

PLASTIC TUBING, ELECTRICAL INSULATION
Polytetrafluoroethylene, Heat Shrinkable
Overexpanded

1. SCOPE:

- 1.1 Form: This specification covers a modified polytetrafluoroethylene in the form of flexible tubing.
- 1.2 Application: Primarily for use as a flexible, electrical insulation tubing whose diameter can be reduced to a predetermined size by heating to 325°C (620°F) or higher. This tubing is stable for continuous exposure from -65° to +250°C (-90° to +480°F).
- 1.3 Safety - Hazardous Materials: While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the safety and health of all personnel involved.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

- 2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods

REAFFIRMED

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2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM D2671 - Testing Heat-Shrinkable Tubing for Electrical Use

2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Military Standards:

MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

3. TECHNICAL REQUIREMENTS:

3.1 Material: Shall be a modified polytetrafluoroethylene composition.

3.2 Color: Shall be a standard unpigmented state, varying from transparent milk-white to translucent-tan.

3.3 Properties: Tubing shall conform to the following requirements; reported values shall be the average of all specimens tested for each requirement. Tests shall be performed in accordance with ASTM D2671 insofar as practicable.

3.3.1 Recovered Tubing: The following requirements apply to tubing after being shrunk by heating to $350^{\circ}\text{C} + 3$ ($660^{\circ}\text{F} + 5$) in a convection-current air oven with an air velocity of 100 - 200 ft per min. (0.5 - 1.0 m/sec) past the tubing, holding at heat for not less than 10 min., removing from the oven, and cooling to room temperature:

3.3.1.1	Tensile Strength, min Jaw separation rate 2 in. per min. (50 mm/min.)	2500 psi (17.0 MPa)	
3.3.1.2	Elongation, min	200%	
3.3.1.3	Dielectric Strength, min	800 V per mil (31,500 V/mm)	4.5.1
3.3.1.4	Volume Resistivity, min	10^{18} ohm-cm	
3.3.1.5	Low-Temperature Flexibility At $-65^{\circ}\text{C} \pm 2$ ($-90^{\circ}\text{F} \pm 4$)	No cracks	4.5.2
3.3.1.6	Heat Aging, 96 hr ± 2 at $350^{\circ}\text{C} \pm 4$ ($660^{\circ}\text{F} \pm 7$)		
3.3.1.6.1	Tensile Strength, min	2500 psi (17.0 MPa)	
3.3.1.6.2	Elongation, min	200%	
3.3.1.6.3	Dielectric Strength, min	800 V/mil (31,500 V/mm)	

3.3.1.7 Dimensional Change on Heating

3.3.1.7.1 Diametral

In accordance with
Table I

3.3.1.7.2 Longitudinal, max

+15%

3.3.2 Expanded Tubing: The following requirements apply to tubing in the expanded (as-received) condition. Heating for the tests of 3.3.2.1 and 3.3.2.2 shall be performed in an oven as specified in 3.3.1.

3.3.2.1 Heat Shock at $400^{\circ}\text{C} \pm 5$
($750^{\circ}\text{F} \pm 10$)No dripping,
flowing, or
cracking

3.3.2.1.1 Bending After Heat Shock

No cracks

4.5.3

3.3.2.2 Restricted Shrinkage, Procedure C
After 5 min. ± 1 at $350^{\circ}\text{C} \pm 4$
($660^{\circ}\text{F} \pm 7$)No cracks;
withstand 2000 V
for 1 min.

3.3.2.3 Specific Gravity

2.13 - 2.20

3.3.2.4 Water Absorption, max
24 hr ± 0.25 at $25^{\circ}\text{C} \pm 2$ ($77^{\circ}\text{F} \pm 4$)

0.01%

3.4 Quality: Tubing, as received by purchaser, shall be uniform in quality and condition, smooth, and free from foreign materials and from imperfections detrimental to usage of the tubing.

3.5 Sizes and Tolerances: Tubing shall be supplied in lengths of 48 in., ± 1 , -0 (1200 mm, ± 25 , -0) and in the standard sizes and to the tolerances shown in Table I. Tolerances apply at $23^{\circ} - 30^{\circ}\text{C}$ ($73^{\circ} - 86^{\circ}\text{F}$). Measurements shall be made in accordance with ASTM D2671.

TABLE I

Recovered Dimensions (After Heating)

Size	Expanded (As Supplied)			
	ID, Inches min	ID, Inch max	Nominal Wall Thickness, Inch	Wall Thickness Tolerance, Inch plus and minus
5/64	0.078	0.025	0.009	0.002
1/8	0.125	0.037	0.010	0.002
1/4	0.250	0.063	0.012	0.003
3/8	0.375	0.096	0.012	0.003
1/2	0.500	0.144	0.015	0.004
5/8	0.625	0.178	0.015	0.004
3/4	0.750	0.224	0.015	0.004
1	1.000	0.278	0.015	0.004
1-1/4	1.250	0.347	0.015	0.004

TABLE I (SI)

Recovered Dimensions (After Heating)

Size	Expanded (As Supplied)			
	ID, Millimetres min	ID, Millimetres max	Nominal Wall Thickness Millimetre	Wall Thickness Tolerances, Millimetre plus and minus
5/64	1.95	0.62	0.22	0.05
1/8	3.12	0.92	0.25	0.05
1/4	6.25	1.58	0.30	0.08
3/8	9.50	2.40	0.30	0.08
1/2	12.50	3.60	0.38	0.10
5/8	15.50	4.45	0.38	0.10
3/4	18.75	5.60	0.38	0.10
1	25.00	6.95	0.38	0.10
1-1/4	31.25	8.68	0.38	0.10

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of tubing shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.6. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the tubing conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to requirements for tensile strength (3.3.1.1), elongation (3.3.1.2), dimensional change on heating (3.3.1.7), heat shock (3.3.2.1), and sizes and tolerances (3.5) are classified as acceptance tests and shall be performed on each lot.

