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**Raychem  
Tubing**

Specification  
This Issue:  
Date:  
Replaces:

**RT-360**  
Issue 10  
30-Jan-15  
Issue 9

## **THERMOFIT® CRN TUBING Polyolefin, Semirigid, Heat-Shrinkable**

### **1. SCOPE**

This specification covers the requirements for two types of semirigid electrical insulating, extruded tubing whose diameter will reduce to a predetermined size upon the application of heat in excess of 135°C (275°F).

#### **1.1 TYPE 1**

Type 1 tubing shall be flame-retardant and shall be black.

#### **1.2 TYPE 2**

Type 2 tubing shall not be flame-retardant and shall be clear.

### **2. APPLICABLE DOCUMENTS**

This specification takes precedence over documents referenced herein. Unless otherwise specified, the latest issue of referenced documents applies. The following documents form a part of this specification to the extent specified herein.

#### **2.1 GOVERNMENT-FURNISHED DOCUMENTS**

##### Military

MIL-G-5572 Gasoline, Aviation, Grades 80/87, 100/130, and 115/145

MIL-PRF-5606 Hydraulic Fluid, Petroleum Base, Aircraft, Missile and Ordinance

MIL-T-83133 Turbine Fuel, Aviation, Grades JP-8

## 2.2 OTHER PUBLICATIONS

### American Society for Testing and Materials (ASTM)

D 2671 Standard Methods of Testing Heat-Shrinkable Tubing for Electrical Use

(Copies of ASTM publications may be obtained from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, Pennsylvania 19103.)

### International Organization for Standardization (ISO)

ISO 846 Plastics – Evaluation of the action of Microorganisms

(Copies of ISO publications may be obtained from the International Organization for Standardization, 1, rue de Varembé, CH-1211 Geneva 20, Switzerland or via the ISO website at <http://www.iso.ch/iso/en/ISOOnline.frontpage>)

## 3. REQUIREMENTS

### 3.1 MATERIALS

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

### 3.2 PROPERTIES

The tubing shall meet the requirements of Table 3.

## 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 Acceptance Tests

Acceptance tests are those performed on tubing submitted for acceptance under contract. Acceptance tests shall be: dimensions, longitudinal change, tensile strength, ultimate elongation, secant modulus, flammability (Type 1 only), and heat shock. Statistical process control data may be used to demonstrate conformance for dimensions.

## 4.2 SAMPLING INSTRUCTIONS

### 4.2.1 Qualification Test Samples

Qualification test samples shall consist of 50 feet (15 m) of black and clear tubing. Qualification of any size within each size range specified below shall qualify all sizes within that size range.

**Range of Sizes**

3/64 through 1/4

3/8 through 3/4

### 4.2.2 Acceptance Test Sample

Acceptance test samples shall consist of not less than 16 feet (5 m) of tubing selected at random from each compound batch or the first sleeving production lot of the batch compound. Physical property tests performed at this time qualify subsequent sleeving lots produced from the same compound batch.

## 4.3 TEST PROCEDURES

Unless otherwise specified, perform tests on specimens which have been fully recovered by conditioning for 3 minutes in a  $200 \pm 5^{\circ}\text{C}$  ( $392 \pm 9^{\circ}\text{F}$ ) oven. Condition the test specimens (and measurement gauges, when applicable) for 3 hours at  $23 \pm 3^{\circ}\text{C}$  ( $73 \pm 5^{\circ}\text{F}$ ) and  $50 \pm 5$  percent relative humidity for 3 hours prior to all testing. Use mechanical convection type ovens in which air passes the specimens at a velocity of 100 to 200 feet (30 to 60 m) per minute.

