



**Electronics OEM Division (Europe) RK Specification**

**RK 6024 Revision 3**

**ATUM SLEEVING (Coloured and Clear)**

**SCOPE**

**This Quality Assurance Specification establishes the quality standard for a semi-flexible, electrically insulating, selectively cross-linked, dual wall, heat shrinkable sleeving.**

**Approved Signatories\***

This document is electronically reviewed and approved - therefore no signatures will appear.

**1. REVISION HISTORY**

Revision Number	Change Request	Date	Incorporated By
1	Initial	01 Sep 95	D. Innes
2	CR98-DM-0199	24 Sep 98	L. Abrams
3	Via DMTEC	26 March 14	C. Diss

**2. REQUIREMENTS****2.1 Composition, Appearance and Colour**

The sleeving shall be homogeneous and essentially free from pinholes, flaws, bubbles, cracks, seams, defects and inclusions. The colour shall be as specified in the contract or order.

**2.2 Dimensions**

Size	Inside Diameter as supplied (min) mm	Inside Diameter after recovery (max) mm	Total Wall Thickness after recovery mm	Inner Meltable Wall Thickness after recovery (nom) mm
3/1	3.0	1.0	1.00 ± 0.30	0.50
6/2	6.0	2.0	1.00 ± 0.30	0.50
9/3	9.0	3.0	1.40 ± 0.30	0.60
12/4	12.0	4.0	1.78 ± 0.38	0.75
19/6	19.0	6.0	2.25 ± 0.55	0.80
24/8	24.0	8.0	2.54 ± 0.55	1.00
40/13	40.0	13.0	2.54 ± 0.55	1.00

Sleeving of special expanded or recovered dimensions may be supplied as specified in the contract or order.

**2.3 Test Requirements**

The test requirements shall be as specified in Table 1.

### 3. TEST METHODS

#### 3.1 Preparation of Test Specimen

Unless otherwise specified, tests shall be carried out on specimens of sleeving recovered by conditioning in a fan assisted air circulating oven at  $200 \pm 5^\circ\text{C}$  for  $6 \pm 1$  minutes and allowed to cool in air to ambient temperature. No pre-conditioning period is required prior to testing. Unless otherwise specified, all tests shall be made under standard ambient conditions according to IEC Publication 212. In cases of dispute the tests shall be carried out at a temperature of  $23 \pm 2^\circ\text{C}$  and at  $50 \pm 5\%$  relative humidity.

---

#### 3.2 Dimensions and Longitudinal Change

The test method shall be as specified in ASTM D2671. The length and inside diameter of three 150mm long specimens of expanded sleeving shall be measured. The specimens shall be recovered in a fan assisted air circulating oven and the length and inside diameter of each shall be measured. The longitudinal change shall be expressed as a percentage of the original length. The minimum and maximum recovered wall thickness shall be determined.

---

#### 3.3 Tensile Strength and Ultimate Elongation

The test method shall be as specified in ISO 37. Determine the Tensile Strength based on the cross-sectional area of the jacket only. Use suitable optical method (e.g. microscope) to measure the thickness of the outer wall for this calculation. For sleeving of recovered bore greater than 4mm, five Type 2 dumb-bell specimens shall be tested. For sleeving of recovered bore less than or equal to 4mm, five tubular specimens 125mm long shall be tested. Initial jaw separation shall be 50 mm and rate of jaw separation shall be  $50 \pm 5$  mm per minute. The test shall be carried out at a temperature of  $23 \pm 2^\circ\text{C}$ .

---

#### 3.4 Secant Modulus at 2% Strain

The test method shall be as specified in Method A of ASTM D882. For sleeving of recovered bore greater than 6mm, five strip specimens 150mm long shall be tested. For sleeving of recovered bore less than or equal to 6mm five tubular specimens 150mm long shall be tested. Initial jaw separation shall be 100mm and rate of jaw separation  $10 \pm 1$  mm per minute. The test shall be carried out at a temperature of  $23 \pm 2^\circ\text{C}$ .

---

#### 3.5 Specific Gravity

The test method shall be as specified in Method A of ISO 1183.

