



HIGH TEMPERATURE

FUSION SPLICE PROTECTION SLEEVES

HEAT SHRINK PROCEDURE USING HEAT GUN

Please note that conventional splicer heating ovens may also be used provided they can be adjusted to meet the parameters that are indicated below. For best results, a very gradual temperature ramp up of about 120 seconds until the temperature range below is met, followed by a 30 second cool down period is recommended.

NOTE: A variable heat gun must be used with heat deflector installed at the end of the nozzle.

- Set gun temperature range between 165 and 185 degrees C
- Position splice sleeve between end of heat gun nozzle and heat deflector. *Note:* Avoid directly contacting sleeve with heat gun.
- Begin heating at the center area of the splice sleeve.
- Fully shrink sleeve at this point, then move heat gun to each end of the sleeve.
Note: Bubbles may form during this operation which will begin to dissipate during the cool down period.
- Pass heat gun over entire sleeve in a rapid motion back and forth assuring that the entire assembly is completely heat shrunk.
- Allow sleeve to cool down for at least one minute before handling. You may use the heat gun on “cool” to speed up the cool down process.
- The finished sleeve should be completely shrunk and free of any bubbles that can be seen with the naked eye.

