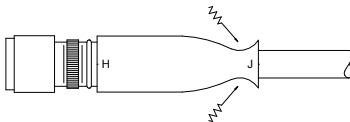
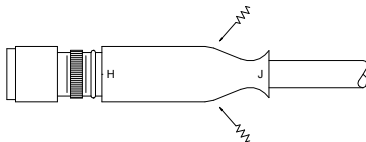
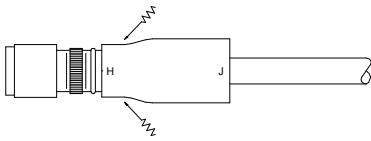
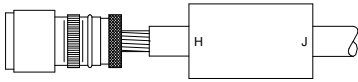


# HellermannTyton

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## Installation Instructions for Hot Melt Tape Adhesive – HMT300A

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 apply heat for a further 60 seconds over the bonding area
- Wrap the cable with the adhesive tape then apply heat further back.
- Recover the remainder of shape

### Step 4

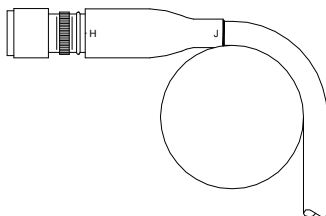
- Apply heat to 'J' end to complete recovery, continue applying heat for a further 60 seconds over the bonding area
- Remove any excess adhesive immediately

**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**



### 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