### 4.3.1 Dimensions and Longitudinal Change

Measure three 6-inch (150 mm) specimens of tubing, as supplied, for length  $\pm 1/32$  inch ( $\pm 1$  mm), and inside diameter in accordance with ASTM D 2671. Condition the specimens for 3 minutes in a  $200 \pm 5^{\circ}\text{C}$  ( $392 \pm 9^{\circ}\text{F}$ ) oven, cool to  $23 \pm 3^{\circ}\text{C}$  ( $73 \pm 5^{\circ}\text{F}$ ) and remeasure. Prior to and after conditioning, the dimensions of the tubing shall be in accordance with Table 1 and the longitudinal change shall be in accordance with Table 3. Calculate the longitudinal change as follows:

$$C = \frac{L_1 - L_0}{L_0} \times 100$$

Where: C = Longitudinal Change [Percent]  
 L<sub>0</sub> = Length Before Conditioning [Inches (mm)]  
 L<sub>1</sub> = Length After Conditioning [Inches (mm)]

#### 4.3.2 Tensile Strength and Ultimate Elongation

Determine the tensile strength and ultimate elongation of the tubing in accordance with ASTM D 2671 using 1-inch (25-mm) bench marks, a 1-inch (25-mm) initial jaw separation, and jaw separation speed of  $2 \pm 0.2$  inches ( $50 \pm 5$  mm) per minute.

#### 4.4 REJECTION AND RETEST

Failure of any sample of tubing to conform to any one of the requirements of this specification shall be cause for rejection of the lot represented. Tubing which has been rejected may be replaced or reworked to correct the defects and resubmitted for acceptance. Before resubmitting, full particulars concerning previous rejection and action taken to correct the defects shall be furnished to the inspector.

### 5. PREPARATION FOR DELIVERY

#### 5.1 PACKAGING

Packaging shall be in accordance with good commercial practice.

#### 5.2 MARKING

Each container of tubing shall be permanently and legibly marked with the size, quantity, manufacturer's name, part number, specification number, and lot number.

**TABLE 1  
Tubing Dimensions**

Size	As Supplied		As Recovered								
	Inside Diameter Minimum		Inside Diameter Maximum		Wall Thickness						
	in.	mm.	in.	mm.	Minimum		Maximum		Nominal		
				in.	mm.	in.	mm.	in.	mm.	in.	mm.
3/64	.046	1.17	.023	0.58	.017	0.43	.023	0.58	.020	0.50	
1/16	.063	1.60	.031	0.79	.017	0.43	.023	0.58	.020	0.50	
3/32	.093	2.36	.046	1.17	.017	0.43	.023	0.58	.020	0.50	
1/8	.125	3.17	.062	1.57	.017	0.43	.023	0.58	.020	0.50	
3/16	.187	4.74	.093	2.36	.022	0.56	.028	0.71	.025	0.63	
1/4	.250	6.35	.125	3.17	.022	0.56	.028	0.71	.025	0.63	
3/8	.375	9.50	.187	4.74	.027	0.69	.033	0.84	.030	0.76	
1/2	.500	12.70	.250	6.35	.027	0.69	.033	0.84	.030	0.76	
3/4	.750	19.05	.375	9.53	.030	0.76	.040	1.016	.035	0.889	

**TABLE 2  
Mandrel Dimensions for Bend Testing**

Tubing Size	Mandrel Diameter	
	in.	mm.
3/64 to 1/4 inclusive	5/16	7.9
3/8 to 1/2 inclusive	3/8	9.5
3/4	7/16	11.1

