

**PIP-061**

**Product Installation Procedure for RNF-100**

**1. Introduction**

The following guidelines are offered for the installation of RNF-100.

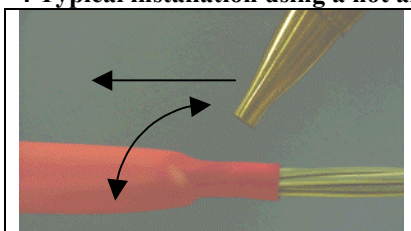
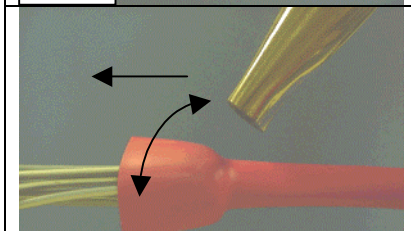
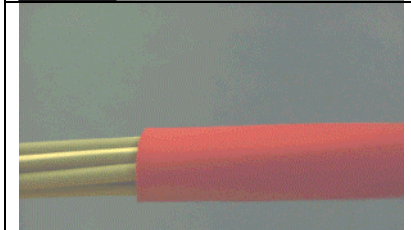
**2. Safety**

It is recommended that local safety regulations are adhered to and that installations are carried out in a well ventilated area with adequate fume extraction. It is further recommended that operators wear heat resistant gloves when installing and handling hot heat shrink products. Avoid contact with molten material and wash hands before eating, drinking or smoking.

**3. General Information**

- 3.1 Refer to the Raychem Safety Data Sheet
- 3.2 Always select the largest size of tube which will shrink snugly onto the substrate. This will maximise the installed wall thickness and provide better protection.
- 3.3 RNF-100 can be shrunk using hot air tools, air circulating ovens or infra red heaters.
- 3.4 RNF-100 will start to shrink at 95°C and full shrinkage can be achieved at 121°C
- 3.5 Higher temperatures can be used but the time and temperature required to fully shrink the tubing will depend on the sensitivity of the substrate to heat input.
- 3.6 It is important to concentrate the applied heat directly onto the tubing if the substrate is sensitive to heat input. Apply the heat uniformly and in a progressive manner along the length of the tubing to be installed to reduce the possibility of air entrapment.
- 3.7 Installations should be allowed to cool naturally to room temperature prior to handling.

**4 Typical installation using a hot air gun**

 <p>Fig 1</p>	<ol style="list-style-type: none"> <li>1. Select the largest size of tubing which will fit snugly onto the substrate when fully shrunk.</li> <li>2. Carefully cut the tubing to the required length using sharp scissors or other suitable cutting equipment ensuring the cut edges are clean and free from burrs.</li> <li>3. Locate the tubing into place on the substrate e.g. wire bundle.</li> <li>4. Start to shrink the tubing starting from one end of the assembly. See figure 1.</li> <li>5. Work progressively to the end of the tubing ensuring uniform heat application. This can be achieved by either rotating the assembly or the heat gun. See figure 2.</li> <li>6. Ensure the end of the heat gun does not touch the exterior of the tubing otherwise splitting may occur.</li> <li>7. Avoid overheating the product after shrinkage has occurred. Stop heating immediately if the product blisters, chars or shows other signs of degradation. Avoid inhaling fumes which may be released and ventilate the area thoroughly before resuming work.</li> <li>8. The completed assembly should be free from cold spots and wrinkles and conform to the shape of the substrate. See figure 3.</li> </ol>
 <p>Fig 2</p>	
 <p>Fig 3</p>	

Note: For installations with other types of equipment please consult your Tyco representative.