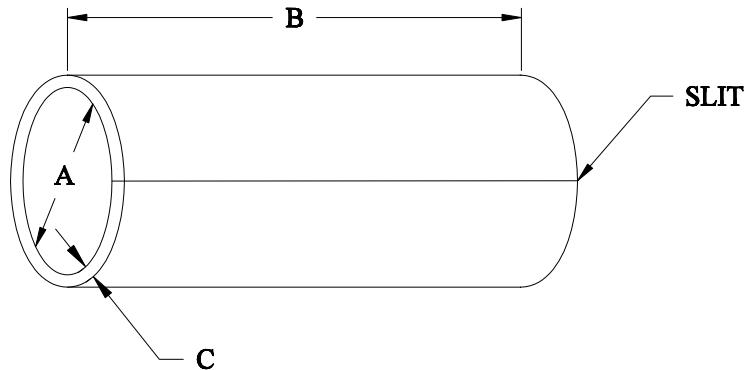


**Slit Adhesive Sleeve  
(S-1124)**

This specification covers the requirements for one type of single wall extruded adhesive. It shall be homogenous and essentially free from flaws, defects, pinholes, seams, cracks or inclusions.

**Table 1: Dimensions (inches)**

Size	Extruded ID (A)	Cut Length (B)	Extruded Wall (C)
SAS-090-1-1124	.090 ± .005	1.000 ± .050	0.024 ± .005
SAS-115-1-1124	.115 ± .005	1.000 ± .050	0.032 ± .005
SAS-160-1-1124	.160 ± .005	1.000 ± .050	0.032 ± .005
SAS-200-1-1124	.200 ± .005	1.000 ± .050	0.035 ± .005
SAS-250-1-1124	.250 ± .010	1.000 ± .050	0.035 ± .005
SAS-300-1-1124	.300 ± .010	1.000 ± .050	0.067 ± .010

**Color:** Gray

**Table 2: Properties**

<b>Property</b>	<b>Unit</b>	<b>Requirements</b>	<b>Test Method</b>
<b>Physical</b>			
Visual	--	No foreign matter, voids, pinholes.	
Specific Gravity	--	1.15 ± 0.05	ASTM D 792
Adhesive Peel Polychloroprene	lbs/in width	20 minimum	Note 1
<b>Chemical*</b>			
Water Absorption	Percent	0.5 maximum	ASTM D 570
Fungus Resistance	--	Rating of 1 or less	ASTM G 21
Fluid Resistance* Weight Change after 24 hours at 23°C (73°F)	Percent		ASTM D 543
Hydraulic Fluid (MIL-H-46170)		25 maximum	
Aviation Fuel (MIL-G-5572)		30 maximum	
Grade 100/130		5 maximum	
Cleaning Compound (P-C-437)		25 maximum	
Isopropyl Alcohol (TT-I-735)			

\*Test specimens shall be prepared in the form of 6 x 6 x .075-inch compression molded slabs. Molding temperature shall be 135 ± 3°C (275 ± 5°F).

**Acceptance Tests:** Visual, Dimensions, Specific Gravity

**Note 1:** Adhesive Peel Strength

**Polyolefin**

Shrink a 6-inch length of size 1-1/2 inch Thermofit NT-FR\* on a glass-laminated plastic or metal tube, 1 inch in diameter, and approximately 1 foot long, with a Thermofit Model 500B Thermogun\* or equivalent. Cool to room temperature, lightly abrade with No. 320 emery cloth, and wipe with MEK. Spiral wrap S-1124<sup>†</sup> tape on the recovered tubing, with a 50% overlap. Place a strip of 3/4-inch-wide masking tape lengthwise on the adhesive tape to hold it in place and to provide unbonded ends to insert into the tensile tester.

Abrade and clean the inside surface of three 1-1/2 inch lengths of size 1-1/2 inch NT-FR. Place them on the prepared mandrel so that they are about 1/2 inch apart, and shrink with the Thermogun. Place the assembly in an oven for 10 minutes at  $150 \pm 3^\circ\text{C}$  ( $302 \pm 5^\circ\text{F}$ ).

Cool to room temperature, and cut along one edge of the masking tape to remove the bonded assembly from the mandrel. Cut a 1-inch wide specimen from the center of each double thickness. Insert the unbonded ends in a tensile tester operating at 2 inches per minute. Make readings of peel strength at every 1/2 inch of jaw separation after 1 inch initial separation. The average of 5 readings shall define peel strength.

\*Obtainable from Raychem Corporation.

+S-1124 tape is made from the same lot of material as SAS-1124.

Raychem reserves the right to amend this specification at any time. Users should evaluate the suitability of the product for their application.

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