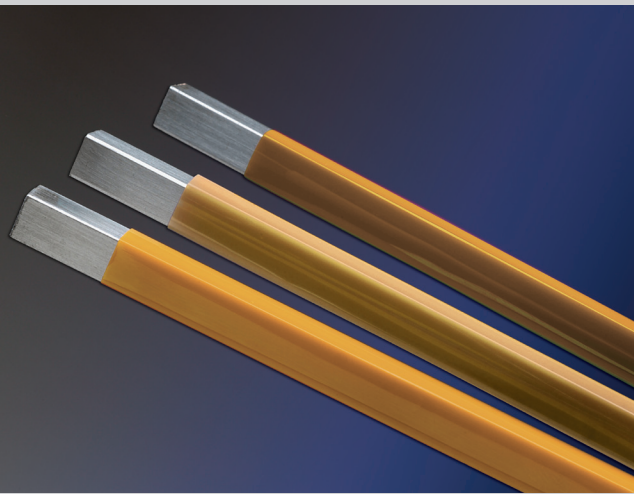


PEEKSHRINK® RECOVERY GUIDE



PEEK SLEEVING RECOVERY OVER SPLICED WIRE

PEEK melts at 650° F/343° C. PEEKshrink® recovery occurs at very near the same temperature. Therefore there is a very fine line between achieving full recovery and melting the product. Equally important in this recovery application is the coating (PEEK, Kapton, and etc.) already surrounding a thermal conductive copper wire.

When using a heat gun to recover shrink sleeving of any kind, it is important that your technique deliver gradually increasing and evenly distributed heat to the location where recovery is desired. The challenge of this process is to fully recover the sleeving so that it bonds with, but does not damage the coating (PEEK, Kapton, and etc.) already on the wire.

For additional information please contact us.

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The heat gun used was a Steinel Electronic Heat Gun Model **HG 2310 LCD**. Several reducer and reflector accessories come standard with this product. The reflector Baffle was used to achieve a surrounding air current in this application.

1 To simulate splice conditions a one inch section of coating was stripped away from the center of a seven inch section of wire. The PEEK sleeving must be applied over one of the two copper wires before they are joined.

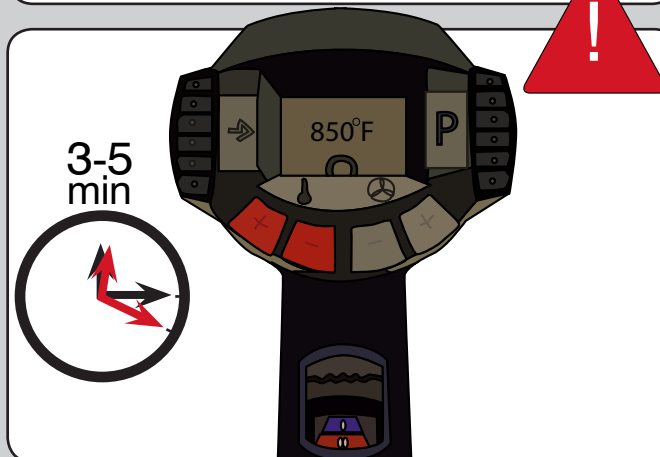


2 The length of the sleeving should allow for each end to extend approximately 2-3 inches past the point where the coating has been stripped away.

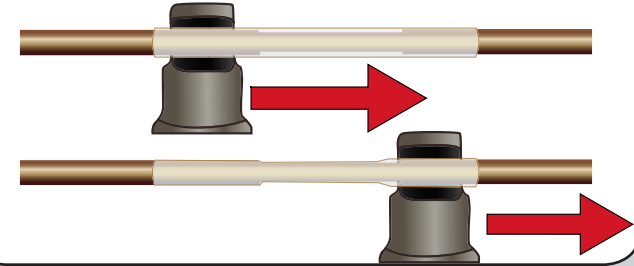


Setting the gun at 850° F/454° C creates an airflow current ranging in temperature from 640° F/338° C to 700° F/371° C in the location of the baffle reflector where the splice will be.

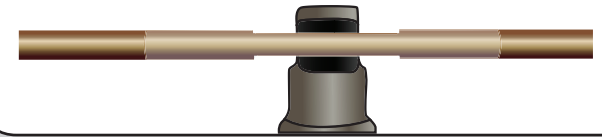
3 The heat gun is fitted with the reflector nozzle and set at 850° F/454° C and maximum fan output. Run the heat gun 3 to 5 minutes to allow temperatures to stabilize.



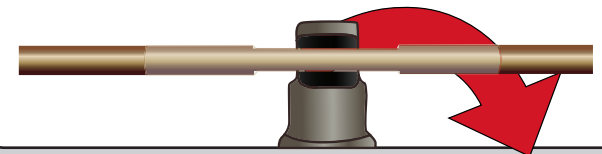
4 Anchor the PEEKshrink on one end and work from there toward the other end. Observe when shrinking occurs and move the heat to the other side to ensure a uniform recovery 360 degrees around the wire. Be aware of the bare coated wire. Too much heat or heat sink in the wire can melt the coating beyond the edges of the sleeve.



5 With the recovery now almost complete, keep in mind it only takes a matter of seconds to properly shrink the PEEKshrink onto the wire. You want the heat to be evenly distributed along the splice area.



6 You should observe a slight color change where coating and sleeving become fused together. When you have observed this, remove the heat source and allow the heat trapped in the wire to complete the recovery.



7 Pay attention to the coated wire beyond the edge of the sleeve for discoloration. This indicates a higher level of crystallization, which will not affect the properties of the PEEK insulation, but may affect the flexibility of the PEEK when bending over a sharp radius.

The following is an examples where the coating began to melt at the edges of the sleeving.



8 The following is an example of a successful recovery.

