



SPECIFICATION

108-120001

RBK-VWS-125-X

Formerly RK-6640

RBK-VWS-125-X is a clear dual wall heat shrinkable non flame retarded tubing which is designed to provide environmental sealing of an electrical splice in an automotive environment.

Continuous operating temperature -40°C to +125°C (3000hrs)

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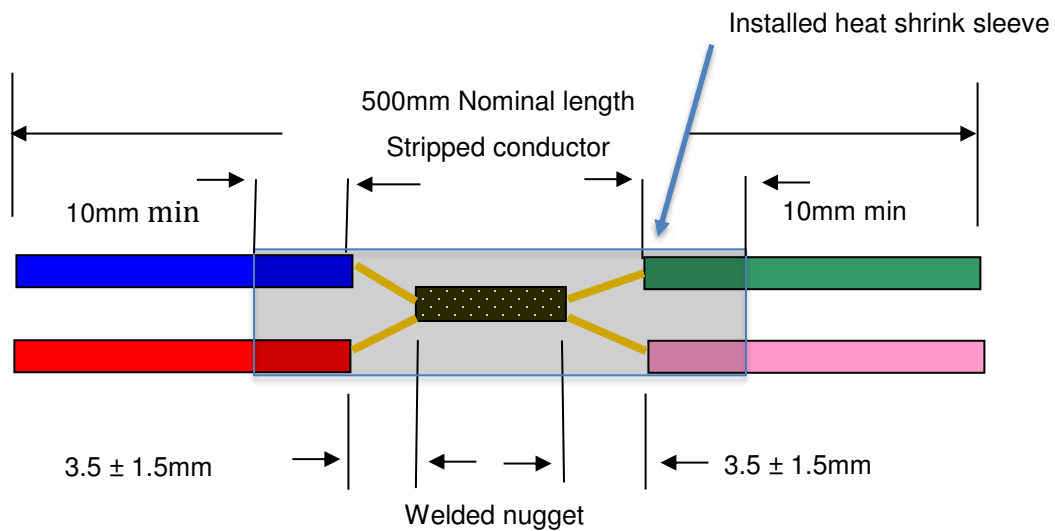


2.	<p>SCOPE</p> <p>This Quality Assurance Specification establishes the quality standard for RBK-VWS-125-X.</p> <p>The objective of this document is to specify tests that will qualify the performance of Automotive wiring in-line splices, protected and insulated by RBK-VWS-125-X tubing using sequential and individual tests that simulate real use conditions.</p> <p>For Qualification purposes standardized splice components are used to eliminate sample variation. It has been established that the wire insulation material will meet the requirements herein prior to commencement of testing.</p>																				
3.	<p>REVISION HISTORY</p> <table border="1" data-bbox="256 804 1523 1150"> <thead> <tr> <th>Revision Number</th> <th>Change Request</th> <th>Change</th> <th>Date</th> </tr> </thead> <tbody> <tr> <td></td> <td>Original Issue</td> <td>As RK-6640</td> <td>March 1994 (Paper copy only)</td> </tr> <tr> <td>1</td> <td>Via PDMLINK as TEC-108-120001</td> <td>Initial release as 108 format</td> <td>March 2017</td> </tr> <tr> <td>A</td> <td>Via PDMLINK as 108-120001</td> <td>Removal of TEC prefix + clarification on voltage withstand test</td> <td>July 2021</td> </tr> <tr> <td>A1</td> <td>Via PDMLINK as 108-120001</td> <td>Dimensions updated - jacket dia 'd'</td> <td>18 March 2024</td> </tr> </tbody> </table>	Revision Number	Change Request	Change	Date		Original Issue	As RK-6640	March 1994 (Paper copy only)	1	Via PDMLINK as TEC-108-120001	Initial release as 108 format	March 2017	A	Via PDMLINK as 108-120001	Removal of TEC prefix + clarification on voltage withstand test	July 2021	A1	Via PDMLINK as 108-120001	Dimensions updated - jacket dia 'd'	18 March 2024
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4.	<p>REQUIREMENTS</p>																				
4.1	<p>Composition, Appearance and colour</p> <p>The tubing components shall be essentially free from pinholes, bubbles, cracks, defects and inclusions and shall be constructed as a dual walled heat shrinkable tubing having a hot melt adhesive inner wall with an outer wall of an irradiated, modified polyolefin material. The standard jacket colour shall be clear. The inner adhesive shall be light amber</p>																				
4.2	<p>Dimensions</p> <p>Specimens shall be prepared and tested as outlined in section 6.1. Dimensions shall meet the requirements shown in Table 9</p>																				
4.3	<p>Test Requirements</p> <p>Unless otherwise stated the requirements of Table 7 (individual tests) will be met by either tubing installed onto splices or tubing installed onto mandrels as appropriate when prepared as recommended in Section 3. The requirements of Table 8 (sequential tests) will be met by tubing installed onto splices. Unless stated otherwise tests will be carried out on tube size NR1 and Nr3 and this will qualify the product range.</p>																				



5.	PREPARATION AND INSTALLATION OF TEST SPECIMENS
5.1	<p>Sequential, Heat Ageing and Strain Relief Specimens</p> <p>The overall length of the splice/wire/tube assembly shall be nominally 500 mm and it shall be established prior to testing that the wire insulation material will meet all the tests in the specification. Wire meeting this requirement would be ISO 6722 T3 XLPE wire. The splice assembly is constructed and installed as described in PIP-004 and shown in Fig 1, using components as described in Table 1.</p>

Figure 1



5.1.1 Splice Components				
Refer to Table 1 below for typical component combinations.				
Table 1 Splice Components and Construction				
Tube Size	Standard Tube Length (mm)	Splice Configuration	Wire Gauge mm ²	
RBK-VWS-125-NR1	50	2:2	0.5	
RBK-VWS-125-NR3	65	7:4	1.5	
NB: Splices can be manufactured by ultrasonic, resistance welding or crimping as required by the customer.				



5.1.2	Product Application Equipment
	Raychem RBK-ILS Processor UHI-250 Thermal Probe
5.1.3	Splice Installation The relevant size splice tubing shall be centered onto the splice area and shrunk into position using the RBK-ILS Processor as detailed in Product Installation Procedure PIP-004. The splices shall be allowed to cool naturally to ambient temperature for a minimum of 30 minutes prior to testing for Insulation Resistance as described in Clause 7.1 of this specification.
5.2	Physical Property (Individual) Test Specimens The installation procedures are given in the appropriate test clause. For Scrape Abrasion, Split Resistance, Thermal Indentation and Dielectric Strength, the components shall be selected according to the substrate selection guide Table 2. The mandrels shall be manufactured from a solid steel rod. Unless otherwise specified the tubing shall be installed using a TE Connectivity Thermogun Type CV 1981 PID at 350° C with a PR12 reflector (Ensuring splice is centralised) in order to achieve full recovery and flow of the adhesive. The specimens must be allowed to cool to ambient temperature prior to the start of the tests.

