

**Service temperature  
range -55°C to +150°C**



Raychem S1184 highly conductive silver loaded adhesive has been developed to terminate Raychem screened moulded shapes. Its excellent conductivity, which causes only negligible increases in end-to-end resistance, enables the very high shielding levels of Raychem

screened moulded shapes, multicore cables, braided cables and adaptors to be combined to form efficient totally screened harnessing systems.

Raychem S1184 two part epoxy adhesive is designed to make terminations 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.

**Highly conductive termination adhesives**

Typical properties		Performance	Test method
Mechanical	Lap shear strength		
	Aluminium to aluminium	3.5KN	RK6627 Clause 2.1
	-25s to -25s	300N	
Thermal	Maximum operating temperature	150°C	
	Minimum operating temperature	-55°C	
Electrical	Resistivity	0.01 Ω/cm	RK6627 Clause 2.4
<b>Specifications</b>	Raychem RK6627		

**Installation**

<b>Mixing</b>	S1184 is supplied in a twin syringe to ensure accurate metering of the adhesive. The required amount of adhesive is measured from the syringe and mixed thoroughly.
<b>Pot life</b>	Once mixed, S1184 has a pot life of approximately 1 hour at 25°C.
<b>Surface preparation</b>	The moulded part and connector back shell should be degreased using a suitable solvent e.g. Isopropanol following the handling instructions supplied by the solvent supplier.
<b>Adhesive application</b>	The adhesive is applied to the connector back shell and to the cable shield. Apply heat to recover the heat-shrinkable moulded shape (refer to the installation guidelines supplied with product).
<b>Curing</b>	After recovery of the screened moulded shapes, one of the following cure cycles is recommended. <ul style="list-style-type: none"> <li>■ 24 hours at 20°C</li> <li>■ 1 hour at 80°C</li> <li>■ 20 minutes at 135°C</li> </ul>
<b>Shelf life</b>	6 months when stored in the original unopened packaging.
<b>Handling precautions</b>	<p>Irritant and dangerous for the environment while in its uncured state. Part A contains epoxy constituents. Part B contains Triethylenetetramine. Irritating to eyes and skin. Risk of serious damage to eyes. May cause sensitisation by skin contact. Toxic to aquatic organisms; may cause long-term adverse effects in the aquatic environment.</p> <p>In case of contact with eyes, rinse immediately with plenty of water and seek medical advice. After contact with skin wash immediately with plenty of water and soap. Wear suitable gloves and eye/face protection. Avoid release to the environment. Refer to safety data sheets. These are available via <a href="http://www.raychem.com/corporate/partners.asp">www.raychem.com/corporate/partners.asp</a></p>
<b>Packaging</b>	20cm <sup>3</sup> in a twin syringe

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