



Tyco Electronics Corporation
300 Constitution Drive
Menlo Park, CA 94025 USA

Raychem

Specification
This Issue:
Date:
Replaces:

RW-3023
Issue 7
June 16, 2005
Issue 6

VERSAFIT V2 AND V4 TUBING

Polyolefin, Flexible, Heat-Shrinkable, Flame-Retardant

1. SCOPE

This specification covers the requirements for one type of flexible electrical insulating, extruded tubing whose diameter will reduce to a predetermined size upon the application of heat in excess of 90°C (194°F). The tubing is free of polybrominated biphenyls (PBB) and polybrominated biphenyl oxides (PBBO).

VERSAFIT V2, a standard wall 125°C, VW-1 rated, UL recognized tubing meeting the requirements of UL 224. VERSAFIT V2 also meets the requirements of Standard C22.2 No. 198.1 and is CSA certified.

VERSAFIT V4, a thin wall very flexible 125°C, 300 volt, VW-1 rated, UL recognized tubing meeting the requirements of UL 224. VERSAFIT V4 also meets the requirements of Standard C22.2 No. 198.1 and is CSA certified with a 150 volt rating.

2. APPLICABLE DOCUMENTS

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

2.1 UNDERWRITERS LABORATORIES, INCORPORATED

UL Subject 224 Extruded Insulating Tubing

(Copies of UL publication may be obtained from Underwriters Laboratories, Inc., 1285 Walt Whitman Road, Melville, Long Island, New York 11746.)

2.2 CANADIAN STANDARDS ASSOCIATION

C22.2 No. 198.1 Extruded Insulating Tubing

(Copies of CSA publications may be obtained from Canadian Standards Association, 1897 Rexdale Boulevard, Rexdale, Ontario, Canada M9W 1R3.)

2.3 OTHER PUBLICATIONS

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>)

American Society for Testing and Materials (ASTM)

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.)

3. REQUIREMENTS

3.1 MATERIAL

The tubing shall be fabricated from thermally stabilized, flame-retardant, 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.

3.3 COLOR

The tubing shall be available in black, white, red, yellow, blue, green, brown, orange, violet and gray.

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 consist of the following:

Dimensions
Longitudinal Change
Tensile Strength
Ultimate Elongation

4.2 SAMPLING INSTRUCTIONS

4.2.1 Qualification Test Samples

Qualification test samples shall consist of 15m (*50 feet*) of tubing of the size and color specified. Qualification of one size or color shall qualify all sizes and colors.

4.2.2 Acceptance Test Samples

Acceptance test samples shall consist of not less than 5m (*16 feet*) of tubing selected at random from each lot. A lot shall consist of all tubing of the same size from the same production run and offered for inspection at the same time.

4.3 TEST PROCEDURES

Unless otherwise specified, tests shall be performed on specimens which have been fully recovered by conditioning in accordance with 4.3.1. Prior to all testing, the test specimen (and measurement gauges, when applicable) shall be conditioned for 3 hours at $23 \pm 3^{\circ}\text{C}$ ($73 \pm 5^{\circ}\text{F}$) and 50 ± 5 percent relative humidity. All ovens shall be of the mechanical convection type in which air passes the specimens at a velocity of 30 - 60m (*100 to 200 feet*) per minute.

4.3.1 Dimensions and Longitudinal Change

Three 150mm (6 inch) specimens of tubing, as supplied, shall be measured for length, to an accuracy of ± 1 mm ($\pm 1/32$ inch) and inside diameter in accordance with ASTM D 2671. The specimens then shall be conditioned for 3 minutes in a $200 \pm 3^\circ\text{C}$ ($392 \pm 5^\circ\text{F}$) oven, removed from the oven, cooled to $23 \pm 3^\circ\text{C}$ ($73 \pm 5^\circ\text{F}$), re-measured for length, inside diameter and wall thickness in accordance with ASTM D 2671. The longitudinal change shall be calculated as follows:

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

Where: C = Longitudinal Change (percent)
 L_0 = Length Before Conditioning [mm (inches)]
 L_1 = Length After Conditioning [mm (inches)]

4.3.2 Tensile Strength and Ultimate Elongation

The tensile strength and ultimate elongation of the tubing shall be determined in accordance with ASTM D 2671 using 25mm (1 inch) bench marks and a 25 mm (1 inch) initial jaw separation. The speed of jaw separation shall be 500 ± 50 mm (20 ± 2 inches) per minute.

