General shrinkage rules:

Heat shrink tubes and heat shrink molded parts are made of thermoplastic. They have an "elastic shape memory". By applying heat, tubes and shrink molded parts shrink to their predetermined size (free shrinkage). In order to get the temperature of 120 to 140 °C necessary for shrinkage, suitable heat sources such as gas burners or hot air blowers must be used.

Precautionary measures must be taken before starting the shrinking process (observe local regulations for fire protection, keep them free of flammable or heat-sensitive materials or elements, wear suitable protective clothing).

Gas burners must be set to a soft (yellow) flame.

To improve adhesion, it is recommended to roughen the cable sheath insulation with emery cloth (grit 60-80) before cleaning. Thoroughly clean sheath and conductor insulation in the area of shrink tubes or shrink molded parts with CELLPACK Universal Cleaner No. 121 or another suitable cleaning agent and preheat to approx. 60 °C. Avoid pointed or sharp-edged areas.

Position the tubes or molded parts according to the specifications. Shrink tubes or molded parts shrinking, start shrinking from the middle. (Fig. 1-2), shrink tubes alternatively start shrinking from one side (Fig. 3), shrink end caps start shrinking from the closed end (Fig. 4). Ensure even radial heat distribution. Avoid overheating. If there is a risk of folding over the ends of the tube or cap, hold the flame briefly inside the tube/cap, the shrink material will then align itself again.

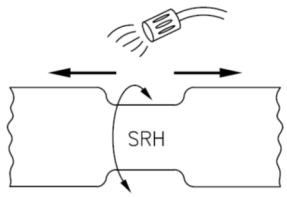	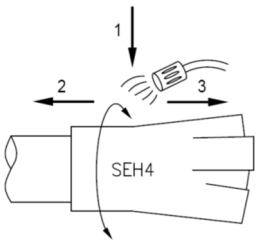	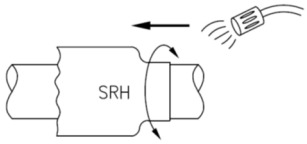	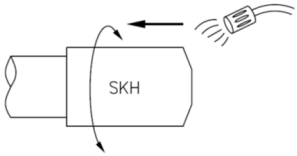
Fig. 1	Fig. 2	Fig. 3	Fig. 4

The shrink process is completed as soon as the heat shrink tube/molding is firmly and wrinkle-free (without air bubbles) on the substrate. If it is a product with hot melt adhesive, the hot melt adhesive will leak out at the ends.

Important indications for correct shrinkage are uniform wall thicknesses and straight labeling. After the shrinking process has ended, observe sufficient cooling times (lukewarm).

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