

## **Raychem SST/SST-FR Tubing Adhesive Sealing Heat-Shrinkable**

### **1. SCOPE**

This specification covers requirements for two types of electrically insulating, extruded tubing whose diameter will reduce to a predetermined size upon the application of heat in excess of 120°C. It is suitable for use with Hot Melt Adhesive /97 or Sealant /226.

#### **SST**

SST tubing is not flame retardant and shall be black, white, red, yellow or clear unless otherwise specified. The standard color is black.

#### **SST-FR**

SST-FR is flame retardant and shall be black, white, red or yellow. The standard color is black.

### **2. REQUIREMENTS**

#### **Composition and Appearance**

The tubing shall be fabricated from thermally stabilized, modified polyolefin and shall be irradiation cross-linked. It shall be homogeneous and essentially free from flaws, defects, pinholes, bubbles, seams, cracks and inclusions.

### **3. PROPERTIES**

The tubing shall meet the requirements of Tables 1 and 2.

### **4. QUALITY ASSURANCE PROVISIONS**

#### **4.1 Classification of Tests**

##### **4.1.1 Qualification Tests**

Qualification tests are those performed on tubing submitted for qualification as a satisfactory product and shall consist of all tests listed in this specification.

##### **4.1.2 Production Routine Tests**

Production routine tests shall be carried out on every batch, unless otherwise specified and shall consist of the following: dimensions, longitudinal change, tensile strength, ultimate elongation, heat shock, low temperature flexibility and flammability. Flammability is not applicable to SST.

### **5. SAMPLING INSTRUCTIONS**

#### **5.1 Qualification Test Samples**

Qualification test samples shall consist of 50 feet (15m) of tubing. Qualification of any size qualifies all sizes. The color shall be black.

#### **5.2 Production Routine Test Samples**

Production routine test samples shall consist of a sufficient length to perform the tests listed in 4.1.2 selected at random from each batch. A batch shall consist of all tubing of the same size, from the same production run and offered for inspection at the same time. Physical property tests performed at this time qualify subsequent tubing lots produced from the same compound batch.

## 6. TEST PROCEDURES

Unless otherwise specified the tubing shall be recovered in a forced air circulating oven for 10 minutes at  $150 \pm 2^\circ\text{C}$ . All tests shall be performed without the adhesive. Uncoated samples are available upon request.

### 6.1 Dimensions and Longitudinal Change

The test method shall be as specified in ASTM D2671.

The length and inside diameter of three 250 mm long specimens of expanded tubing shall be measured. The specimens shall be recovered 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 thicknesses shall be determined.

### 6.2 Tensile Strength and Ultimate Elongation.

The test method shall be as specified in ASTM D 638.

For tubing of recovered inside diameter greater than 6 mm, five Type IV dumbbell specimens shall be tested. For tubing of recovered inside diameter less than or equal to 6 mm, five tubular specimens 150 mm long shall be tested. Rate of jaw separation shall be  $500 \pm 10$  mm per minute.

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

## 7. PREPARATION FOR DELIVERY

### 7.1 Form

The tubing shall be supplied in cut lengths unless otherwise specified.

### 7.2 Packaging

Packaging shall be in accordance with good commercial practice.

### 7.3 Marking

Each container of tubing shall be permanently and legibly marked with the size, quantity, manufacturer's identification and batch number.

## 8. RELATED DOCUMENTS

MIL-A-8243	De-icing Fluid
SAE-AMS-DTL-23053	Insulation Tubing, Electrical, Heat Shrinkable, General Specification
MIL-H-5606	Hydraulic Fluid, Petroleum Base, Aircraft, Missile and Ordnance
MIL-DTL-83133	Turbine Fuel, Aviation, Grade JP-8
MIL-STD-104	Limits for Electrical Insulating Color
MIL-PRF-7808	Lubricating Oil
MIL-L-23699	Lubricating Oil
A-A-694	5% NaCl
ASTM D 2671	Standard Test Methods for Heat-Shrinkable Tubing for Electrical Use
ASTM D 882	Standard Test Methods for Tensile Properties of Thin Plastic Sheeting
ASTM D 876	Standard Test Methods for Non Rigid Vinyl Chloride Polymer Tubing Used for Electrical Insulation
ASTM D 792	Standard Test Method for Specific Gravity (Relative Density) and Density of Plastic by Displacement
ISO 846 Method B	Plastics – Evaluation of the Action of Microorganisms
ASTM D 638	Standard Methods for Tensile Properties of Plastics
ASTM D 570	Standard Test Method for Water Absorption

