



Tyco Electronics Corporation
300 Constitution Drive
Menlo Park, CA 94025 USA

Raychem

Specification
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Issue 2

**THERMOFIT® ADHESIVE AND SEALANT
THERMOFIT S-1124**

Thermofit S-1124 is a flexible adhesive based on elastomeric polymers. This adhesive was developed for use with Thermofit heat-shrinkable products, NT, NT-FR, and Elastomeric Polymer Blend (EPB). This adhesive provides good bonds of the heat-shrinkable materials to metals, such as steel and aluminum when bond line is heat to 150 °C (302 °F). The adhesive is supplied as a tape in .75 inch by .018 inch by 100 foot rolls, unless otherwise specified.

PROPERTY	UNIT	REQUIREMENT	METHOD OF TEST
PHYSICAL			
Visual Color		Pass Grey	Section 4.3.1.1
Specific Gravity		1.15 ± .05	Section 4.3.1.2 ASTM D 792
Adhesive Peel* EPB to EPB NT to NT EPB to NT EPB to Aluminum NT to Aluminum	Pounds/inch width	20 minimum 20 minimum 20 minimum 15 minimum 15 minimum	Section 4.3.1.9
CHEMICAL			
Water Absorption	Percent	0.5 maximum	Section 4.3.1.1 ASTM D 570
Corrosive Effect 16 hours at 121 °C (250 °F)		Pass	SECTION 4.3.2.2 ASTM D 2671 Method B
Fungus Resistance		Rating of 1 or less	Section 4.3.2.5 ASTM G 21
Solvent and Fluid Resistance** Weight change after 24 hours at 23 °C (74 °F): Hydraulic Fluid (MIL-H-46170) Aviation Gas (MIL-G-5572) Cleaning Compound (P-C-437) Isopropyl Alcohol (TT-I-735)	Percent	25.0 maximum 30.0 maximum 5.0 maximum 25.0 maximum	Section 4.3.2.6 ASTM D 543

Acceptance Tests: Visual and peel (EPB to EPB).

- * Prepare test specimens per Appendix F (including a solvent wipe) except heat for 30 minutes $150\text{ }^{\circ}\text{C}$ ($302\text{ }^{\circ}\text{F}$). NT or NT-FR may be used where NT is specified.

NT per RT-510
NT-FR per RT-511
EPB per RT-1321

- ** After immersion, specimens shall be lightly wiped and air dried 30 to 60 minutes at $23 + 2\text{ }^{\circ}\text{C}$ ($73 + 4\text{ }^{\circ}\text{F}$).