Table 2 Substrate Selection Guide

Product	Nominal Substrate Diameter	
	(mm)	(inches)
RBK-VWS-125-NR1	4.8	3/16
RBK-VWS-125-NR2	6.4	1/4
RBK-VWS-125-NR3	9.5	3/8
RBK-VWS-125-NR4	12.7	1/2



6.	INDIVIDUAL PHYSICAL PROPERTY TESTS
6.1	<p>Dimensions and Longitudinal Change</p> <p>The test method shall be as specified in ASTM D2671. The length and inside diameter of five 254 mm long specimens of expanded tubing shall be measured. The specimens shall be recovered at 200°C ± 5°C for 3 minutes in a fan assisted air circulating oven, and immediately quenched in water at room temperature and the dimensions re-measured. The longitudinal change shall be expressed as a percentage of the original length. The recovered jacket wall thickness shall be determined from four measurements equi-spaced around the circumference and the mean value shall be recorded. Blocking of the adhesive liner shall not constitute a failure.</p> <p>Note: The adhesive used in RBK-VWS-125 is designed to melt and flow around wire splices to create an environmental seal when installed in accordance with PIP-004. Consequently, the inner recovered bore and adhesive wall thickness cannot be reliably or consistently measured after full shrinkage. These dimensions are adequately controlled during the manufacturing process.</p>
	PREPARATION AND INSTALLATION OF TEST SPECIMENS
6.2	<p>Inner Wall Flow Test</p> <p>This test is carried out on standard length cut pieces of RBK-VWS-125-X tubing material and is intended as a guide to adhesive flow.</p> <p>Five specimens shall be selected at random and conditioned at 200 ± 5°C for 3 minutes in a fan assisted air circulating oven after which time approximately 5mm of one end is crimped together using flat faced pliers for approximately 30 seconds.</p> <p>The specimens are then allowed to cool for a minimum of 15 minutes then reconditioned at 200 ± 5°C for a further 3 minutes. Upon removal from the oven the specimens shall be allowed to cool for 15 minutes minimum and examined for adhesive blocking. The tests shall be considered satisfactory if all specimens are totally blocked in at least one area of the specimen length.</p>



<p>6.3</p>	<p>Split Resistance</p> <p>Five standard length cut pieces of RBK-VWS-125-X tubing material shall be selected at random and slid onto the appropriate mandrels as stated in Table 2.</p> <p>The specimens shall then be conditioned in a fan assisted air circulating oven at $200 \pm 5^{\circ}\text{C}$ for 10 minutes \pm 30 seconds ensuring the specimens do not come into contact with internal parts of the oven. Upon removal from the oven the specimens shall be examined visually for evidence of splitting. There shall be no splitting.</p>
<p>6.4</p>	<p>Strain Relief</p> <p>This test is carried out on splice assemblies constructed as described in Clause 3.1. Five specimens shall be tested.</p> <p>Secure one wire from any end in the upper jaw of a suitable tensile testing machine and any other wire from the same end in the lower jaw. The initial jaw separation shall be 100mm and rate of separation shall be 100mm per minute. The test shall be carried out at an ambient temperature of $23 \pm 3^{\circ}\text{C}$. Each test specimen shall be loaded to 50N and the load immediately released. (Refer to Figure 2) All specimens shall then be checked for Insulation Resistance according to Clause 7.1 of this Specification.</p> <p>N.B For the 7:4 splice choose 2 wires randomly from the 7 wire side for the test as per Figure 2.</p> <div data-bbox="324 1197 1425 1591" style="border: 1px solid black; padding: 10px;"><p>Figure 2 Strain Relief</p></div>



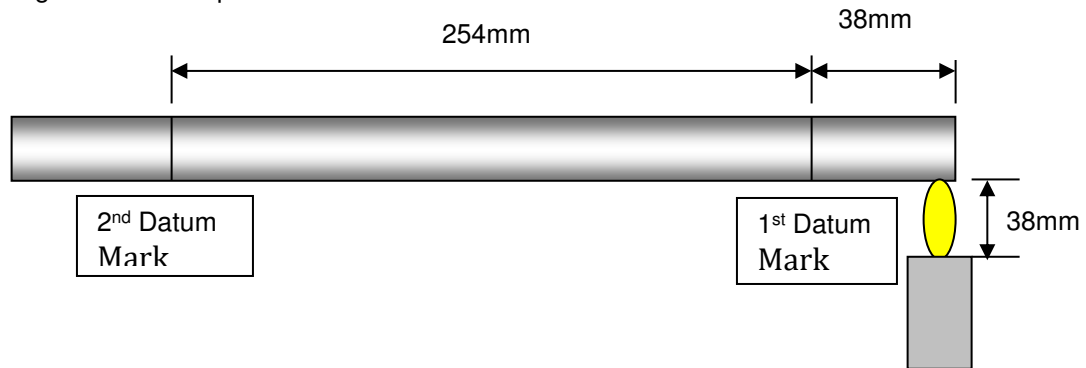
6.5

Flammability

Figure 3

The test method shall be essentially in accordance with FMVSS302.

The test shall be carried out on a length of RBK-VWS-125-X that has been fully recovered at 200°C ± 5°C for 3 minutes in a fan assisted air circulating oven and allowed to cool naturally to room temperature. The length of the test specimen shall be 330mm.*



Apply the flame at the end of the specimen for 15 seconds and remove. When the flame reaches the 1st Datum Mark start the timer. Record the time in seconds for the flame to reach the 2nd Datum Mark.

*Tubing not installed on a mandrel for this test

Calculate the Horizontal Burn Rate as follows:

$$V = 254 \times 60/t$$

Where V= Horizontal Burning Rate

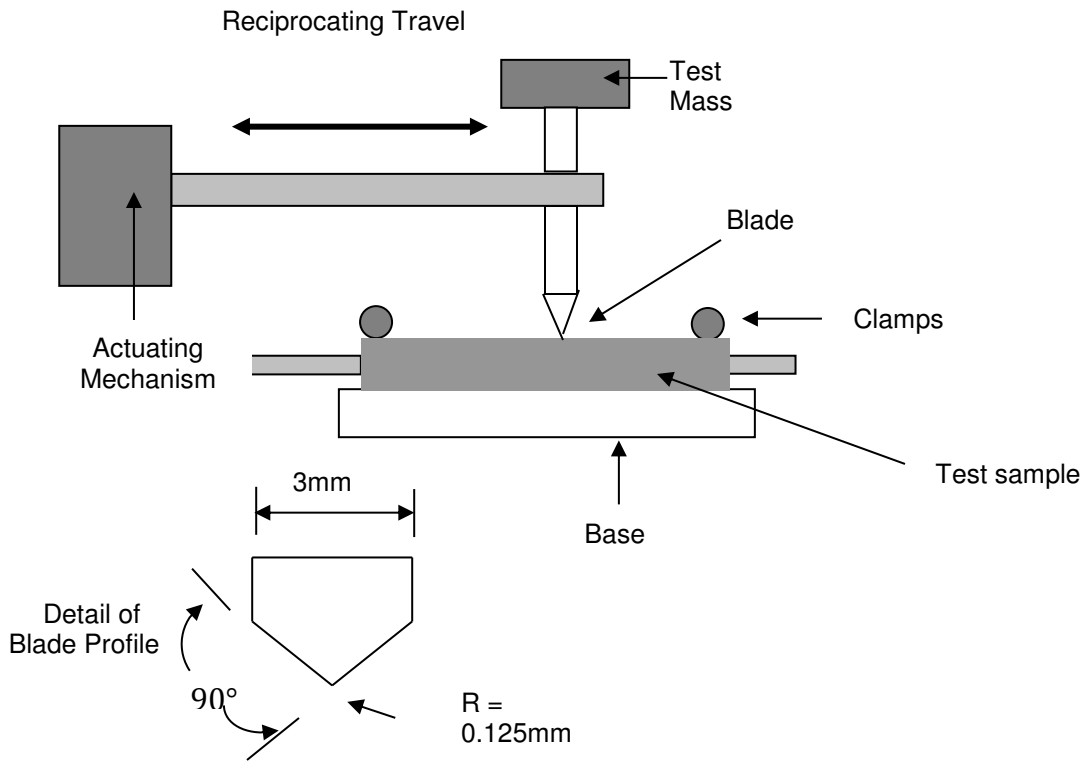
t = Duration of the combustion, in seconds, to burn 254mm



