



RW 2051 Revision 3

LSTT SLEEVING

SCOPE

This Quality Assurance Specification establishes the quality standard for a heat-shrinkable polyolefin sleeving

Approved Signatories*

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1. REVISION HISTORY

Revision Number	Change Request	Date	Incorporated By
0	Formerly RK6209 Revn 6		
1	CRF P1097 CRF T1020 CR-98-DM0028	30 May 1996 27 August 1997 06 February 1998	L. Abrams C. Woosnam L. Abrams
2	CR02-DM-0157	05 August 1998	L. Abrams
3	Via DMTEC	27 February 2014	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	Wall Thickness after recovery mm
1.6	1.6	0.8	0.50 ± 0.12
2.4	2.4	1.2	0.55 ± 0.12
3.2	3.2	1.6	0.55 ± 0.12
4.8	4.8	2.4	0.55 ± 0.12
6.4	6.4	3.2	0.65 ± 0.12
9.5	9.5	4.8	0.65 ± 0.15
12.7	12.7	6.4	0.65 ± 0.15
19.0	19.0	9.5	0.80 ± 0.15
25.4	25.4	12.7	0.95 ± 0.18
32.0	32.0	16.0	1.05 ± 0.20
38.0	38.0	19.0	1.05 ± 0.20
52.0	52.0	26.0	1.14 ± 0.18

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 Specimens

Unless otherwise specified, tests shall be carried out on specimens of sleeving recovered by conditioning in a fan assisted air circulating oven at $125 \pm 5^\circ\text{C}$ for 6 ± 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. For sleeving of recovered bore greater than 6mm, five Type 2 dumb-bell specimens shall be tested. For sleeving of recovered bore less than or equal to 6mm, five tubular specimens 125mm long shall be tested. Initial jaw separation shall be 50 mm and rate of jaw separation shall be $100 \pm 10\text{mm}$ per minute. The test shall be carried out at a temperature of $23 \pm 2^\circ\text{C}$.

3.4 Secant Modulus

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 $10 \pm 1\text{mm}$ per minute. The test shall be carried out at a temperature of $23 \pm 2^\circ\text{C}$.

3.5 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.

3.6 Heat Ageing

The test method shall be as specified in ISO 188. Five tensile test specimens prepared as in Clause 3.3 shall be conditioned in a fan assisted air circulating oven as specified in Table 1. After conditioning the specimens shall be removed from the oven, allowed to cool naturally to room temperature and tested for Tensile Strength and Ultimate Elongation according to clause 3.3.

TEST METHODS (Cont'd)**3.7 Recovery at 80 °C**

Measure the internal diameter of the sleeving in both the expanded and fully recovered state. Immerse one 60mm long specimen of expanded sleeving completely in water for the time and temperature as specified in Table 1. Remove the sleeving and quench immediately in cold water. Cut the sleeving into 3 pieces each 20mm in length and measure the partially recovered internal diameter. Calculate the average.

Determine the percentage recovery from the formula:

$$(\text{ID Expanded} - \text{ID Partially Recovered}) / (\text{ID Expanded} - \text{ID Fully Recovered}) \times 100\%$$

3.8 Low Temperature Flexibility

The test method shall be as specified in Procedure C of ASTM D2671. For sleeving of recovered bore 6mm or less, apply the test to whole sections of recovered sleeving. For sleeving of recovered bore greater than 6mm, apply the test to strips 6mm wide, cut from the recovered sleeving, with their lengths parallel to the extruded axis. Mandrel diameter shall be 20 x specimen thickness \pm 10%. For tubular specimens the thickness is the outside diameter. The specimens and mandrel shall be conditioned as specified in Table 1.

3.9 Flammability Test

The test method shall be as specified in MVSS 302.

3.10 Electric Strength

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

3.11 Copper Contact Corrosion

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, allowed to cool naturally to room temperature and tested for Ultimate Elongation according to Clause 3.3.

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.

3.13 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°C for 1h \pm 15m. 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.

TEST METHODS (Cont'd)**3.14 Clarity Stability (Clear Product Only)**

A specimen of sleeving approximately 100mm in length shall be conditioned in a fan assisted air circulating oven as specified in Table 1. After conditioning, the specimen shall be removed from the oven, slit the longitudinally and pressed flat. Place the flattened sleeving over printed text of 8-point Helvetica medium type and checked for legibility of print using normal reading vision.

4. RELATED STANDARDS & issue

ASTM D882-00	Standard Test Methods for Tensile Properties of Thin Plastic Sheeting
ASTM D2671-00	Standard Test Methods for Heat-Shrinkable Tubing for Electrical Use
IEC 60212: 1971	Standard Conditions for Use Prior to and During Testing of Solid Electrical Insulating Materials
IEC 60243-1: 1998	Electrical Strength Of Insulating Materials - Test Methods - Tests At Power Frequencies
ISO 37: 1994	Rubber, vulcanized or thermoplastic - Determination of Tensile Stress-Strain Properties
ISO 188: 1998	Rubber, vulcanized - Accelerated Ageing or Heat Resistance Tests.
ISO 1817: 1999	Rubber, vulcanized - Determination of the effect of liquids
MVSS 302: 1975	Flammability of Materials - Passenger Cars, Multiple Passenger Vehicles, Trucks and Buses (Docket N. 3-3; Notice 4)

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, batch number and maximum storage temperature. Additional information shall be supplied as specified in the contract or order.

TABLE 1 Test Requirements

Test	Test Method	Test Requirements
Visual	-	As per Clause 2.1
Dimensions	ASTM D2671	As per Clause 2.2
Longitudinal Change	ASTM D2671	+1 to -10%
Tensile Strength	ISO 37	15 MPa minimum
Ultimate Elongation	ISO 37	300% minimum
Secant Modulus at 2% Strain	ASTM D882	70 MPa maximum
Heat Shock (4h ± 15m at 150 ± 5°C)	ASTM D2671	No dripping, cracking or flowing
Heat Ageing (168 ± 2h at 125 ± 3°C)	ISO 188	
- Tensile Strength	ISO 37	15 MPa minimum
- Ultimate Elongation		300% minimum
Recovery at 80°C (30 ± 5 seconds at 80 ± 2°C)		50% minimum
Low Temperature Flexibility (4h ± 15m at -45 ± 2°C)	ASTM D2671	No cracking
Flammability Test Burning Rate	MVSS 302	100mm/minute maximum
Electric Strength	IEC 243-1	15 MV/m minimum
Copper Contact Corrosion (24 ± 2h on copper mandrel at 90-95% RH, 23 ± 2°C, followed by 168 ± 2h on mandrel at 150 ± 3°C)	ASTM D2671	No corrosion of mandrel
-Ultimate Elongation	ISO 37	200% minimum
Copper Mirror Corrosion (16h ± 30 m at 150 ± 3°C)		No corrosion of mirrors

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TABLE 1 Test Requirements (Cont'd)

Clarity Stability (Clear Product Only)		Printing must be legible beneath sleeving, discolouration of sleeving acceptable providing print is legible
Fluid Resistance (24 ± 2h immersion at 23 ± 2°C)	ISO 1817	
<ul style="list-style-type: none"> • Gasoline Fuel to ISO 1817 Test liquid B • Lubricating Oil to O-148 • Hydraulic Fluid to SAE J1703 • Diesel Fuel to BS 2869 Class A1 • Water • Battery Acid to BS 2031 • Antifreeze (Ethylene Glycol) / Water 50/50 v/v 	ISO 37	8 MPa minimum 200% minimum
- Tensile Strength		
- Ultimate Elongation		

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