

Precision Tools

B-7, Street No 3, NICE, MIDC, Satpur, Nasik – 422 007. INDIA

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M/s :

Phone :
Attn :
Mobile :
E mail :
Website :

Sub : **“Shrinkin’Sleeves” - Heat Shrink Sleeves**

Dear Sir / Madam,

We introduce ourselves as manufacturers of ROHS Compliant, FRLS Heat Shrink Sleeveings. "Shrink wrapping" is a unique process by which most products are conveniently, economically and esthetically packed.

The process involved is to enclose the product in a sleeve which has been given a special treatment during manufacture, causing an orientation in the sleeve introducing a built-in shrinkage which is released at an elevated temperature, resulting in shrinkage of the sleeve. The shrink force reaches its maximum during cooling and is maintained for a long period there after.

“Shrinkin’Sleeves” are available in the following grades:

Bus Bar Grade Bb 100.	Capacitor Grade Cp 200.
Cap Seal Grade Cs 300.	Container Grade Ct 400.
Fridge Grade Rg 500.	Dry Cell Grade Db 600.
Cable Lug Grade Cl 700.	

We understand that you have good requirement of Ht Sh Sleeveings for the products manufactured by you. Find enclosed herewith specifications of “Shrinkin’Sleeves” to give you brief idea while selecting proper grade to suit your specific requirement.

Looking forward to receive your valued enquiry.

Thanking You,

Yours Truly,

Ameya Aher.

An ISO 9001 : 2008 Company.

**"Shrinkin'Sleeves" ARE TO BE STORED IN A COOL PLACE AWAY FROM
DIRECT SUNLIGHT, HIGH TEMPERATURE AND HUMIDITY.**

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Bus Bar Grade - Bb 100

"Shrinkin'Sleeves" used to insulate BusBars and Conductors provide excellent insulation with a high dielectric strength & a good retention of dielectric strength under wet conditions.

Physical & Electrical Properties :

Tensile strength	: > 300 kg/Sq. Cm.
Ultimate elongation	: > 250 %
Insulation resistance	: 3×10^6 Mega ohms (at R/T)
Dielectric strength	: 12 KV (B.D.V. : 15 KV)
Shrink temperature	: 120° Centigrade
Shrink ratio	: MD - 10 % TD - 40 %
Continuous operating tempt	: - 05 to 110° Centigrade
Corrosive effect - Non corrosive	: Resistant to acid, alkalis & oil
Fire retardation	: Self extinguishing, Non flammable
Type	: Creased type
Sizes available	: L/F size 41mm to 240 MM
Bus Bars Size	: 25 x 6 to 200 x 12 MM
Thickness	: 0.20 to 0.40 MM
Std. Color	: Red, Yellow, Blue & Black
Std. length / roll	: 50 to 100 meters
Shelf Life	: 6 months, stored below 25° Centigrade



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Capacitor Grade - Cp 200

"Shrinkin'Sleeves" provide good insulation assuring quality and offer a high degree of impact resistance protecting the capacitor from breakage during rough uses.

Physical & Electrical Properties :

Tensile strength	: 300 kg / Sq. Cm.
Tear strength	: 75 kg / Cm.
Water absorption	: Less than 0.70 %
Dielectric strength	: 6 KV at 0.10 MM thickness
Heat resistance	: 105° C for 1000 Hrs continuous
Shrink ratio	: MD 10 %; TD 40 %.
Fire retardation	: Self extinguishing, Non flammable
Type	: Creased Type
Sizes available	: For dia. from 4.00 to 150.00 mm
Standard Color	: Blue Gray, Black, Violet, and Green.



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Cap Seal Grade - Cs 300

"Shrinkin'Sleeves" are extensively used for sealing of containers making the container pilfer proof, protecting the aroma & test of the product, prevents evaporation to retain the moisture content.

These are used on the cap or the top of the container, these sleeves can be plain or printed depending on the requirement of the customer. These sleeves act as tamper evident or pilfer proof labels. A tab and a perforation (vertical, horizontal or slanting) are provided on the sleeve. If the cap is to be opened the perforation has to be torn and hereby giving a clear indication if the container is tampered.