4.3.3 Secant Modulus

The secant modulus of the tubing shall be tested using tubing as supplied in accordance with ASTM D 2671.

4.3.4 Copper Stability

Three 150mm (6 inch) specimens of tubing shall be slipped over a snug fitting, straight, clean, bare copper conductor. For tubing sizes 1/4 and smaller a solid conductor shall be used; for tubing sizes 3/8 and larger a solid or tubular conductor shall be used. The specimens on the conductors shall be conditioned for 24 hours in a desiccator or similar humidity chamber at 90 to 95 percent relative humidity and $23 \pm 3^\circ\text{C}$ ($73 \pm 5^\circ\text{F}$) (three specimens shall be conditioned for 7 days in $158.0 \pm 1.0^\circ\text{C}$ ($316.4 \pm 1.8^\circ\text{F}$) oven. After conditioning, the specimens shall be removed from the oven and cooled to $23 \pm 3^\circ\text{C}$ ($73 \pm 5^\circ\text{F}$). The copper conductor then shall be removed from the tubing, the tubing and conductor shall then be examined. Darkening of the copper due to normal air oxidation shall not be cause for rejection. The tubing then shall be conditioned at room temperature for 16 to 96 hours and tested for ultimate elongation in accordance with 4.3.2.

4.3.5 Dielectric Withstand, Breakdown and Strength

The dielectric strength of the tubing shall be measured under oil in accordance with ASTM D 2671. Five 150mm (6 inch) specimens of tubing shall be recovered over a metal mandrel by conditioning for 3 minutes in a $200 \pm 3^\circ\text{C}$ ($392 \pm 5^\circ\text{F}$) oven. The mandrel diameter shall be slightly larger than the fully recovered inside diameter of the tubing being tested. The metal mandrel shall serve as one electrode and a 25mm (1 inch) wide strip of lead foil wrapped around the outside of the tubing as the other electrode. The test voltage shall be applied at a rate of rise of 500 volts per second. Thickness measurements for calculating dielectric strength shall be made adjacent to the point of breakdown. Specimens for dielectric withstand shall be held for 60 seconds at 2500 volts.

4.3.6 Corrosive Effect

Three specimens of tubing shall be tested for copper contact corrosion in accordance with ASTM D 2671, Procedure B. Three specimens shall be conditioned for 7 days in a $158.0 \pm 1.0^\circ\text{C}$ ($316.4 \pm 1.8^\circ\text{F}$) oven. After conditioning, the specimens shall be visually examined for evidence of corrosion.

4.4 REJECTION AND RETEST

Failure of any samples 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 defect and then resubmitted for acceptance. Before resubmitting, full particulars concerning the rejection and the action taken to correct the defect shall be furnished to the inspector.

5. PREPARATION FOR DELIVERY**5.1 FORM**

The tubing shall be supplied on spools, unless otherwise specified.

5.2 PACKAGING

Packaging shall be in accordance with good commercial practice.