**TEST METHODS (Cont'd)****3.6 Inner Wall Adhesion**

The test shall be carried out on Size 40/13 ATUM. Five cylindrical rolling drum adhesion test mandrels 25mm long by 25mm diameter and of surface material as specified shall be cleaned and degreased. Specimens of Size 40/13 ATUM approximately 50mm long shall be recovered on to the mandrels by conditioning in a fan assisted air circulating oven at  $150 \pm 3^\circ\text{C}$  for 20 minutes. After conditioning the specimens shall be removed from the oven and allowed to cool naturally to room temperature. Surplus lengths of ATUM shall be trimmed level with the ends of the mandrels. The specimens shall be slit axially and peeled from the mandrels in a suitable tensile testing machine such that the sleeving peels off at a rate of  $50 \pm 5\text{mm}$  length per minute as the mandrel rotates. See Figure 1. The test shall be carried out at a temperature of  $23 \pm 2^\circ\text{C}$ . The mean peel-off force for each specimen shall be recorded, and the mean of the five recorded measurements reported as the Inner Wall Adhesion.

---

**3.7 Heat Shock**

The test method shall be as specified in ASTM D2671.  
The specimens shall be conditioned in a fan assisted air circulating oven as specified in Table 1.

---

**3.8 Heat Ageing**

The test method shall be as specified in ISO 188.  
For sleeving of recovered bore greater than 6mm, five strip specimens 75mm x 6mm, shall be tested. For sleeving of recovered bore less than or equal to 6mm, five tubular specimens 75mm long shall be tested. The specimens shall be conditioned in a fan assisted air circulating oven as specified in Table 1.

---

**3.9 Low Temperature Flexibility**

The test method shall be as specified in Procedure C of ASTM D2671.  
The sleeving shall be tested in the as supplied state.  
Mandrel diameter shall be  $20 \times$  specimen thickness  $\pm 10\%$ .  
The specimens and mandrels shall be conditioned as specified in Table 1.

---

**3.10 Flammability**

The test method shall be as specified in Procedure B of ASTM D2671.

---

**3.11 Electric Strength**

The test method shall be as specified in IEC 243 (short-time test).

---

**3.12 Copper Mirror Corrosion**

The test method shall be as specified in ASTM D2671.  
The specimens shall be conditioned as specified in Table 1.

**TEST METHODS (Cont'd)****3.13 Water Absorption**

The test method shall be as specified in Method 1 of ISO 62.

For sleeving of recovered bore greater than 8mm, three disc specimens of diameter  $25 \pm 1$ mm shall be cut from the sleeving. For sleeving of recovered bore less than or equal to 8mm, three tubular specimens 50mm long shall be cut from the sleeving.

**3.14 Fluid Resistance**

The test method shall be as specified in ISO 1817.

Five tensile test specimens prepared as in Clause 3.3. shall be completely immersed in each of the fluids for the times and temperatures specified in Table 1. The volume of the fluid shall not be less than 20 times that of the specimen. After immersion, lightly wipe the specimens and allow to air dry at  $23 \pm 2^\circ\text{C}$  for  $1\text{h} \pm 15\text{m}$ . The Tensile Strength and Ultimate Elongation of each specimen shall be tested according to Clause 3.3. The test shall be repeated on the remaining specified fluids.

**4. RELATED STANDARDS & issue**

ASTM D882: 1991	Standard Test Methods for Tensile Properties of Thin Plastic Sheeting
ASTM D2671: 1995	Standard Test Methods for Heat-Shrinkable Tubing for Electrical Use
IEC 212: 1971	Standard Conditions for Use Prior to and During Testing of Solid Electrical Insulating Materials
IEC 243-1: 1988	Methods of Test for Electric Strength of Solid Insulating Materials Part 1 Tests at Power Frequencies
ISO 37: 1994	Rubber, vulcanized or thermoplastic - Determination of Tensile Stress-Strain Properties
ISO 62: 1980	Determination of Water Absorption
ISO 188: 1982	Rubber, vulcanized - Accelerated Ageing or Heat Resistance Tests.
ISO 1183: 1987	Methods for determining the density and relative density of non-cellular plastics
ISO 1817: 1985	Rubber, vulcanized - Determination of the effect of liquids