Container Grade - Ct 400

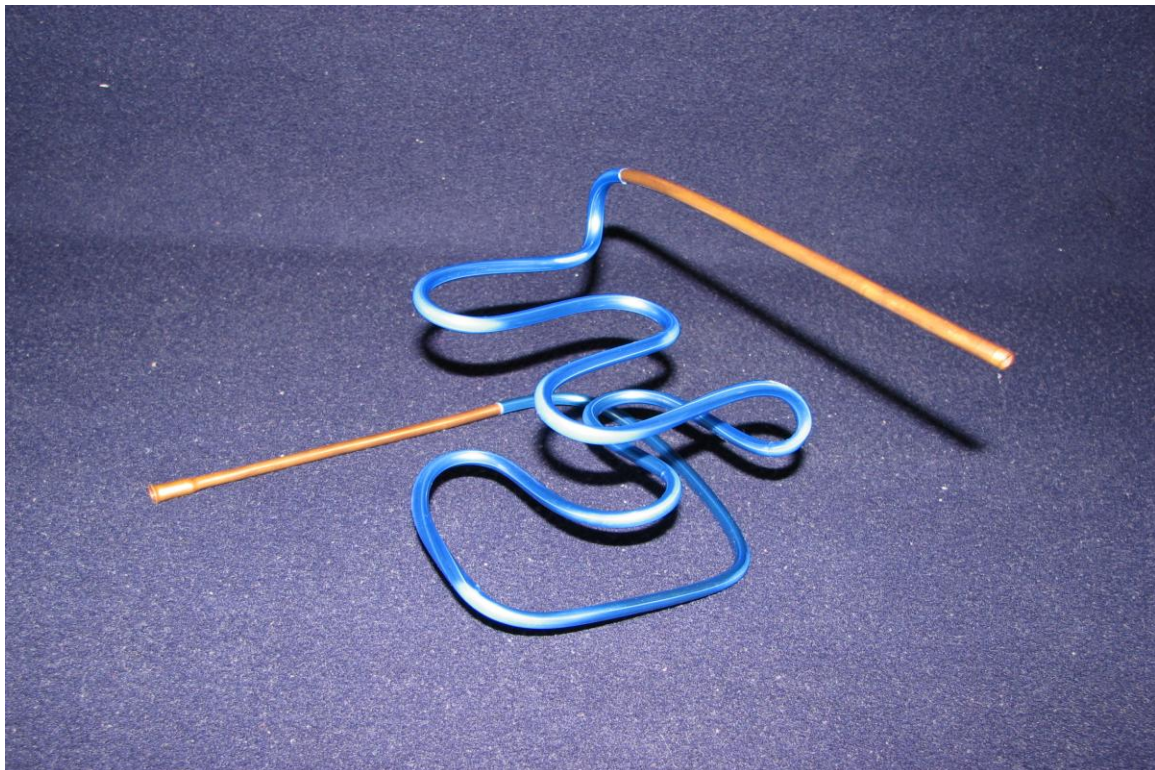
"Shrinkin'Sleeves" used over glass/aluminum containers make them shatter resistant, and provide a decorative wrapping which prevents pilferage during handling & tampering by spurious suppliers.

Refrigerator Grade Rg 500

"Shrinkin'Sleeves" widely accepted in the "Fridge" manufacturing provide good heat, electrical insulation. The biaxial forces, released during shrinking provide a long lasting, infallible mechanical bondage

Physical & Electrical Properties:

Shrink temperature	120° Centigrade
Corrosive effect - Non corrosive	Resistant to acids, alkalis & oils
Fire retardation	Self extinguishing, Non flammable
Std. Color	Red, Grey, Blue Clear & Transparent



