

Adhesives

Selection guide

To determine the adhesive or sealant most compatible with a Raychem part, you must know the part's product type.

Use the Adhesive/Sealant Selection Table (page 5-1) to determine a Raychem part's product type and the adhesive/sealant compatible with that type.

Use the Adhesive/Sealant Product Characteristics Table (pages 5-2 and 5-3) to be sure the adhesive or sealant has the product characteristics your application requires.

Adhesives

Adhesive/sealant selection table

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To use the Selection Table, follow these four steps:

1. Under "Substrate Category," find the product material and product name/part number for the Raychem part.
2. Across the top of the table, find the part's product type and dash number.
3. At the intersection of the substrate category (product material/name/part number) and the product type (by designated dash number) you will find the part number for the most compatible adhesive for the Raychem part.
4. Turn to the Adhesive/Sealant Product Characteristics Table (page 5-2) to verify the characteristics of the adhesive/sealant you selected.

Adhesive/sealant selection table

Substrate Category	Product name examples	Molded part material dash number												
		-3	-4	-6	-8	-12	-25	-50	-51	-55	-71	-100	-125	-130
Polyolefin	RNF-100	S-1006	S-1006									S-1006		S-1006
	Versafit	S-1009	S-1009									S-1009		S-1009
	CRN	S-1017	S-1017									S-1017		S-1017
	BSTS	S-1030	S-1030									S-1030		
	SST	S-1048	S-1048									S-1048		
	HR	S-1298	S-1297									S-1297		
Fluoro-polymer	Kynar	S-1009	S-1009		S-1009	S-1125					S-1009		S-1009	
		S-1048	S-1048								S-1048		S-1048	
		S-1125	S-1125								S-1125		S-1125	
	RT555				S-1255				S-1255			S-1255		
	HCTE				S-1255	S-1125			S-1255					
CONVOLEX				S-1125				S-1125						
Vinyl	PVC	S-1006	S-1006								S-1006			
		S-1009	S-1009								S-1009			
		S-1017	S-1017								S-1017			
Elastomer	DR-25					S-1125	S-1125	S-1125						
	NT	S-1006	S-1006					S-1124			S-1006			
		S-1009	S-1009								S-1009			
		S-1017	S-1017								S-1017			
	NT-FR					S-1125		S-1124						
	SFR													
	SRFR													
	VITON					S-1255				S-1255		S-1255		
Zerohal	XFFR												S-1030	
	ZHTM												S-1030	

*GE RTV 108 used with SFR SRFR and -6 (silicone) molded parts.

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Adhesive/sealant product characteristics table

Adhesive/sealant product characteristics table					
Product type	Precoat designation	Type	Operating temperature range	Product designation	Available form/ packaging
Thermosets					
S-1006		Epoxy/polyamide two-part paste	-55°C to 135°C	S-1006 Kit 1 S-1006 Kit 2	Two x 15-gram packs Four x 7.5-gram packs
S-1009		Epoxy/polymercaptan two-part paste	-55°C to 135°C	S-1006 Kit A S-1009 Kit A	Ten 3-gram packs Ten 3-gram packs
S-1255-04		One-part epoxy tape adhesive	-55°C to 200°C	S-1255-04	Tape (3/4" x .020" x 100')
S-1125		Epoxy/polyamide two-part paste	-55°C to 150°C	S-1125 Kit 1 S-1125 Kit 2 S-1125 Kit 3 S-1125 Kit 4 S-1125 Kit 5 S-1125 Kit 8	Five 10-gram packs Two 10-gram packs One 100-gram pack Five 10-gram packs One 10-gram pack Two 50-ml syringes
	/225	Precoated latent-curing epoxy/polyamide	-75°C to 150°C	Precoat only on -25 molded parts	
Thermoplastics					
S-1017	/42	Hot-melt/polyamide	-20°C to 60°C***	S-1017	Tape (1" x .010" x 50')
S-1030	/180	Hot-melt/polyolefin	-80°C to 80°C	S-1030	Tape (3/4" x .010" x 33')
S-1048	/86	Hot-melt, high performance	-55°C to 120°C	S-1048	Tape (1" x .026" x 100')
S-1124	/164	Hot-melt/elastomeric polymer	-55°C to 105°C	S-1124	Tape (3/4" x .018" x 100')
S-1297	/97	Hot-melt/polyamide adhesive	-20°C to 90°C	S-1297	Tape (1" x .010" x 10')
Sealants					
S-1278		Hot-melt grey butyl sealant	-40°C to 90°C	S-1278-01 S-1278-02	Tape (1" x .062" x 25') Tape (3 3/4" x .125" x 10')
S-1305		Hot-melt grey butyl sealant	-40°C to 90°C	S-1305-01	Tape (1" x .062" x 25')

*Shelf life from date of manufacture. **For specific adhesion properties, see product specification sheets.
 Passes cold bend at -40°C per RT-4204. *Only S-1006 Kit A conforms to MIL-A-46864.

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Pot life at 23°C	Curing conditions	Shelf life* at or below 25°C	Specifications**	Comments
1 h	96 h at 20°C min. or 1 hr at 120°C	2 years	RT-1006 RK-6612 MIL-A-46864****	General purpose harnessing adhesive. Not used on Viton, silicone or Kynar; 20-minute pot life
20 min	24 h at 20°C min. or 1 hr at 95°C	2 years	RT-1009	General purpose harnessing adhesive. Not used on Viton or silicone; 20-minute pot life
90 min	45 min at 120°C 2 h at 155°C min. or 15 min at 240°C	1 year	RT-1014	One-part epoxy tape used with Viton harness systems. Heat cure required (2 hours at 155°C)
	24 h at 20°C min. or 1 hr at 85°C	18 months	RT-1011 RK-6619 VG-95343	Good fluid-resistant epoxy used with System 25
	Cure during installation of molded parts	1 year 1 year	VG-95343 RK-6630	Precoated epoxy system for System 25
	120°C	Unlimited	RT-1050/1	General purpose harnessing adhesive Standard precoated adhesive for -3 and -4 molded parts
	120°C	Unlimited	RT-1050/6 RK-6017	Good low-temperature flexibility. Available as a preinstalled tape for molded parts
	160°C	Unlimited	RT-1050/3 RK-6626	Requires high temperature to achieve bonding. Highest service temperature for hot melt
	135°C	Unlimited	RT-1050/13	Requires reflowing in an oven at 150°C for 90 minutes. Designed to bond to -51 molded parts.
	120°C	Unlimited	RW-2019	General purpose harnessing adhesive Standard precoated adhesive in Sigmaform molded parts, CES and CSGA cable entry seals, and SST-FR heat-shrinkable tubing
	110°C	Unlimited	RW-2020	General purpose sealant and cable breakout area filler
	110°C	Unlimited	RW-2021	Halogen-free, flame-retardant sealant and cable breakout area filler

Users should independently evaluate the suitability of the product for their application.
Before ordering check with factory for most current data.