

# Adhesives Selection Guide

Adhesives and Sealants That Accommodate  
a Wide Range of Applications, Materials, and  
Environmental Conditions



## S1006

### Raychem Two-Part Epoxy Adhesive

S1006 flexible high-viscosity, two-part epoxy is supplied in a bi-pack to ensure correct mixing. S1006 consists of a pale yellow epoxy resin and an amber hardener.

#### APPLICATION

S1006 is an excellent adhesive for many substrates including:

- Polyolefin tubing
- Heat shrink polyolefin molded parts
- Aluminum alloy adapters and connector end fittings
- Mild steel, brass and copper
- Raychem RNF-100 heat-shrink tubing
- Raychem Versafit heat-shrink tubing
- Raychem CRN heat-shrink tubing
- Raychem NT and NTFR heat-shrink tubing
- Raychem -3, -4, and -71 molded parts

#### TEMPERATURE RANGE

- -55°C to +135°C

#### PACKAGING

- **S1006 Kit 1:** 2 sachets, 15 g each
- **S1006 Kit 2:** 4 sachets, 7.5 g each
- **S1006 Kit A:** 10 sachets, 3 g each  
(Kit A is Mil-Spec certified)

#### SPECIFICATIONS

Raychem RT-1006  
Raychem RK-6612  
A-A56031

## TE Components . . . TE Technology . . . TE Know-how . . .

AMP | AGASTAT | CII | HARTMAN | KILOVAC | MICRODOT | NANONICS | POLAMCO | Raychem | Rochester | DEUTSCH  
SEACON Phoenix | Phoenix Optix | AFP | SEACON

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## S1009

### Raychem Two-Part Modified Epoxy Adhesive

S1009 adhesive is a two-part modified epoxy that provides an environmental seal that is flexible, watertight, low outgassing, and permanent in a variety of applications, including space equipment and vehicles.

#### APPLICATION

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The adhesive is specifically formulated for use with TE polyolefin tubing, such as

- Raychem RNF-100 heat-shrink tubing
- Raychem RT-218 and RT-220 heat-shrink tubing
- Raychem Versafit heat-shrink tubing
- Raychem CRN heat-shrink tubing
- Raychem NT and NTFR heat-shrink tubing
- Raychem -3, -4, and -71 molded parts

S1009 adhesive also bonds well to PVC tubing.

#### TEMPERATURE RANGE

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- -55°C to +135°C

#### PACKAGING

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- **S1009 Kit A:** 10 sachets, 3 g each

#### SPECIFICATIONS

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Raychem RT-1009



## S1125

### Raychem Chemical and Heat-Resistant Adhesive

S1125 high performance adhesive has been developed to match the superior chemical and heat resistance properties of DR-25 heat-shrinkable tubing and -25 heat-shrinkable molded parts. The adhesive forms the third member of the System 25 product trio and has low outgassing.

#### APPLICATION

Although developed for Raychem System 25 cable harnessing products range, S1125 is an excellent adhesive for many other substrates including:

- Raychem RNF-100 heat-shrink tubing
- Raychem Versafit heat-shrink tubing
- Raychem CRN heat-shrink tubing
- Raychem Convolex and HCTE convoluted tubing
- Raychem -3, -4, -12 and -100 molded parts
- Raychem System 100 components
- Aluminum alloy adapters and connector fittings

#### TEMPERATURE RANGE

- -55°C to +150°C

#### PACKAGING

- **S1125 Kit 1:** 5 sachets, 10 g each + accessories
- **S1125 Kit 4:** 5 sachets, 10 g each
- **S1125 Kit 5:** 1 sachet, 10 g
- **S1125 Kit 8:** One 50 ml dual syringe + 3 mixing nozzles, 5 mixing sticks, 5 abrasive, and 1 installation leaflet

#### SPECIFICATIONS

Raychem RT-1011  
Raychem RK-6619  
DIN VG-95343  
NASA SP-R-022A



## S1184

### Raychem Highly Conductive Termination Adhesive

Raychem S1184 highly conductive silver-loaded termination adhesive has been developed to terminate Raychem moulded shapes. Its excellent conductivity enables very high shielding levels of Raychem screened molded shapes, multicore cables, braided cables and adaptors to be combined to form efficient, totally screened harness systems.

#### APPLICATION

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Raychem S1184 two part epoxy adhesive is designed to make termination which can withstand high temperatures and aggressive solvents and fuels. When mixed and installed in conjunction with Rayaten heat-shrinkable parts, S1184 will continue to cure at room temperature reaching full cure after 24 hours. Pot life after mixing is approximately 1 hour.

#### TEMPERATURE RANGE

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- -55°C to +150°C

#### PACKAGING

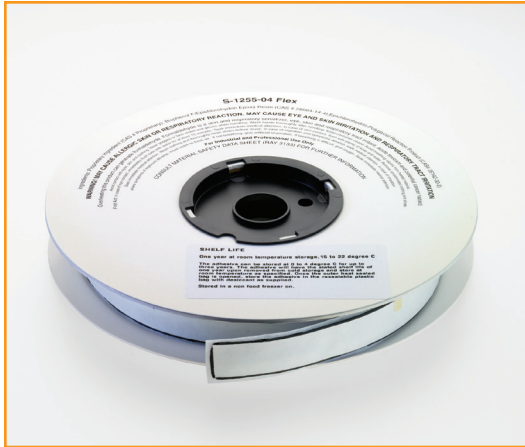
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- **S1184 Kit 1:** Two 10 ml syringes

#### SPECIFICATIONS

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Raychem RK-6627



## S1255-04 Raychem Adhesive Tape

S1255-04 one-part epoxy tape has been developed to match the superior chemical and heat resistance properties of TE's Raychem System 200, 300, 780 and 790.

### APPLICATION

Developed originally to match the +200°C temperature performance of Raychem System 200 components. S1255-04 also offers resistance to the effects of nuclear, biological and chemical agent exposure and decontamination when used with other compatible components.

- Raychem System 200 fluoroelastomeric tubing and molded parts
- Raychem System 300 fluoropolymer tubing and -55 molded parts
- Raychem System 780 fluoroelastomeric tubing and molded parts
- Raychem System 790 fluoropolymer tubing and molded parts
- NBCCS resistant

### TEMPERATURE RANGE

- -55°C to +200°C

### PACKAGING

- 3/4 in. x .020 in. x 100 ft. roll  
(20 mm x 0.5 mm x 30 m)

### SPECIFICATIONS

Raychem RT-1255  
Raychem RT-1014



## S1264

### Raychem NBCCS\* Adhesive

S1264 high performance adhesive has been developed to match the superior chemical and heat resistance properties of TE's Raychem System 770. The adhesive material has been hardened to withstand the damaging effect of NBC contamination and decontamination washdowns.

#### APPLICATION

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S1264 adhesive is suitable for use in wire harness systems requiring resistance to the effects of nuclear, biological and chemical agent exposure and decontamination when used with other NBC compatible components. S1264 will adhere to

- Raychem DR-25 heat-shrink tubing
- Raychem -25 molded parts
- Raychem FDR cable jackets
- Raychem RT-770 tubing and -770 molded parts
- Raychem RT-780 tubing and -780 molded parts

#### TEMPERATURE RANGE

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- -55°C to +150°C

#### PACKAGING

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- **S1264 Kit 1:** 1 sachet, 10 g
- **S1264 Kit 8:** One 50 ml dual syringe, 5 mixing sticks, 5 abrasives, and 1 installation leaflet

#### SPECIFICATIONS

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Raychem RT-1012

\*Nuclear, biological, chemical contamination survivable