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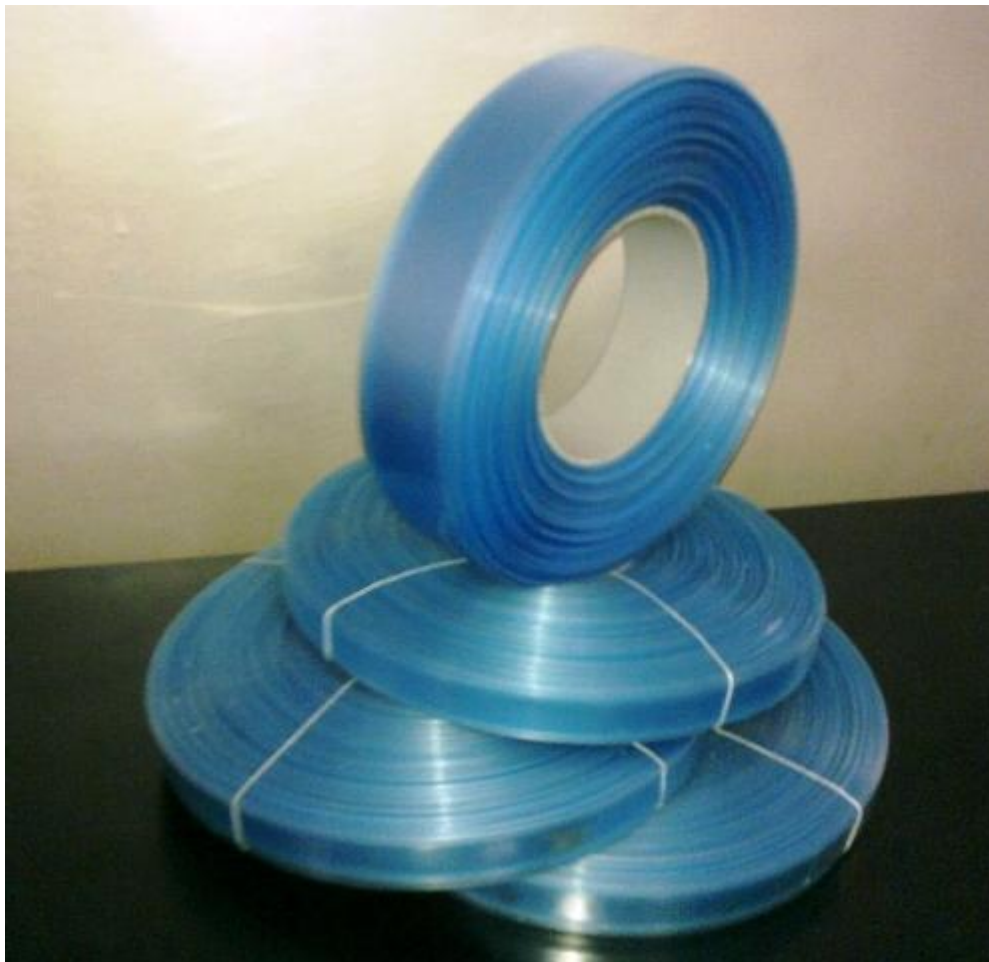
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Dry Cell Battery Grade - Db 600

"Shrinkin'Sleeves" are used in dry cell batteries for individual or batch packing and also to cover internal core to provide insulation and to protect the equipment from corrosion by leakage



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Cable Lug Grade - CI 700

"Shrinkin'Sleeves" insulate lugged cable ends with scratch proof, hard, noncorrosive cover so as to avoid flashing/sparking due to accidental contacts, while mechanical bonding provided at the Lug & Conductor Sheath juncture by "Shrinkin'Sleeves" reduce the stress at the terminal

Physical & Electrical properties:

Tensile Strength	> 300 kg/Sq. cm.
Ultimate elongation	> 200 %.
Insulation resistance	(at R/T) 3 x 106 Mega ohms
Dielectric strength	12 KV (B.D.V. 15 KV)
Shrink temperature	120° Centigrade
Shrink ratio	MD - 10 % TD - 40 %
Operating temperature	-05 to 110 Deg Centigrade
Corrosive effect - non corrosive	Resistant to acid, alkalis & oil
Fire retardation	Self extinguishing, non flammable
Thickness	0.20 mm to 0.40 mm
Shelf life	6 months, stored below 25 ⁰ Centigrade.



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BUS BAR

Bus Bar is a vital link in transmission of electrical energy. Insulation of the conductors is of utmost importance.