**Subsequent amendments to, or revisions of, any of the above publications apply to this standard only when incorporated in it by updating or revision.**

**5. SAMPLING**

Tests shall be carried out on a sample taken at random from each batch of finished sleeving. A batch of sleeving is defined as that quantity of sleeving extruded at any one time. Testing frequency shall be Production Routine or Qualification. Production Routine tests consisting of Visual Examination, Dimensions, and Longitudinal Change shall be carried out on every batch of sleeving.

Qualification tests shall be carried out to the requirements of the Design Authority.

**6. PACKAGING**

Packaging shall be in accordance with good commercial practice. Each package shall bear an identification label showing material quantity, description, size, colour and batch number.

Additional information shall be supplied as specified in the contract or order.

**FIGURE 1 - Peel Specimen in Tensile Tester**

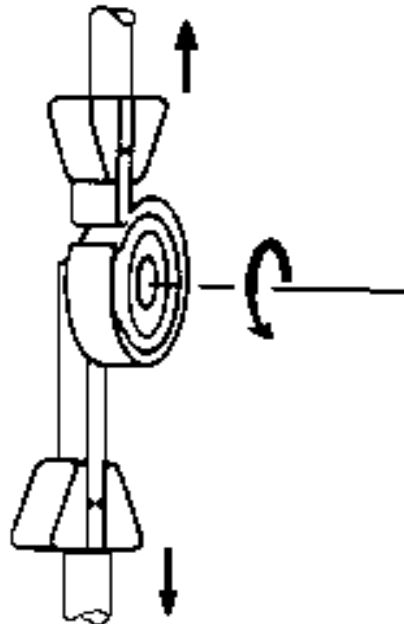


TABLE 1 Test Requirements

Test	Test Method	Test Requirements
Visual Examination	-	As per Clause 2.1
Dimensions	ASTM D2671	As per Clause 2.2
Longitudinal Change	ASTM D2671	0 to -15%
Tensile Strength	ISO 37	9.0 MPa minimum
Ultimate Elongation	ISO 37	200% minimum
Specific Gravity	ISO 1183	1.25 maximum
Secant Modulus at 2% Strain	ASTM D882	125 MPa maximum
Inner Wall Adhesion - RNF-100 to ATUM - ATUM to Aluminium	Clause 3.6	150 N /25mm minimum 60 N /25mm minimum
Heat Shock (4h ± 15m at 225 ± 5°C)	ASTM D2671	No dripping, cracking or flowing of outer wall
Heat Ageing (168 ± 2h at 150 ± 3°C)	ISO 188	No dripping, cracking or flowing of outer wall
Low Temperature Flexibility (4h ± 15m at -55 ± 2°C)	ASTM D2671	No cracking
Electric Strength	IEC 243-1	12 MV/m minimum
Flammability Coloured ATUM outer wall only	ASTM D2671	Duration of Burning 60s maximum. No burning or charring of indicator
Copper Mirror Corrosion (16h ± 30m at 150 ± 3°C)		No corrosion of mirrors
Water Absorption (24 ± 2h immersion at 23 ± 2°C)	ISO 62	0.5% maximum

**TABLE 1 Test Requirements (Cont'd)**

Test	Test Method	Test Requirements
Fluid Resistance 24 ± 2h immersion at 23 ± 2°C <ul style="list-style-type: none"> <li>• Diesel Fuel to BS 2869 Class A1</li> <li>• Hydraulic Fluid to H-515 (Mil-H-5606)</li> <li>• Lubricating Oil to O-149</li> </ul>	ISO 1817	
<ul style="list-style-type: none"> <li>- Tensile Strength</li> <li>- Ultimate Elongation</li> </ul>	ISO 37	5 MPa minimum 200% minimum

**In line with a policy of continual product development, TE Connectivity reserves the right to make changes in construction, materials and dimensions without further notice. You are advised, therefore, to contact TE Connectivity, should it be necessary to ensure that this document is the latest issue.**