INDIVIDUAL PHYSICAL PROPERTY TESTS (continued)	
6.6	<p>Scrape Abrasion</p> <p>The test method is essentially in accordance with that defined in ISO 6722 where a 0.125mm radius needle or profile is drawn back and forth over the splice material. The tests shall be carried out at an ambient temperature of $23 \pm 3^{\circ}\text{C}$ on five specimens of each size of tubing. The result shall be recorded as the average of the 5 determinations.</p> <p>A length of splice tubing approximately 150mm long shall be installed onto the appropriate mandrel as specified in Table 2 by conditioning in a fan assisted air circulating oven at $200^{\circ}\text{C} \pm 5^{\circ}\text{C}$ for 3 minutes. The samples shall then be allowed to cool naturally to room temperature. Each specimen shall be subjected to the test conditions shown below in Table 3 and shall meet or exceed the cycle requirements given in Table 7. A cycle is defined as one complete forward and backward reciprocation of the test probe and does not lift off at the end of each stroke. Refer to Figure 4.</p>
Table 3 Scrape Abrasion Test Conditions	
Test Temp	$23 \pm 3^{\circ}\text{C}$
Test Mass	700g
Probe Radius	0.125mm
Cycle Rate	50-60 per minute
Cycle Length	10mm minimum



Figure 4 – SCRAPE ABRASION TEST RIG





	INDIVIDUAL PHYSICAL PROPERTY TESTS (Cont'd)
6.7	<p>Heat Ageing (Long Term 3000hrs)</p> <p>Twenty five specimens shall be prepared as described in Clause 5.1.</p> <p>The specimens shall be suspended vertically in a fan assisted air circulating oven and conditioned at $125 \pm 3^{\circ}\text{C}$ for 3000 hours. After conditioning, the specimens shall be allowed to cool naturally to room temperature and visually examined for signs of outer jacket cracking. Visual discolouration of the RBK-VWS-125-X jacket material or adhesive does not constitute failure.</p> <p>All specimens shall be subjected to the Insulation Resistance test per Clause 7.1.</p>
6.8	<p>Tensile Strength</p> <p>5 specimens shall be tested in accordance with ISO 37. The Tensile Strength shall be calculated based on the wall thickness of the jacket material only. The result shall be expressed as the average value of the 5 determinations.</p> <p>Initial jaw separation shall be 50 mm and rate of jaw separation shall be 50 ± 5 mm/min. The test shall be carried out at a temperature of $23 \pm 2^{\circ}\text{C}$</p>
6.9	<p>Ultimate Elongation</p> <p>5 specimens shall be tested in accordance with ISO37. The result shall be expressed as the average value of the 5 determinations.</p>
6.10	<p>2% Secant Modulus</p> <p>5 specimens shall be tested in accordance with ASTM D882. The test shall be carried out using specimens of expanded tubing. The 2% Secant Modulus shall be calculated based on the wall thickness of the jacket material only. The result shall be expressed as the average value of the 5 determinations.</p> <p>The test shall be carried out at a temperature of $23 \pm 2^{\circ}\text{C}$</p>
6.11	<p>Volume Resistivity</p> <p>5 specimens shall be tested in accordance with ASTM D2671. The result shall be expressed as the average value of the 5 determinations.</p>



6.12

Thermal Indentation

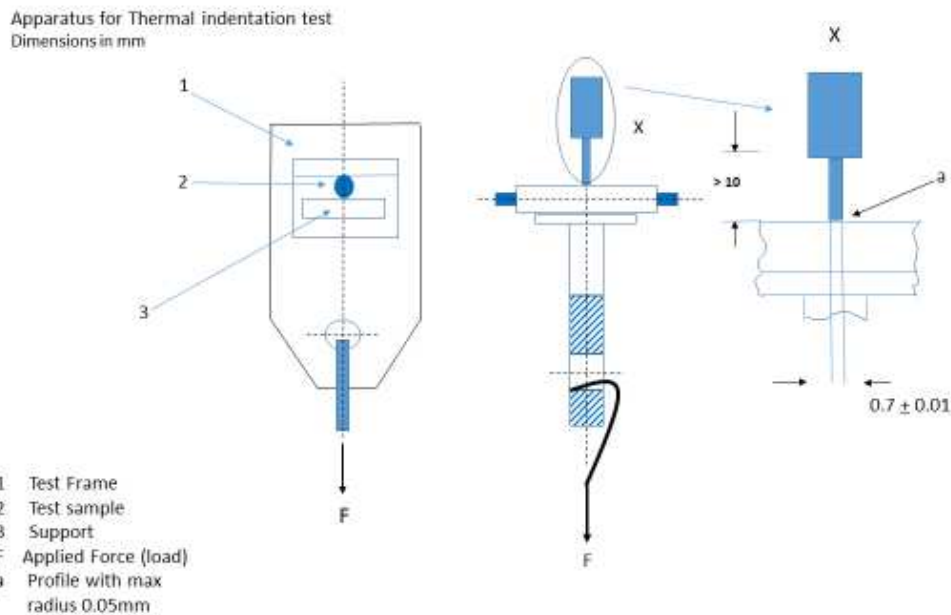
The test set up is shown below in Figure 5

