

Thermofit® Molded Parts Adhesives

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Applications

Thermofit adhesives are intended to provide an environmental seal when used with Thermofit molded parts, tubing, and adapters, and when installed in accordance with installation procedures.

Thermosets

Product designation	Precoat designation	Type	Operating temperature range	Available form	
S-1006	N/A	Epoxy/polyamide 2-part paste	-55 to 135°C	S-1006 Kit A S-1006 Kit C	Ten 3-g packs Six 2-oz semkits
S-1009	N/A	Epoxy/polymercaptan 2-part paste	-55 to 135°C	S-1009 Kit A	Ten 3-g packs 1-qt part B
S-1010	N/A	VITON® cement 2-part liquid	-55 to 200°C	S-1010	1/2-pint can with accelerator
S-1044	N/A	VITON tape adhesive	-55 to 200°C	S-1044-03 S-1044 Primer	Tape 3/4" x .018" x 100' 1/2-pint can
S-1125	N/A	Epoxy/polyamide 2-part paste	-55 to 135°C	S-1125 Kit 1 S-1125 Kit 3	Five 10-g packs One 100-g pack

Thermosets

Curing conditions	Shelf life* at or below 25°C	Compatible with material	Specifications	Comments
96 hrs @ 20°C min. or 1 hr @ 120°C	2 years	-3, -4, -5, -71	RT-1006 MIL-A-46864	General purpose harnessing adhesive. Not used on VITON, silicone, or substrates.
24 hrs @ 20°C min. or 1 hr @ 95°C or 45 mins @ 120°C	2 years	-3, -4, -5, -71	RT-1009 MIL-A-46864	General purpose harnessing adhesive. Not used on VITON or silicone—20 minute pot life.
2 hrs @ 150°C min. or 20 mins @ 200°C	1 year	-12	RT-1050/10	Used with VITON. Heat cure required.
2 hrs. @ 150°C min. or 20 mins @ 200°C	Tape: 1 year Primer: 1 year	-12 -12	RT-1050/22 RT-1050/14	Self-amalgamating tape used with VITON harness systems. All surfaces should be primed with S-1044 primer. Heat cure required: 2 hrs @ 150°C.
24 hrs @ 20°C min. or	18 months	-12, -25	RT-1011	Good fluid-resistant epoxy used with System 25.

*Shelf life from date of manufacture.

Thermoplastics

Product designation	Precoat designation	Type	Operating temperature range	Available form
S-1017	/42	Hot melt/polyamide	-20 to 60°C	S-1017 Tape 1" x .010" x 50'
S-1030	/180	Hot melt/polyolefin	-80 to 80°C	S-1030 Tape 3/4" x .010" x 33'
S-1048	/86	Hot melt high performance	-55 to 120°C	S-1048 Tape 1" x .026" x 100'

Thermoplastics

Bonding temperature minimum	Shelf life at or below 25°C	Compatible with material	Specifications	Comments
120°C	Unlimited	-3, -4, -25, -71	RT-1050/1	General purpose harnessing adhesive. Standard precoated adhesive for -3 and -4 molded parts.
120°C	Unlimited	-3, -4, -71	RT-1050/6	Good low-temperature flexibility. Available as a preinstalled tape for molded parts.
160°C	Unlimited	-3, -4, -25, -71	RT-1050/3	Requires higher temperature to achieve bonding. Highest service temperature for hot melt.

Ordering Information

Thermosets can be ordered by the designated "S" number and kit size (for example, S-1006-KIT-C). To receive the tape form, order the thermoplastics by their "S" number. They may be precoated on a molded part when the optional adhesive coating is included in the part number (see page 3-3).

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