Insulation is traditionally done by the following ways, * Taping * Painting / Spraying * Powder coating * Epoxy potting * Bare Bus Bar * Sleeveings a) Imported b) "Shrinkin'Sleeves"

1) Taping : In this process ordinary Electrical Insulation tape is used which is wrapped around the Bus bar from end to end. Desired insulation is achieved by no. Of layers laid over the conductor. The reliability of this method is very poor

2) Painting / Spraying : Certain paints are available to attain electrical insulation up to a low value.

3) Powder Coating: Uniformity achieved is uniform with insulation limitation being the main constraint.

4) Epoxy Potting : By this method insulation of high value is achieved in the best possible way but it is tedious, costly and time consuming

5) Bare Bus Bar: Air being natural insulator, insulation up to a certain low value is achieved by adjusting the distance between two conductors. However space availability is the constraint

6) Sleeveing : By this, high insulation values are achieved. Uniformity, consistency & reliability levels attained are of very high standards.

A) Imported Sleeves : These are rubberized polymer sleeves having excellent insulation properties. Availability and very high costs are the major factors restricting their extensive usage.

B) "Shrinkin'Sleeves": Sleeveings with improved Electrical insulation properties Higher insulation values are achieved by encapsulating the conductor in "Shrinkin'Sleeves" - Bb 100 grade. Versatility, reliability & operational simplicity, in addition to cost effectiveness are the major favorable factors.

The manufacturing process involves orientation of molecular memory of the sleeve, F introducing a built-in shrinkage which is subsequently released at elevated temperature activating molecular memory of the sleeve resulting in instantaneous release of the Shrink Strains. The Biaxial strains thus released result in contraction of the sleeve, lengthwise and width wise. The shrinkage force reaches its maximum during cooling and is maintained for a longer period thereafter.

"Shrinkin'Sleeves" are available in creased type rolls with roll length ranging from 50 mtrs to 200 mtrs. wound over hard card board core, covered in Polyethylene bag and packed in card board containers.

Activation of molecular memory of the "Shrinkin'Sleeves" at elevated temperature demands the sleeves to be stored in cool place away from direct sunlight, high temperature and humidity with storage tempt not exceeding 25°C. The shelf life of "Shrinkin'Sleeves" prior to shrinking, is 6 Months

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Sleeving Recommendations :

Capping of the Conductor :

Slip over sleeve of length 60 MM approx on one end of the conductor for about 30 MM & shrink it. A cap is formed over this end after cooling. This cap prevents scratching of internal surface of "Shrinkin'Sleeves" while insertion by free burr and / or sharp edge of the conductor.

The protective cap can be removed by cutting with a sharp blade.

Sleeving of the conductor :

Sleeving of straight conductor :

"Shrinkin'Sleeves"_ can be slipped over the straight conductor from the capped end & pulled to cover the desired section. Conductor with loosely fitted sleeve shall then be subjected to "Shrink Tempt" for an appropriate time till a skin - tight cover with smooth surface finish is formed without undulations.

The conductor may be reheated to remove the undulations, if any.

Sleeving of bend conductor :

Slip "Shrinkin'Sleeves" of length 200 MM to be positioned over both arms of the bend uniformly. After shrinkage it covers the bend without any undulation leaving no air cavity. After cooling, sleeve both arms by inserting "Shrinkin'Sleeves" from each side till the preshrunk bend portion is completely overlapped resulting, after shrinkage, in the encapsulation of the conductor with a smooth, protective cover.

Double sleeving of the conductor :

The conductor is sleeved as per the procedure specified earlier in "Shrinkin'Sleeves" and cooled down to the room temperature. Then the same procedure is repeated by inserting the presleeved conductor again in fresh unshrunk "Shrinkin'Sleeves" of appropriate dimensions to provide a double coated conductor giving improved insulation properties.

Recommended shrinkage temperature / time : 120°C / 20 Minutes.

However the actual tempt & time depends on the Heat System mainly and is to be arrived at only after actual trials by the operator. Increase in Shrink tempt reduces the Shrink time.