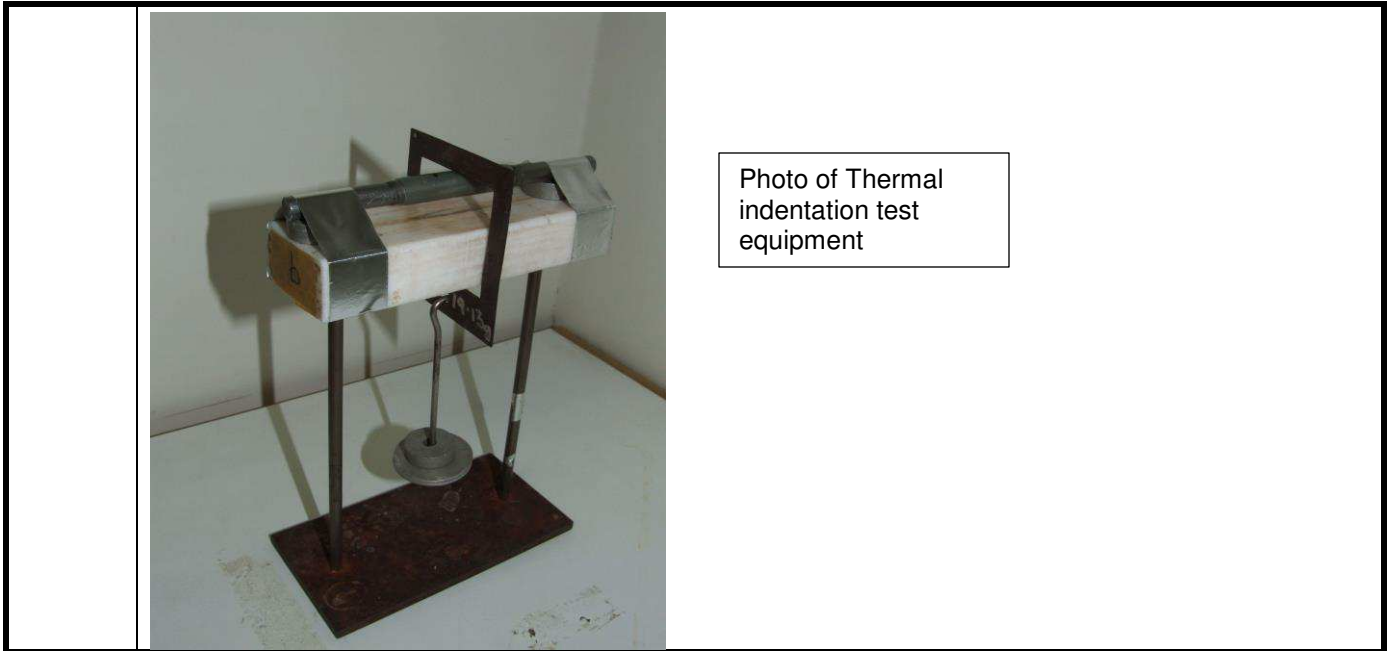
5 standard length pieces of tubing shall be shrunk onto mandrels (Section 5.2 table 2) in a fan assisted air circulating oven at $200^{\circ}\text{C} \pm 5^{\circ}\text{C}$ for 3 minutes and allowed to cool naturally to room temperature. Position the specimen on the fixture and condition the assembly in an air circulating oven at the conditions shown below.

- Total Load = 150g (including test frame)
- Profile width = 0.7mm
- Temperature = 90°C
- Time = 1 hour

After the exposure time carefully remove from the oven and quench the indented region in water at room temperature. The residual wall thickness shall be measured. The average value of the 5 determinations shall be 40% minimum of the original average wall thickness. The apparatus shall be essentially as shown in Figure 5.

Figure 5





6.13	Copper Mirror Corrosion The test shall be carried out in accordance with ASTM D2671. There shall be no corrosion of the copper mirror. Test temperature = 150°C Duration of test = 16 hours
6.14	Dielectric Strength The test shall be carried out essentially in conformance with IEC 243. A 200mm length of tubing shall be shrunk onto mandrels as shown in Table 2 Substrate Selection Guide. The average value of 5 measurements shall be taken.
6.15	Specific Gravity The test method shall be as specified in Method A of ISO 1183.
6.16	Water Absorption The test method shall be specified in Method 1 of ISO 62. For sleeving of recovered bore greater than 8mm, 3 disc specimens of diameter 25 ± 1 mm shall be cut from sleeving. For sleeving of recovered bore less than or equal to 8mm, 3 tubular specimens 50mm long shall be cut from the sleeving.

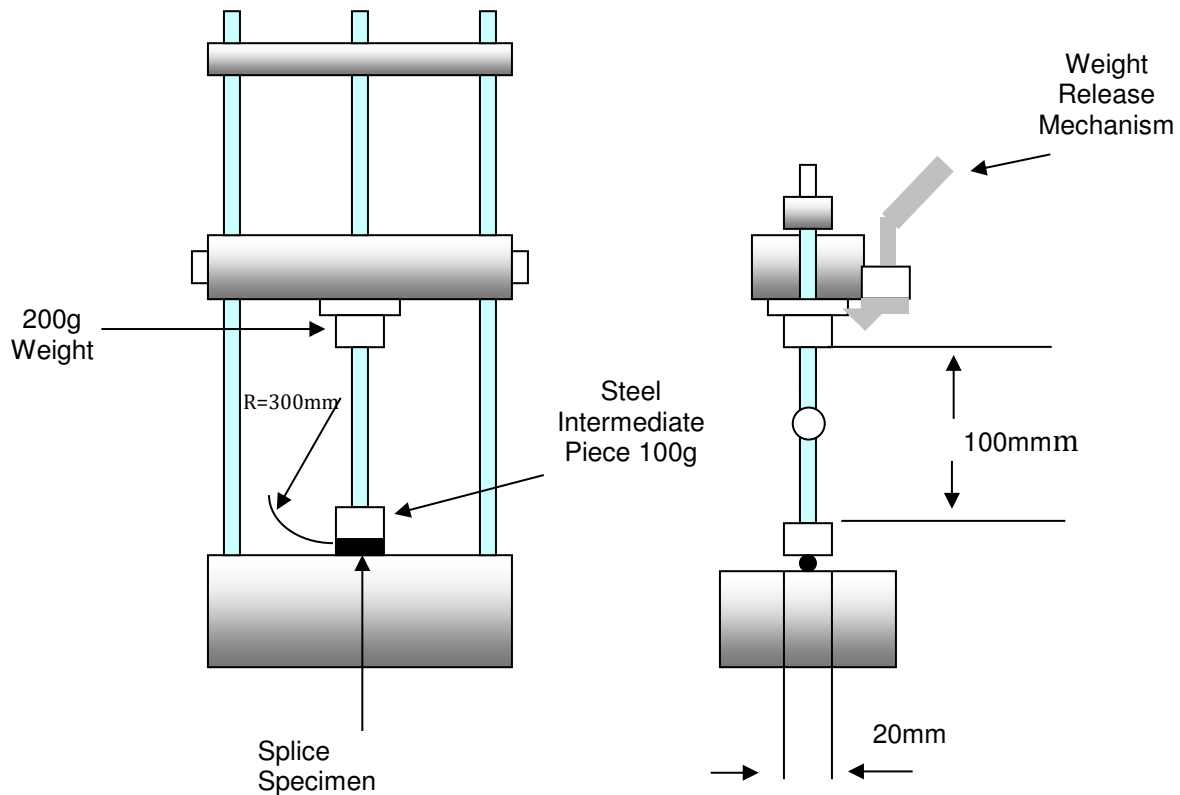


<p>7</p>	<p>SEQUENTIAL TEST PROGRAMME</p> <p>50 Test specimens shall be prepared as described in Clause 7.1 and subjected to the following sequence of tests shown in Clause 7.1 to 7.9.</p>
<p>7.1</p>	<p>Insulation Resistance Test</p> <p>The apparatus shall be essentially as shown in Figure 6 below.</p> <p>The 50 specimens shall be immersed in salt solution (5% by weight) at $23 \pm 3^{\circ}\text{C}$ for 24 ± 2 hours.</p> <p>After this conditioning period the resistance between each specimen and an immersed electrode (of surface area 100mm square) shall be measured by means of a suitable Megohmmeter. The reading shall be taken 30 seconds after application of 100V dc. Resistance of less than 2×10^8 Ohms shall constitute a failure.</p> <p>Subsequent Insulation Resistant tests both in the sequential cycle and individual test sections shall be carried out after 1hour immersion only. These 50 specimens shall then be subjected to test clause 7.2</p>
<p>Figure 6. Insulation Resistance Test</p>	