5.3 MARKING

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

TABLE 1**V2 TUBING DIMENSIONS,
METRIC**

Size	As Supplied (mm)		As Recovered (mm)	
	Inside Diameter	Wall Thickness	Inside Diameter	Wall Thickness
		nominal	maximum	minimum
0.8/0.4	1.2 ± 0.2	0.2	0.4	0.33
1.0/0.5	1.5 ± 0.2	0.2	0.5	0.33
1.5/0.75	2.1 ± 0.2	0.2	0.75	0.35
2.0/1.0	2.6 ± 0.2	0.25	1.0	0.43
2.5/1.25	3.1 ± 0.2	0.25	1.25	0.43
3.0/1.5	3.6 ± 0.2	0.25	1.5	0.43
3.5/1.75	4.1 ± 0.3	0.25	1.75	0.43
4.0/2.0	4.6 ± 0.3	0.25	2.0	0.43
5.0/2.5	5.6 ± 0.3	0.3	2.5	0.56
6.0/3.0	6.6 ± 0.3	0.3	3.0	0.56
7.0/3.5	7.6 ± 0.3	0.3	3.5	0.56
8.0/4.0	8.6 ± 0.3	0.3	4.0	0.56
9.0/4.5	9.6 ± 0.3	0.3	4.5	0.56
10.0/5.0	10.4 ± 0.3	0.3	5.0	0.56
11.0/5.5	11.4 ± 0.3	0.3	5.5	0.56
12.0/6.0	12.7 ± 0.3	0.3	6.0	0.56
13.0/6.5	13.5 ± 0.3	0.35	6.5	0.66
14.0/7.0	14.4 ± 0.4	0.35	7.0	0.68
15.0/7.5	15.7 ± 0.4	0.35	7.5	0.68
16.0/8.0	16.9 ± 0.4	0.35	8.0	0.68
18.0/9.0	19.0 ± 0.4	0.4	9.0	0.76
20.0/10.0	21.4 ± 0.4	0.4	10.0	0.76
22.0/11.0	23.2 ± 0.4	0.45	11.0	0.89
25.0/12.5	26.8 ± 0.4	0.45	12.5	0.89
27.0/12.5	28.2 ± 0.5	0.45	12.5	0.89
28.0/14.0	30.0 ± 0.5	0.45	14.0	0.89
30.0/15.0	32.1 ± 0.5	0.45	15.0	0.89

TABLE 2
V4 TUBING DIMENSIONS,
METRIC

Size	As Supplied (mm)		As Recovered (mm)	
	Inside Diameter	Wall Thickness	Inside Diameter	Wall Thickness
		nominal	maximum	minimum
0.6/0.3	0.95 ± 0.25	0.1	0.3	0.25
0.8/0.4	1.2 ± 0.25	0.1	0.4	0.25
1.0/0.5	1.4 ± 0.25	0.1	0.5	0.25
1.5/0.75	1.9 ± 0.25	0.1	0.75	0.25
2.0/1.0	2.3 ± 0.25	0.1	1.0	0.25
2.5/1.25	2.8 ± 0.25	0.15	1.25	0.25
3.0/1.5	3.3 ± 0.25	0.15	1.5	0.25
3.5/1.75	3.8 ± 0.25	0.15	1.75	0.25
4.0/2.0	4.4 ± 0.25	0.15	2.0	0.25
5.0/2.5	5.5 ± 0.25	0.15	2.5	0.25
6.0/3.0	6.5 ± 0.4	0.15	3.0	0.28
7.0/3.5	7.5 ± 0.4	0.15	3.5	0.28
8.0/4.0	8.5 ± 0.4	0.15	4.0	0.28
9.0/4.5	9.5 ± 0.4	0.15	4.5	0.28
10.0/5.0	10.5 ± 0.5	0.15	5.0	0.28