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Recommended sleeve sizes - Electrical Bus Bars / Conductors

Sr	Bus Bar		L/F Size	Thicknes	B.D.V	SS Code
01	25 x 06	25 x 09	43.00	0.20	15 KV	10004320
02	25 x 12	30 x 12	51.00	0.20	15 KV	10005120
03	50 x 10	60 x 12	82.00	0.20	15 KV	10008220
04	75 x 06		93.00	0.20	15 KV	10009320
05	75 x 12	80 x 10	102.00	0.20	15 KV	10010220
06	100 x 12	100 x 10	128.00	0.20	15 KV	10012820
07	120 x 10		140.00	0.20	15 KV	10014020
08	120 x 12	125 x 12	170.00	0.20	15 KV	10017020
09	150 x 10	160 x 10	190.00	0.20	15 KV	10019020
10	200 x 10	200 x 12	240.00	0.20	15 KV	10024020

Standard Colors : Black, Red, Yellow. Blue, Green..

Recommended sleeve sizes - Capacitors / Containers / Conductors –

Sr	Dia	L/F	SS Code	Sr	Dia	L/F	SS Code
11	5.00	9.00	20000908	21	28.00	46.00	20004620
12	6.00	10.50	20001008	22	30.00	51.00	20005120
13	8.00	14.00	20001408	23	35.00	58.00	20005820
14	10.00	17.00	20001710	24	40.00	65.00	20006520
15	13.00	22.00	20002210	25	45.00	74.00	20007420
16	16.00	27.50	20002710	26	50.00	82.00	20008220
17	19.00	29.50	20002910	27	55.00	90.00	20009020
18	20.00	31.00	20003110	28	57.00	93.00	20009320
19	22.00	36.00	20003610	29	63.00	102.00	20010220
20	25.00	41.50	20004110	30	75.00	124.00	20012420

Standard Color : Black, Gray, Brown, Blue - Clear & Trans.

“Shrinkin'Sleeves” : Standard Length wise Shrinkage (L/S) : 15% +/- 7%
Standard Width wise Shrinkage (W/S) : 40% +/- 7%

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“Shrinkin’Sleeves” : Specifications

Sr	L/F	Tol	Thn	Toll	Mtl. Code	Sr.	L/F	Toll	Thn	Toll	Mtl Code
01	43.00	0.50	0.20	0.02	10004320	01	9.00	0.50	0.07	0.02	50000907
02	51.00	0.50	0.20	0.02	10005120	02	10.50	0.50	0.07	0.02	50001007
03	82.00	0.50	0.20	0.02	10008220	03	14.00	0.50	0.10	0.02	50001410
04	93.00	0.50	0.20	0.02	10009320	04	17.00	0.50	0.10	0.02	50001710
05	102.00	0.50	0.20	0.02	10010220	05	22.00	0.50	0.10	0.02	50002210
06	128.00	0.50	0.20	0.02	10012820	06	27.00	0.50	0.10	0.02	40002710
07	140.00	0.50	0.20	0.02	10014020	07	29.50	0.50	0.10	0.02	40002910
08	170.00	0.50	0.20	0.02	10017020	08	31.00	0.50	0.10	0.02	40003110
09	190.00	0.50	0.20	0.02	10019020	09	36.00	0.50	0.10	0.02	40003610
10	240.00	0.50	0.20	0.02	10024020	10	41.50	0.50	0.10	0.02	40004110
11	43.00	0.50	0.40	0.02	10004340	11	43.00	0.50	0.20	0.02	40004320
12	51.00	0.50	0.40	0.02	10005140	12	51.00	0.50	0.20	0.02	40005120
13	82.00	0.50	0.40	0.02	10008240	13	58.00	0.50	0.20	0.02	40005820
14	93.00	0.50	0.40	0.02	10009340	14	65.00	0.50	0.20	0.02	40006520
15	102.00	0.50	0.40	0.02	10010240	15	74.00	0.50	0.20	0.02	40007420
16	128.00	0.50	0.40	0.02	10012840	16	82.00	0.50	0.20	0.02	40008220
17	140.00	0.50	0.40	0.02	10014040	17	90.00	0.50	0.20	0.02	40009020
18	170.00	0.50	0.40	0.02	10017040	18	93.00	0.50	0.20	0.02	40009320
19	190.00	0.50	0.40	0.02	10019040	19	102.00	0.50	0.20	0.02	40010220
20	240.00	0.50	0.40	0.02	10024040	20	124.00	0.50	0.20	0.02	40012420
21	9.00	0.50	0.07	0.02	20000907	21	128.00	0.50	0.20	0.02	40012820
22	10.50	0.50	0.07	0.02	20001007	22	140.00	0.50	0.20	0.02	40014020
23	14.00	0.50	0.10	0.02	20001410	23	170.00	0.50	0.20	0.02	40017020
24	17.00	0.50	0.10	0.02	20001710	24	190.00	0.50	0.20	0.02	40019020
25	22.00	0.50	0.10	0.02	20002210	25	240.00	0.50	0.20	0.02	40024020
26	27.00	0.50	0.10	0.02	20002710	26	43.00	0.50	0.40	0.02	70004340
27	29.50	0.50	0.10	0.02	20002910	27	51.00	0.50	0.40	0.02	70005140
28	31.00	0.50	0.10	0.02	20003110	28	82.00	0.50	0.40	0.02	70008240
29	36.00	0.50	0.10	0.02	20003610	29	93.00	0.50	0.40	0.02	70009340
30	41.50	0.50	0.10	0.02	20004110	30	102.00	0.50	0.40	0.02	70010240
31	46.00	0.50	0.20	0.02	20004620	31	128.00	0.50	0.40	0.02	70012840
32	51.00	0.50	0.20	0.02	20005120	32	140.00	0.50	0.40	0.02	70014040
33	58.00	0.50	0.20	0.02	20005820	33	170.00	0.50	0.40	0.02	70017040
34	65.00	0.50	0.20	0.02	20006520	34	190.00	0.50	0.40	0.02	70019040
35	74.00	0.50	0.20	0.02	20007420	35	240.00	0.50	0.40	0.02	70024040
36	82.00	0.50	0.20	0.02	20008220						
37	90.00	0.50	0.20	0.02	20009020		“Shrinkin’Sleeves” : Specifications				Shrinkage
38	93.00	0.50	0.20	0.02	20009320		Bb 100 : 100*****, Cp 200 : 200*****				MD : 40 %
39	102.00	0.50	0.20	0.02	20010220		Rg 500 : 500*****, Cl 700 : 700*****				TD : 10 %
40	124.00	0.50	0.20	0.02	20012420						