SEQUENTIAL TEST PROGRAMME (Cont'd)	
7.2	<p>Cold Impact (Sequential)</p> <p>The test apparatus shall be essentially as shown in Figure 7 and the test method is based on ISO 6722.</p> <p>50 splice specimens shall be conditioned together with the test apparatus in a suitable cold chamber for a minimum of 4 hours at $-40 \pm 2^{\circ}\text{C}$. The apparatus shall be pre-conditioned for a minimum of 4 hours prior to the start of the test.</p> <p>Each specimen shall be subjected to a single drop of a 200g weight from a height of 100mm whilst still in the cold chamber ensuring that the weight centrally impacts the splice area.</p> <p>After the test the specimens shall be removed from the cold chamber, allowed to stabilize to room temperature and examined visually for signs of cracking of the outer jacket. Each specimen shall then be subjected to the insulation resistance test as per Clause 7.1.</p> <p>The 50 specimens shall then be subjected to test clause 7.3 Accelerated ageing test.</p>

Figure 7 Cold Impact Test Rig

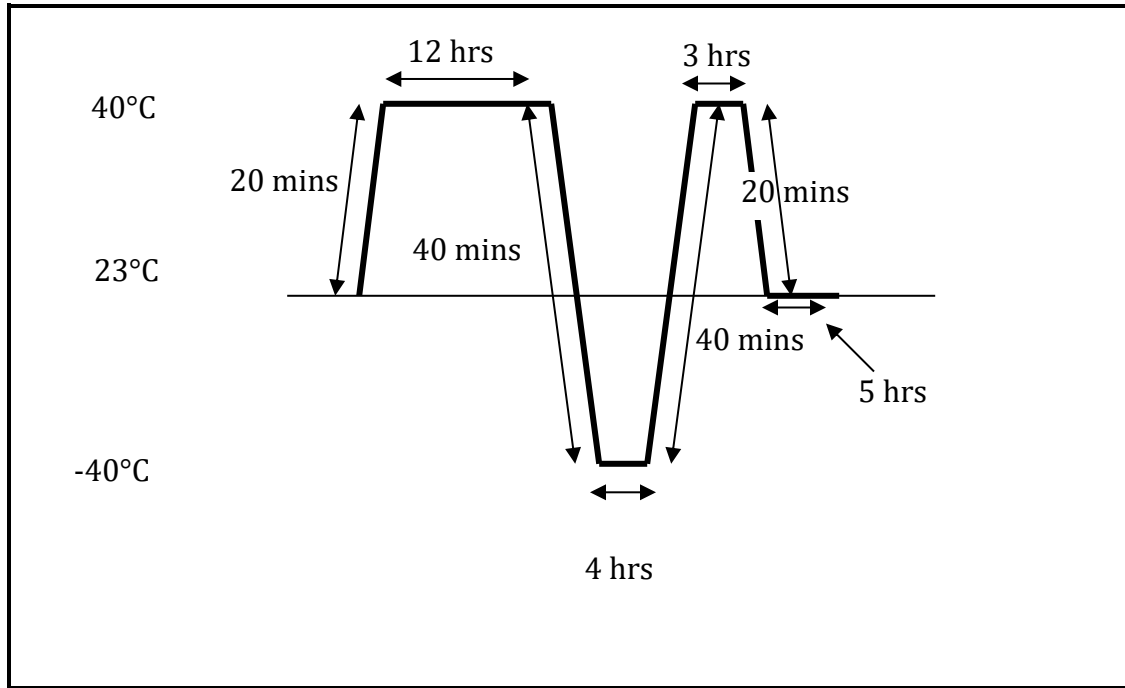




SEQUENTIAL TEST PROGRAMME (Cont'd)		
7.3	Accelerated Ageing Test (Sequential)	
	<p>50 splice specimens of each size shall be suspended vertically in a fan assisted air circulating oven and conditioned for 168 ± 2 hours at $130 \pm 5^\circ\text{C}$. After the conditioning period the specimens shall be removed from the oven and allowed to cool naturally to room temperature and visually examined for signs of cracking of the outer jacket. Discolouration of the RBK-VWS-125-X jacket material or adhesive liner does not constitute a failure. Each specimen shall then be subjected to the Insulation Resistance test per Clause 7.1. These 50 specimens shall then be subjected to test clause 7.4 Thermal Shock.</p>	
7.4	Thermal Shock (Sequential)	
	<p>50 splice specimens of each size shall be suspended vertically in a fan assisted air circulating oven and conditioned for $1 \text{ hour} \pm 5 \text{ minutes}$ at $130 \pm 5^\circ\text{C}$. Immediately after this conditioning period the sealed splice area of the specimens shall be immersed in a saline solution (5% by weight) at a temperature of 0 to 5°C and conditioned for 30 ± 2 minutes.</p> <p>This cycle shall be repeated for a total of five cycles and the samples should be visually examined for signs of cracking of the outer jacket. Each specimen shall then be subjected to the Insulation Resistance test per Clause 7.1. These 50 specimens shall then be subjected to test clause 7.5 Temperature/Humidity Cycling.</p>	
7.5	Temperature/Humidity Cycling (Sequential)	
	<p>50 splice specimens shall be hung vertically and subjected to the following test regime shown in Table 4 for a total of five cycles. Figure 8 shows typical ramp up and down times together with the dwell periods. After completion of the test cycle each specimen shall be tested for Insulation Resistance per Clause 7.1. These 50 specimens shall then be subjected to test clause 7.6 Mechanical Vibration.</p> <p><i>Note 1: Humidity should be checked periodically to ensure it is running at the correct level</i></p>	
	Table 4 Temperature/Humidity Cycling	
	12 hours	at
		95% RH at $40^\circ\text{C} \pm 3^\circ\text{C}$
	4 hours	at
		$-40^\circ\text{C} \pm 3^\circ\text{C}$
	3 hours	at
		95% RH at $40^\circ\text{C} \pm 3^\circ\text{C}$
	5 hours	at
		$23^\circ\text{C} \pm 3^\circ\text{C}$



Figure 8





7.6

SEQUENTIAL TEST PROGRAMME (Cont'd)

Mechanical Vibration (Sequential)

The test method shall essentially be in accordance with IEC 60068-2-6.