V4 TUBING DIMENSIONS,
USA CUSTOMARY

Size	AS SUPPLIED		RECOVERED			
	Inside Diameter		Inside Diameter		Wall Thickness	
	Minimum		Maximum		mm.	in.
	mm.	in.	mm.	in.		
3/64	1.17	.046	0.58	.023	.30 ± .05	.012 ± .002
1/16	1.60	.063	0.79	.031	.30 ± .05	.012 ± .002
3/32	2.36	.093	1.17	.046	.30 ± .05	.012 ± .002
1/8	3.17	.125	1.57	.062	.33 ± .05	.013 ± .002
3/16	4.74	.187	2.36	.093	.33 ± .05	.013 ± .002
1/4	6.35	.250	3.17	.125	.36 ± .05	.014 ± .002
3/8	9.52	.375	4.74	.187	.36 ± .05	.014 ± .002
1/2	12.70	.500	6.35	.250	.36 ± .05	.014 ± .002
3/4	19.05	.750	9.52	.375	.46 ± .08	.017 ± .003
1	25.40	1.000	12.70	.500	.51 ± .08	.020 ± .003

TABLE 3
Requirements

PROPERTY	UNIT	REQUIREMENT	TEST METHOD
PHYSICAL			
Dimensions	mm (<i>inches</i>)	In accordance with Table 1	Section 4.3.1 ASTM D 2671
Dimensional Recovery			
Longitudinal Change			Section 4.3.1
V2 - ASTM D 2671	Percent	+1, -5	ASTM D 2671
V4 – ASTM D 2671	Percent	+1, -15	ASTM D 2671
UL 224	Percent	+3, -3	UL 224
Eccentricity (Recovered)	Percent	30 maximum	ASTM D 2671
Tensile Strength	MPa (<i>psi</i>)	10.3 (1500) minimum	Section 4.3.2 ASTM D 2671
Ultimate Elongation	Percent	200 minimum	
Secant Modulus (expanded)	MPa (<i>psi</i>)	172 (2.5 x 10 ⁴) maximum	ASTM D 2671
Low Temperature Flexibility 1 hour at -30°C (-22°F)	--	No cracking	UL 224
Heat Shock 4 hours at 250°C (482°F)	--	No cracking	UL 224
Heat Aging 7 days at 158°C (316°F) Followed by tests for:	--	--	UL 224
Tensile Strength	MPa (<i>psi</i>)	70% minimum of unaged specimens	Section 4.3.2 UL 224
Ultimate Elongation	Percent	100 minimum	
Flexibility	--	No cracking	
Dielectric Withstand at 2500 V	Seconds	60 minimum	Section 4.3.5 ASTM D 2671
Dielectric Breakdown	Volts	50% minimum of unaged specimen	
Dielectric Strength	kV/mm (Volts/mil)	19.7 (500) minimum	
Copper Stability 7 days at 158°C (316°F) Followed by test for		No brittleness, glazing, cracking or severe discoloration of tubing. No pitting or blackening of copper.	Section 4.3.4 ASTM D 2671
Ultimate Elongation	Percent	100 minimum	Section 4.3.2
Restricted Shrinkage	--	Pass	UL 224
ELECTRICAL			
Dielectric Withstand at 2500 V	Seconds	60 minimum	UL 224
Dielectric Strength	kV/mm (Volts/mil)	19.7 (500) minimum	Section 4.3.5
Volume Resistivity	Ohm-cm	10 ¹⁴ minimum	ASTM D 2671

TABLE 3
Requirements
 (continued)

PROPERTY	UNIT	REQUIREMENT	TEST METHOD
CHEMICAL (continued)			
Corrosive Effect 7 days at 158° C (316°F)	--	No Corrosion	Section 4.3.6 ASTM D 2671
Flammability	--	Pass	UL 224, VW-1
Water Absorption (Recovered) 24 hrs at 23°C ± 2° C (73°F ± 3° F)	Percent	0.5 maximum	ASTM D 2671
Fungus Resistance			ISO 846 Method B
Followed by tests for:			
Tensile Strength	psi (<i>Mpa</i>)	1500 (10.3) minimum	Section 4.3.2
Ultimate Elongation	percent	200 minimum	ASTM D 2671
Dielectric Strength	Volts per mil (volts per mm)	500 (19,700) minimum	ASTM D 2671