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1.0 Suitability test of "Shrinkin'Sleeves" for :

- a) Continuous operating temperature.
- b) Long duration testing at high temperature.

1.1 Sample Description : a) Cut lengths of "Shrinkin'Sleeves" to be tested.

b) Sleeves under test, shrunk on appropriate mandrel.

1.2 Procedure : Cut lengths of sleeves / sleeved mandrels progressively exposed to various temperatures, durations in the oven. The results observations are tabulated after removal of test samples from oven.

1.3 Test Specified : Expose test samples to following parameters..a) Continuous operation temperature : 100°C x 1000 hrs.b) Long duration testing at higher temperature : 110°C x 24 hrs.

1.4 Observations : a) The shrinkage should be even from all sides. b) The surface, smooth all over without pit marks / pin holes c) The sleeving should not develop any crack. d) The sleeving retains all its properties after cooling.

1.5 Inference :

- i) "Shrinkin'Sleeves" can be used at an elevated temperature of 100°C for 1000 hours.
- ii) "Shrinkin'Sleeves" have got a capacity to bear a heat shock Upton 110°C for 24 hours.

2.0 Self extinguishing properties of "Shrinkin'Sleeves"

2.1 Sample Description : Cut lengths of "Shrinkin'Sleeves".

2.2 Apparatus : Ignition chamber : Corning / Pyrex glass, dia. 75 mm x 450 length.
Ignition source : Bunsen burner, placed in a fume cupboard.

2.3 Procedure : a) Clamp an appropriate size & length of "Shrinkin'Sleeves" in a holder & fix it into the ignition chamber .b) Light the ignition source under normal Oxygen conditions .c) Bring the test sample in the ignition zone.

2.4 Observations : a) After shrinkage test sample gets ignited in the ignition zone. b) There is no droppage of any melt during ignition. c) Test sample withdrawn out of ignition zone or the ignition source put off, the ignition of test sample ceases immediately. d) The ignited material leaves granular ash.

2.5 Inference : "Shrinkin'Sleeves" are self extinguishing with no droppage of any melt during ignition.

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