50 splice specimens shall be subjected to the following vibration regime shown in Table 5. Each specimen shall be clamped horizontally as shown in Figure 9. The wires should be clamped so that they are not under tension ensuring that the vibration is transferred to the splice area of the test piece. At the completion of the test, each specimen shall be subjected to the Insulation Resistance Test per Clause 7.1. These 50 specimens shall then be subjected to test clause 7.7 Flex Test.

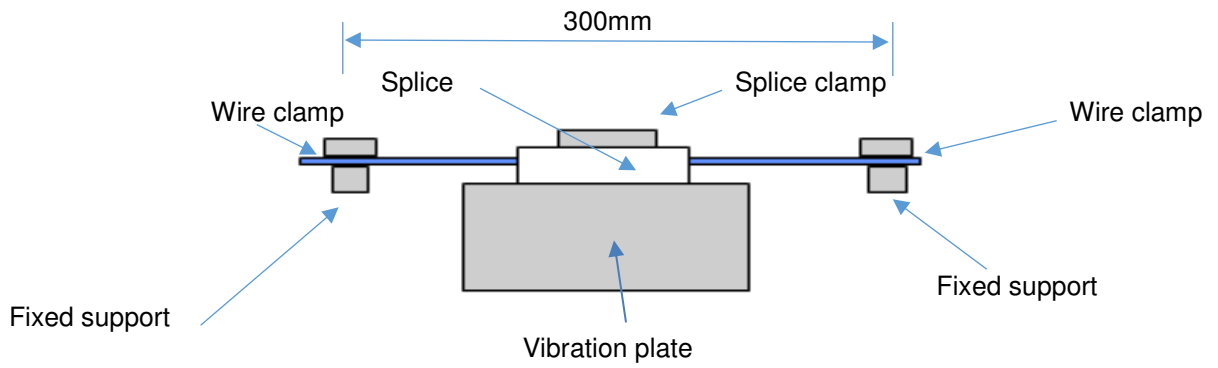
Table 5 Vibration Regime		
Frequency range	Acceleration level m/s²	Acceleration Rate ^{Note 1} Octave /min
10-25Hz	9.8 (1G)	1
25-500Hz	44 (4.5G)	1
Test Duration		8 hrs ± 15 minutes
Vibration axis		X axis only

Note 1:

1 octave /minute acceleration rate is the doubling of the frequency each minute, e.g if starting at 25Hz the frequency will be 50Hz after 1 minute, 100Hz after 2 minutes, 200Hz after 3 minutes etc.



Figure 9
Vibration Jig Layout





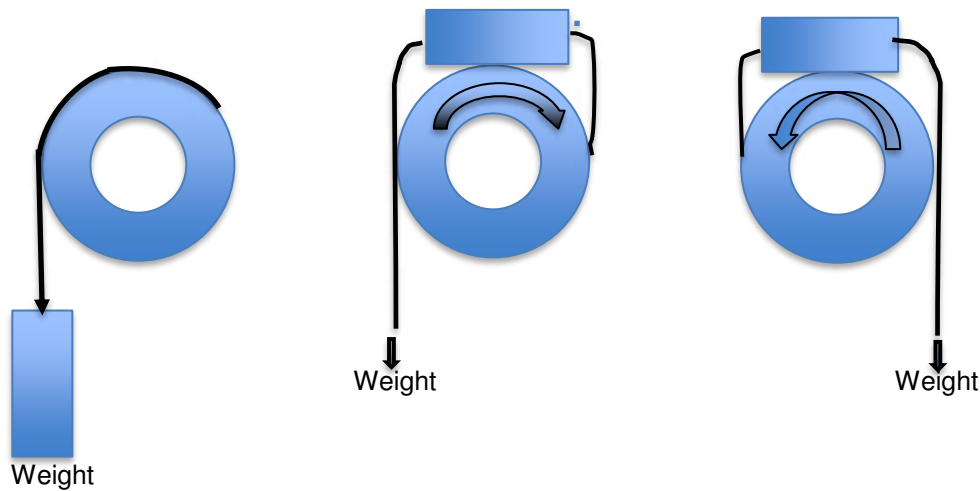
7.7 Flex Test (Sequential)

50 splice specimens shall be flexed at Room temperature around a 50.8mm (2") diameter mandrel as follows. Attach one end of the specimen to the mandrel and the other end to a weight (see below). Rotate the mandrel sufficiently to cause the splice area to wrap around the mandrel and the wires on the opposite side of the splice to contact the mandrel. Rotate the mandrel in the opposite direction until the splice is again wrapped around the mandrel. This shall constitute one cycle. Test each sample for 5 cycles. Refer to Figure 10. At the completion of the test, each specimen shall be subjected to the Insulation Resistance Test per Clause 7.1. These 50 specimens shall then be subjected to test clause 7.8 Voltage Withstand.

Weight for RBK-VWS-125-NR1 = 1 kg

Weight for RBK-VWS-125-NR3 = 3 kg

Figure 10
FLEX TEST



7.8 Voltage Withstand Test (Sequential)

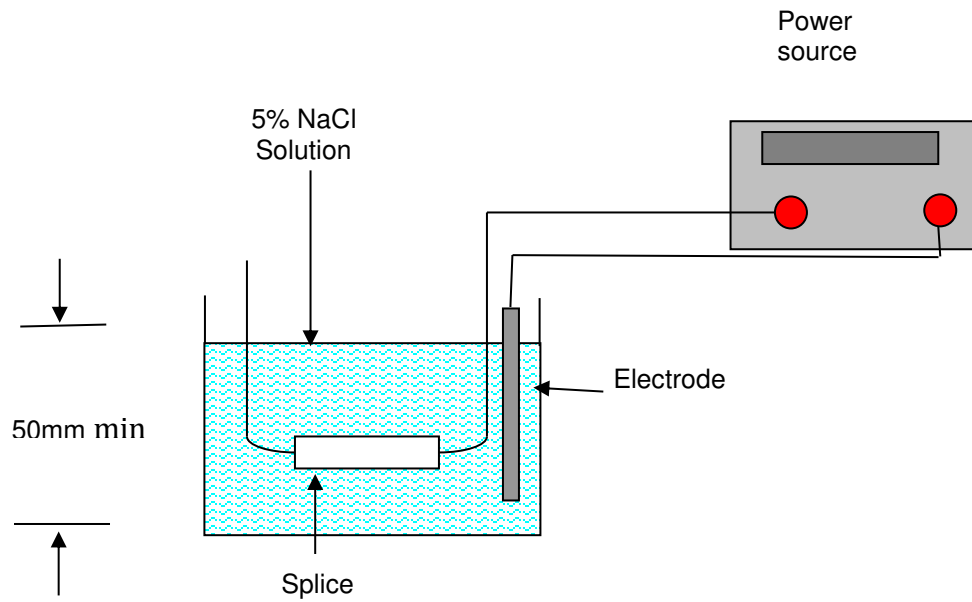
The test method and apparatus shall be essentially as described in IEC 60243 (refer to Figure 11)

50 splice specimens shall be subjected to the following test.

Each specimen shall be immersed in a 5% (by weight) salt solution at $23 \pm 3^\circ\text{C}$ for 4 hours \pm 5 minutes with the wire ends overhanging the solution bath. The test voltage shall be applied between each conductor and the salt solution at a rate of 500 volts per second until a voltage of 1kV AC is reached. The voltage shall be maintained for 1 minute. There shall be no flashover of the splice sleeve. These 50 specimens shall then be subjected to test 7.9 Fluid compatibility.