**TABLE 3**  
**Requirements**

PROPERTY	UNIT	REQUIREMENT		TEST METHOD
		TYPE 1	TYPE 2	
<b>PHYSICAL</b> Dimensions	Inches ( <i>mm</i> )	In accordance with Table 1	In accordance with Table 1	Section 4.3.1 ASTM D 2671
Longitudinal Change	Percent	+/-5	+/-5	
Tensile Strength	psi ( <i>MPa</i> )	2000 (13.8) minimum	2000 (13.8) minimum	Section 4.3.2 ASTM D 2671
Ultimate Elongation	Percent	200 minimum	200 minimum	
Secant Modulus (Expanded)	psi ( <i>MPa</i> )	$2.5 \times 10^4$ (172) minimum	$2.5 \times 10^4$ (172) minimum	ASTM D 2671
Specific Gravity	---	1.35 maximum	1.0 maximum	ASTM D 2671
Low Temperature Flexibility 4 hours at $-55 \pm 1^\circ\text{C}$ ( $-67 \pm 2^\circ\text{F}$ )	---	No cracking	No cracking	Table 2 ASTM D 2671 Procedure C
Heat Shock 4 hours at $250 \pm 3^\circ\text{C}$ ( $482 \pm 5^\circ\text{F}$ )	---	No dripping, flowing or cracking	No dripping, flowing or cracking	Table 2 ASTM D 2671
Heat Resistance 168 hours at $175 \pm 2^\circ\text{C}$ ( $347 \pm 4^\circ\text{F}$ ) Followed by test for: Ultimate Elongation	---	---	---	ASTM D 2671
	Percent	150 minimum	150 minimum	
<b>ELECTRICAL</b> Dielectric Strength	Volts/mil ( <i>volts/mm</i> )	500 (19,680) minimum	500 (19,680) minimum	NOTE 1 ASTM D 2671
Volume Resistivity	ohm-cm	$10^{14}$ minimum	$10^{16}$ minimum	ASTM D 2671
<b>CHEMICAL</b> Copper Mirror Corrosion 16 hours at $150 \pm 2^\circ\text{C}$ ( $302 \pm 4^\circ\text{F}$ )	---	No removal of copper	No removal of copper	ASTM D 2671 Procedure A
Copper Contact Corrosion 168 hours at $150 \pm 2^\circ\text{C}$ ( $302 \pm 4^\circ\text{F}$ )	---	No pitting or blackening of copper	No pitting or blackening of copper	ASTM D 2671 Procedure B
Flammability	---	Self-extinguishing within 1 minute, 25% maximum flag burn, no falling burning particles	Not Applicable	ASTM D 2671 Procedure B

**TABLE 3**  
**Requirements**  
(continued)

PROPERTY	UNIT	REQUIREMENT		TEST METHOD
		TYPE 1	TYPE 2	
<b>CHEMICAL</b> (continued) Fungus Resistance  Followed by tests for: Tensile Strength  Ultimate Elongation Dielectric Strength	psi ( <i>Mpa</i> )  percent Volts per mil ( <i>volts per mm</i> )	2000 ( <i>13.8</i> ) minimum 200 minimum 500 ( <i>19,680</i> ) minimum  Rating - 0	2000 ( <i>13.8</i> ) minimum 200 minimum 500 ( <i>19,680</i> ) minimum  Rating - 0	ISO 846 Method B  Section 4.3.2  ASTM D 2671 ASTM D 2671  Or  ASTM G 21
Water Absorption 24 hours at 23 ± 3°C ( <i>73 ± 5°F</i> )	Percent	0.5 maximum	0.2 maximum	ASTM D 2671
Fluid Resistance 24 hours at 23 ± 3°C ( <i>73 ± 5°F</i> ) in: JP-8 Fuel (MIL-T-83133) Skydrol- 500 Hydraulic Fluid (MIL-PRF-5606) Aviation Gasoline (100/130) (MIL-G-5572) Water  Followed by tests for: Dielectric Strength  Tensile Strength	---  Volts/mil ( <i>volts/mm</i> ) psi ( <i>MPa</i> )	---  400 ( <i>15,760</i> ) minimum 1600 ( <i>11.0</i> ) minimum	---  400 ( <i>15,760</i> ) minimum 1600 ( <i>11.0</i> ) minimum	ASTM D 2671

NOTE 1: Recover the specimens on the metal mandrels for 10 minutes minimum, at 175 ± 3° C (*347 ± 5° F*) or until the tubing is completely shrunk on the mandrels.