<b>TABLE 1</b>			
<b>TUBING DIMENSIONS</b>			
<b>Part Number</b>	<b>Internal Diameter, mm</b>		<b>Wall Thickness Nom., mm</b>
	<b>D (Min.) Expanded as Supplied</b>	<b>D (Max.) Recovered After Heating</b>	<b>W (Nom.) Total Wall Recovered After Heating</b>
SST-*-03	7.7 (0.300)	2.6 (0.100)	1.8 (0.070)
SST-*-04	10.2 (0.400)	3.9 (0.150)	1.8 (0.070)
SST-*-07M	19.1 (0.750)	5.6 (0.220)	1.8 (0.070)
SST-*-07	19.1 (0.750)	5.6 (0.220)	2.3 (0.090)
SST-*-11M	27.9 (1.100)	9.5 (0.380)	2.8 (0.110)
SST-*-11	27.9 (1.100)	9.5 (0.380)	3.0 (0.120)
SST-*-13M	33.1 (1.300)	9.6 (0.380)	2.8 (0.110)
SST-*-13	33.1 (1.300)	9.6 (0.380)	3.0 (0.120)
SST-*-15M	38.1 (1.500)	12.7 (0.500)	3.0 (0.120)
SST-*-15	38.1 (1.500)	12.7 (0.500)	3.6 (0.140)
SST-*-17M	43.2 (1.700)	12.7 (0.500)	3.0 (0.120)
SST-*-17	43.2 (1.700)	12.7 (0.500)	3.6 (0.140)
SST-*-20M	50.8 (2.000)	19.1 (0.750)	3.0 (0.120)
SST-*-20	50.8 (2.000)	19.1 (0.750)	4.1 (0.160)
SST-*-27	68.6 (2.700)	22.9 (0.900)	4.1 (0.160)
SST-*-30	76.2 (3.000)	31.8 (1.250)	4.1 (0.160)
SST-*-40	101.6 (4.000)	44.5 (1.750)	4.1 (0.160)
SST-*-45	114.3 (4.500)	44.5 (1.750)	4.1 (0.160)

\* Cut Length ( ) Inches  
M, Indicates Medium Wall

**TABLE 2**  
**REQUIREMENTS**

PROPERTY	UNIT	SST	SST-FR	TEST METHOD
<b>PHYSICAL</b>				
Dimensions	mm (in.)	In accordance with Table 1	In accordance with Table 1	Section 6.1 ASTM D 2671
Longitudinal Change	Percent	+1, -10	+1, -10	Section 6.1 ASTM D 2671
Tensile Strength	MPa	8.4 Min.	8.4 Min.	Section 6.2 ASTM D 638
Ultimate Elongation	Percent	300 Min.	200 Min.	Section 6.2 ASTM D 638
Secant Modulus (Expanded)	MPa	N/A	172.4 Max.	ASTM D 882
Specific Gravity		1.4 Max.	1.5 Max.	ASTM D 792
Low Temperature Flexibility 4 hours at -55 ± 2°C		No cracking	No cracking	SAE-AMS-DTL-23053
Heat Shock 4 hours at 225 ± 3°C		No dripping, flowing or cracking	No dripping, flowing or cracking	SAE-AMS-DTL-23053
Heat Resistance 168 hrs at 175°C for SST-FR 168 hrs at 175°C for SST Followed by tests for Tensile Strength Ultimate Elongation	MPa Percent	7 Min. 100 Min.	7 Min. 100 Min.	ASTM D 638 ASTM D 638
Color		Pass	Pass	MIL-STD-104
Color Stability		Pass	Pass	SAE-AMS-DTL-23053
<b>ELECTRICAL</b>				<b>*Note 1</b>
Dielectric Strength	KV/mm	7.9 Min.	7.9 Min.	ASTM D 2671
Volume Resistivity	Ohm-cm	10 <sup>15</sup> Min.	10 <sup>13</sup> Min.	ASTM D 876
<b>CHEMICAL</b>				
Copper Mirror Corrosion 16 hours at 120 ± 2°C		No removal of copper	No removal of copper	SAE-AMS-DTL-23053
Copper Contact Corrosion 16 hours at 120 ± 2°C		No pitting or blackening of copper	No pitting or blackening of copper	SAE-AMS-DTL-23053
Flammability	Seconds	N/A	60 Max.	SAE-AMS-DTL-23053 Procedure C ASTM D 2671
Fungus Resistance Followed by tests for Tensile Strength Ultimate Elongation Dielectric Strength	MPa Percent KV/mm	8.4 Min. 300 Min. 7.9 Min.	8.4 Min. 200 Min. 7.9 Min.	ISO 846 Method B ASTM D 638 ASTM D 638 ASTM D 2671
Water Absorption 24 hours at 23 ± 2°C	Percent	0.5 Max.	0.5 Max.	ASTM D 570
Fluid Resistance 24 hours at 23 ± 2°C JP-8 Fuel (MIL-DTL-83133) Hydraulic Fluid (MIL-H-5606) De-icing Fluid (MIL-A-8243) Lube Oil (MIL-PRF-7808) Lube Oil (MIL-L-23699) 5% NaCl (A-A-694) Followed by tests for Tensile Strength	MPa	5.2 Min.	5.2 Min.	SAE-AMS-DTL-23053 ASTM D 638
Ultimate Elongation	Percent	100 Min.	100 Min.	ASTM D 638
Dielectric Strength	KV/mm	7.9 Min.	7.9 Min.	ASTM D 2671 <b>*Note 2</b>

**\*Note 1:** Recover specimens on the metal mandrels for 10 minutes, minimum, at 200 ± 3°C or until the tubing is completely recovered on the mandrel.

**\*Note 2:** For dielectric strength, immerse the recovered specimens in the fluids for 24 hours at 50 ± 2°C. After drying, place the specimens over closest fitting metal mandrels.