Figure 11



7.9 Fluid Compatilby (Sequential)

50 splice specimens shall be divided into groups of 5 and subjected to the Fluid Test in clause 7.9.1

7.9.1 Fluid Soak

5 Splice specimens shall be immersed in each of the fluids as specified in Table 6

A new group of 5 specimens shall be used for each fluid.

After the conditioning period the specimens shall be removed from the fluids, allowed to cool naturally to room temperature, wiped dry and subjected to the insulation resistance test detailed in clause 7.1.

**Table 6****Soak Test Fluids**

	Fluid Description	Fluid Specification	Immersion Time (mins)	Immersion Temp (°C)
a)	Engine Oil	ISO 1817 Oil No. 1 (IRM 901)	30 ± 2	100 ± 3
b)	Automatic Transmission Fluid (ATF)	Dexron VI™	30 ± 2	100 ± 3
c)	Diesel Fuel	90% ISO 1817, Oil Number 3 10% p-xylene	30 ± 2	23 ± 2
d)	Brake Fluid	DOT 4	30 ± 2	23 ± 2
e)	Engine Cleaner	Gunk™ Degreaser	30 ± 2	23 ± 2
f)	Petrol (without oxygen compounds)	ISO 1817 Liquid C*1	30 ± 2	23 ± 2
g)	Screen Wash	50% Iso-propanol / 50% Distilled H ₂ O by volume	30 ± 2	23 ± 2
h)	Multi-Purpose Detergent (Carwash)	1% Teepol / 99% Distilled H ₂ O by volume	30 ± 2	23 ± 2
i)	Battery Acid	H ₂ SO ₄ + H ₂ O (SG 1.25)	30 ± 2	23 ± 2
j)	Engine Coolant	50% Ethylene Glycol / 50% Distilled H ₂ O by volume	30 ± 2	23 ± 2
*1 Use fresh fluid for Fuel C for each batch test. Seal in airtight containers when not in use to avoid evaporation				



8.	Related Documents	
	ASTM D2671-00	Standard Test Methods for Heat-Shrinkable Tubing for Electrical Use
	ASTM D882-09	Standard Test Methods for Tensile Properties of Thin Plastic Sheeting
	Dot 4	Hydraulic Brake Fluid
	IEC 60068-2-6: 2007	Environmental Testing - Test Fc And Guidance: Vibration (Sinusoidal)
	IEC 60243-1: 2013	Electrical Strength Of Insulating Materials - Test Methods - Tests At Power Frequencies
	ISO 37: 2011	Rubber, vulcanized or thermoplastic - Determination of Tensile Stress-Strain Properties
	ISO 1817: 2015 - Oil No 1 - Oil No.3 - Fuel C	Rubber, vulcanized - Determination of the effect of liquids (Engine Oil) (Diesel Fuel) (Gasoline)
	ISO 6722: 2011	Road Vehicles - 60 V And 600 V Single-Core Cables - Dimensions, Test Methods And Requirements
	FMVSS 302 : 1991	Flammability of Interior Materials
	PIP-004	Size Selection & Installation of RBK-VWS-125



<p>9</p>	<p>SAMPLING</p> <p>9.1 Qualification</p> <p>Qualification tests are those performed on tubing submitted for qualification as a satisfactory product and when a change of formulation takes place, and shall consist of all tests listed in this Specification. Tube sizes NR1 and NR3 shall qualify the product range. Qualification test samples shall be cut to the specified lengths and installed onto either splices or the appropriate mandrels. Product is tested on wire configurations or mandrels as specified in Section 5 of this Specification “Preparation and Installation of Test Specimens”. The minimum number of specimens to be tested shall be as follows:</p> <p>For Sequential Tests: 50 specimens</p> <p>For Individual Tests: 5 specimens unless otherwise stated</p> <p>Refer to the Qualification Flow Chart for more details Figure 12</p>
<p>9.2</p>	<p>Production Routine</p> <p>Production Routine tests must be carried out on every batch of finished tubing and shall consist of the following:</p> <p>Visual Appearance, Dimensions, Longitudinal Change, Inner Wall Flow and Split Resistance.</p> <p>A minimum of 5 tests shall be carried out on sample lengths taken at random from each batch of finished tubing. A batch of tubing is defined at that quantity of tubing of the same size from the same production run and offered for inspection at the same time.</p>
<p>10</p>	<p>PACKAGING</p> <p>Packaging shall be in accordance with good commercial practice. Each package shall bear an identification label showing material quantity, description, size, batch number and maximum storage temperature. Additional information shall be supplied as specified in the contract or order.</p>



