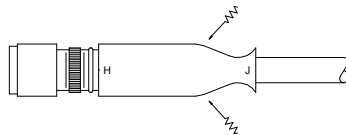

Step 1 –
- Degrease the bonding area on the cable jacket and the Connector with Hellermann Tis-Wipe.
- Abrade cable area with 100 grit paper.
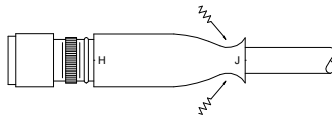- Dry wipe with tissue.
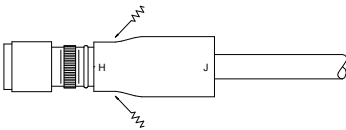
Step 2
- Apply heat evenly on the shape at the connector end first.
- Locating the rib into the groove.

Step 3
- After 'H' end is recovered apply heat further back.
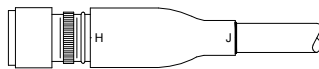- Recover the remainder of shape.

Step 4
- Apply heat to 'J' end to complete recovery.
- Remove any excess adhesive immediately.

DO NOT TWIST OR ADJUST THE POSITION OF THE SHAPE IMMEDIATELY AFTER RECOVERY, WHILST THE SHAPE IS STILL HOT. THIS WILL AFFECT THE BONDING PROCESS AND COULD RESULT IN AN INFERIOR BOND STRENGTH
PLEASE NOTE: NO POST CURE IS REQUIRED

Step 5
- The assembly can be moved once the shape has cooled to ambient temperature.
- Bend testing can be carried out after 24hours.
- Full cure is reached after 7 days.
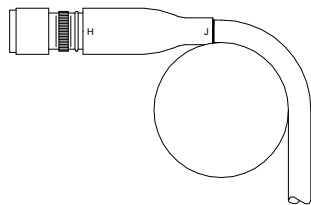
Step 6
- Standard bend test for bond integrity-see diagram.
- Bend cable at 'J' end around a mandrel 6x diameter of cable.
- For example, a cable with an overall outer jacket diameter of 10mm would be bent 90° around a mandrel of at least 60mm in diameter.

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.

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