4.2.2 Periodic Tests: Tests to determine conformance to requirements for dielectric strength (3.3.1.3), volume resistivity (3.3.1.4), low-temperature flexibility (3.3.1.5), heat aging (3.3.1.6), restricted shrinkage (3.3.2.2), specific gravity (3.3.2.3), and water absorption (3.3.2.4) are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

4.2.3 Preproduction Tests: Tests to determine conformance to all technical requirements of this specification are classified as preproduction tests and shall be performed prior to or on the initial shipment of tubing to a purchaser, when a change in material, processing, or both requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

4.2.3.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, the contracting officer, or the request for procurement.

4.3 Sampling: Shall be in accordance with ASTM D2671 and the following:

4.3.1 For Acceptance Tests: Not less than 16 ft (5 m) of tubing taken at random from each lot. The number of determinations for each requirement shall be as specified in the applicable test procedure or, if not specified therein, not less than three.

4.3.1.1 A lot shall be not more than 100,000 ft (30,500 m) of tubing of the same size from the same production run presented for vendor's inspection at one time. A lot may be packaged and delivered in smaller quantities under the basic lot approval provided lot identification is maintained.

4.3.1.2 When a statistical sampling plan and acceptance quality level (AQL) have been agreed upon by purchaser and vendor, sampling shall be in accordance with such plan in lieu of sampling as in 4.3.1 and the report of 4.6.1 shall state that such plan was used.

4.3.2 For Periodic Tests: Not less than 50 ft (15 m) of tubing of each size or size range. Certain representative sizes may be used to demonstrate conformance of a range of sizes as follows:

Representative Size

Range of Sizes

1/4
1

5/64 - 1/4, incl
3/8 - 1-1/4, incl

4.3.3 For Preproduction Tests: As agreed upon by purchaser and vendor.

4.4 Approval:

4.4.1 Sample tubing shall be approved by purchaser before tubing for production use is supplied, unless such approval be waived by purchaser. Results of tests on production tubing shall be essentially equivalent to those on the approved sample.

4.4.2 Vendor shall use ingredients, manufacturing procedures, processes, and methods of inspection on production tubing which are essentially the same as those used on the approved sample tubing. If necessary to make any change in ingredients, in type of equipment for processing, or in manufacturing procedures, vendor shall submit for reapproval a statement of the proposed changes in material, processing, or both and, when requested, sample tubing. Tubing made by the revised procedure shall not be shipped prior to receipt of reapproval.

4.5 Test Methods:

4.5.1 Dielectric Strength: Shall be determined by dividing the dielectric breakdown voltage, determined in accordance with ASTM D2671, by the wall thickness, measured at the point of electrical rupture.

- 4.5.2 Low-Temperature Flexibility: Shall be determined in accordance with ASTM D2671, Procedure C, bending the specimen around the applicable mandrel of Table II. Any side-cracking, caused by flattening of the specimen on the mandrel, shall be disregarded.

TABLE II

Size	Mandrel Diameter	
	Inch	Millimetres
5/64 to 3/8 incl	5/16	8.0
1/2 to 3/4 incl	3/8	9.5
1 to 1-1/4 incl	7/16	11.0

- 4.5.3 Bending After Heat Shock: Specimens from the heat shock test of 3.3.2.1 shall be bent 360 deg around the applicable mandrel of Table II. Any sidecracking, caused by flattening of the specimen on the mandrel, shall be disregarded.

4.6 Reports:

- 4.6.1 The vendor of tubing shall furnish with each shipment a report showing the results of tests to determine conformance to the acceptance test requirements and stating that the tubing conforms to the other technical requirements of this specification. This report shall include the purchase order number, AMS 3584B, vendor's compound number, lot number, size, and quantity.
- 4.6.2 The vendor of finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 3584B, contractor or other direct supplier of tubing, supplier's compound number, part number, and quantity. When tubing for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of tubing to determine conformance to the requirements of this specification and shall include in the report either a statement that the tubing conforms or copies of laboratory reports showing the results of tests to determine conformance.
- 4.7 Resampling and Retesting: If the average results of the specimens tested for any requirement fail to meet the specified value, disposition of the tubing may be based on the results of testing three additional specimens for each original specimen failing to meet the specified average requirement. Failure of the average of the original specimens plus the retest specimens to meet any specified requirement shall be cause for rejection of the tubing represented and no additional testing shall be permitted. Results of all tests shall be reported.