**PEEKshrink® Slewing 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 an insulated conductive 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 more information or FREE samples, please contact us.

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**SPlicing RECOVERY GUIDE**

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 **PEEKshrink®** slewing must be applied over one of the two copper wires before they are joined.

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

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 slewing 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 sleeving for discoloration. This indicates a higher level of crystallization, which will not affect the properties of the **PEEKshrink®** insulation, but may affect the flexibility of the **PEEK** when bending over a sharp radius.

The following is an example where the coating began to melt at the edges of the slewing.

8. The following is an example of successful recovery.