Qualification Flow Chart Figure 12

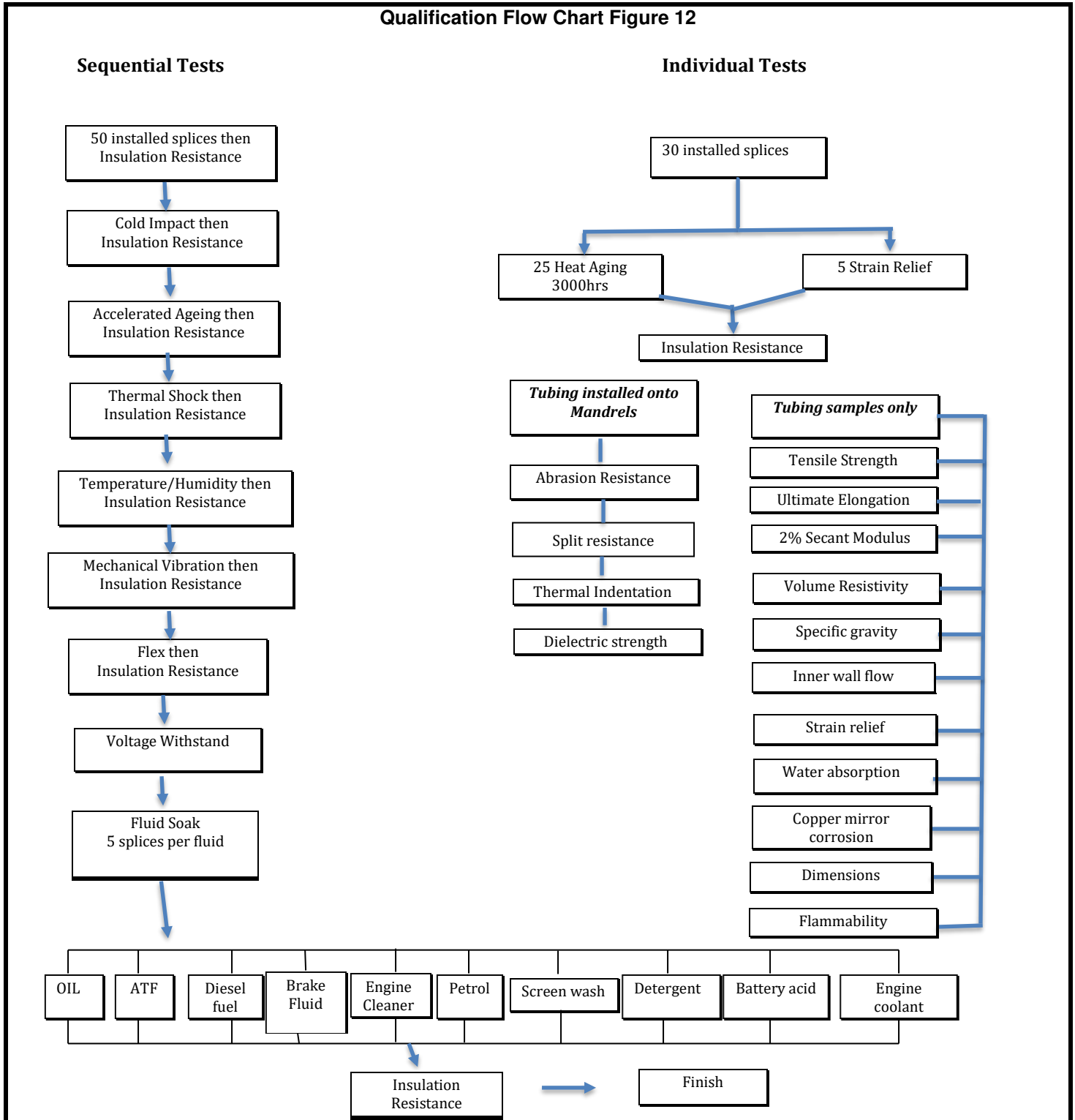




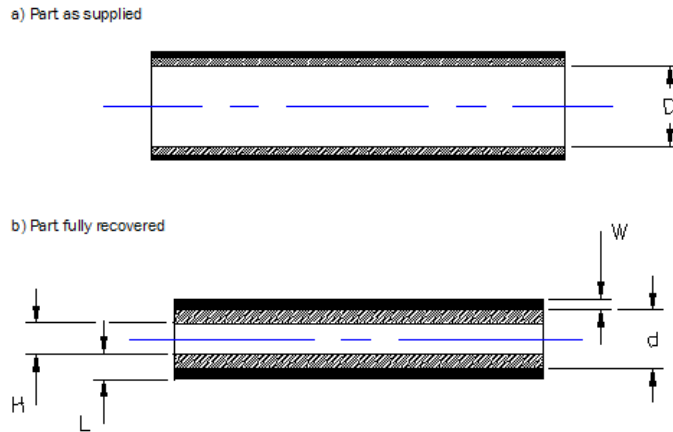
TABLE 7 Test Requirements - INDIVIDUAL TESTS			
	Test	Test Method	Test Requirements
	Dimensions	Clause 6.1 ASTM D2671	As per Table 9
	Longitudinal Change	Clause 6.1 ASTM D2671	0 - 10%
	Inner Wall Flow	Clause 6.2	Total blocking (in at least one area of the splice length)
	Split Resistance	Clause 6.3	No splitting at 200°C
	Strain Relief - Insulation Resistance	Clause 6.4 Clause 7.1	50N minimum 2 x 10 ⁸ Ohms minimum
	Flammability	Clause 6.5 FMVSS302	100mm/min max
	Scrape Abrasion	Clause 6.6 ISO 6722	NR 1 500 cycles min NR 3 5,000 cycles min
	Heat Ageing Long Term (3000 hrs) - Visual - Insulation Resistance	Clause 6.7 Clause 7.1	No cracking of tubing jacket after 3000 hours at 125°C 2 x 10 ⁸ Ohms minimum
	Tensile Strength	Clause 6.8 ISO 37	10MPa minimum
	Ultimate Elongation	Clause 6.9 ISO 37	250% minimum
	2% Secant Modulus	Clause 6.10 ASTM D882	75 MPa minimum
	Volume Resistivity	Clause 6.11 ASTM D2671	1.0 x 10 ¹² ohm-cm minimum
	Thermal Indentation	Clause 6.12 ISO 6722	Minimum of 40% residual wall thickness
	Copper Mirror Corrosion	Clause 6.13 ASTM D2671	No Corrosion of the copper mirror
	Dielectric Strength	Clause 6.14 IEC 243	16 MV/m min
	Specific Gravity	Clause 6.15 ISO 1183	1.20 max
	Water Absorption	Clause 6.16 ISO 62	0.5% max



TABLE 8 Test Requirements – SEQUENTIAL TESTS			
	Test	Test Method	Test Requirements
	Insulation Resistance Test	Clause 7.1	2 x 10 ⁸ Ohms minimum after 24 hours immersion
	Cold Impact - Visual - Insulation Resistance	Clause 7.2 ISO 6722 Clause 7.1	No cracking of tubing jacket at -40°C. 2 x 10 ⁸ Ohms minimum after 1 hour immersion
	Accelerated Heat Ageing - Visual - Insulation Resistance	Clause 7.3 Clause 7.1	No cracking of tubing jacket after 168 hours at 130°C 2 x 10 ⁸ Ohms minimum after 1 hour immersion
	Thermal Shock - Visual - Insulation Resistance	Clause 7.4 Clause 7.1	No cracking of tubing jacket after 1 hour at 130°C/30 min immersion at 0 to 5°C (5 cycles) 2 x 10 ⁸ Ohms minimum after 1 hour immersion
	Temperature Humidity Cycling - Insulation Resistance	Clause 7.5 Clause 7.1	2 x 10 ⁸ Ohms minimum after 1 hour immersion
	Mechanical Vibration - Insulation Resistance	IEC 60068-2-6 Clause 7.6 Clause 7.1	2 x 10 ⁸ Ohms minimum after 1 hour immersion
	Flex Test (Ambient) - Insulation Resistance	Clause 7.7 Clause 7.1	2 x 10 ⁸ Ohms minimum after 1 hour immersion
	Voltage Withstand	Clause 7.8	No breakdown at 1kV after 30 minutes
	Fluid Soak - Insulation Resistance	Clause 7.9 Clause 7.1	30 minutes immersion 2 x 10 ⁸ Ohms minimum after 1 hour immersion



Table 9 Dimensional Requirements



OUTER JACKET:- Irradiated Modified Polyolefin
INNER LINER:- Thermoplastic Hot-Melt polyamide adhesive

COLOUR Clear
COLOUR Amber

Part no	D DIA min Expanded (mm)	Jacket & liner H DIA ¹ (mm)	Jacket d DIA max (mm)	Jacket W(wall) Min (mm)	Jacket & Liner L Min ¹ (mm)
RBK-VWS-125-NR1	5.70	1.27	2.82	0.80	1.42
RBK-VWS-125-NR2	8.00	1.65	3.18	1.06	1.78
RBK-VWS-125-NR3	10.80	2.40	5.15	1.16	2.14
<i>RBK-VWS-125-NR4²</i>	<i>17.78</i>	<i>4.45</i>	<i>7.77³</i>	<i>1.04</i>	<i>2.41</i>

Notes:-

- 1 Dimension H & L (jacket & Liner) value is for reference only
- 2 This sizes is tested and released to TE Connectivity specification RT-1113
- 3 Estimate only