

Tips of using ultra thin wall heat shrink tubing BH-MT-PET-CB

1. How to choose proper size matching your parts:

Tight fit is best: 15% gap or less.

PET should be sized no larger than 15% above the maximum diameter of your part.

2. Shrink temperature:

Approximately 70°C–190°C.

Typical shrinking temperature recommended for most applications: 150°C.

3. Controlling Shrinkage:

Uncontrolled shrinkage, PET heat shrink tubing will shrink both radially and axially. In most cases, the best overall performance comes with minimal shrinkage (less than 15%–20%), except when the tube drawing process is used as described below, or unless you restrict axial shrinkage.

You can restrict axial shrinkage by holding the ends of the heat shrink tube during the heating process to prevent the tube from shrinking in length. This will result in a heat shrink tube with radial shrinkage up to 50% or more, depending on temperature.

4. Tube Drawing for High Radial Shrinkage

Use the tube drawing process to achieve very high radial shrinkage (up to 50% or more).

Simply apply axial tension, stretching the heat shrink tube while you're heating it. You can reduce the diameter by more than 50% at temperatures below 100°C; with even greater diameter reductions at higher temperatures, up to about 190°C.

5. How to avoid wrinkle problem?

Improper Technique - Uncontrolled Shrinkage

When PET material undergoes unrestricted heat shrink process, simultaneous radial and axial dimensional reduction occurs, leading to surface deformation (creases/folds).

Recommended Procedure

Step 1: Position heat-shrink sleeve onto target component. Maintain tension on both terminal sections throughout heating process to inhibit wrinkles.

Step 2: Begin apply heating at midpoint using rotational motion, progressively extending heat application toward the length end while maintaining consistent material rotation.

Note: For enhanced higher radial shrinkage, implement controlled longitudinal tension during the heating phase to attain a greater shrink ratio.