



# TAT-125 Heat Shrink Tubing Specification

# TEC-108-120011

# Raychem TAT-125 Adhesive Lined Tubing Polyolefin, Flexible, Heat-Shrinkable, Dual Wall

TAT-125 is an adhesive-lined, flexible, thin-wall, heat-shrinkable tubing. It provides onestep electrical insulation and moisture sealing for a wide variety of applications. TAT-125 is especially suitable for applications where the moisture seal must withstand flexing or other physical abuse. Because both tubing and adhesive are flexible, the moisture seal is resistant to bending of the substrate.

The thin adhesive lining of TAT-125 melts and flows with the heat of application to form a positive environmental seal. The adhesive will adhere to a wide variety of plastics, rubbers, and metals, including PVC, polyethylene, neoprene, lead, and steel. RoHS and REACH compliant.

Continuous operating temperature -55 to 110°C (-67 to 230°F).

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# 1. SCOPE

This specification covers the requirements for one type of flexible, electrical insulating, extruded tubing diameter that will reduce to a predetermined size upon the application of heat in excess of  $121^{\circ}C$  (250°F).

#### 1.1. FORM

Type 1: The tubing shall be flame retarded and shall be black with a thermoplastic hot melt adhesive lining, unless otherwise specified.

Type 2: The tubing shall have a clear non-flame retarded jacket with a thermoplastic hot melt adhesive lining.

# 2. APPLICABLE DOCUMENTS

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

#### 2.1. AMERICAN SOCIETY FOR TESTING AND MATERIAL (ASTM)

ASTM G21	Standard Practice for Determining Resistance of Synthetic Polymeric
	Materials to Fungi
	Standard Tast Mathad for Prittlances Tomporature of Plastics and

- ASTM D746 Standard Test Method for Brittleness Temperature of Plastics and Elastomers by Impact
- ASTM D882 Standard Test Method for Tensile Properties of Thin Plastic Sheeting
- ASTM D910 Standard Specification for Leaded Aviation Gasolines
- ASTM D2671 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 or via the ASTM website at <a href="http://www.astm.org">http://www.astm.org</a>).

#### 2.2. INTERNATIONAL ORGANIZATION FOR STANDARDIZATION (ISO)

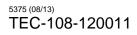
ISO 846 Plastics-Evaluation of the action of microorganisms

(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 <a href="http://www.iso.ch/iso/en/ISOOnline.frontpage">http://www.iso.ch/iso/en/ISOOnline.frontpage</a>)

#### 2.3. MILITARY DOCUMENTS

MIL-T-83133	JP-8 turbine fuel (NATO type F-34)
MIL-PRF-5606	Hydraulic Fluid, Petroleum Base, Aircraft, Missile and
	Ordnance
MIL-STD-104	Limits for Electrical Insulation Color

(Copies of Military documents are available online at http://quicksearch.dla.mil.)



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#### 2.4. OTHER DOCUMENTS

TAT-125 SCD RAYCHEM TAT-125 Adhesive Lined Tubing SCD

## 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. It shall have an interior coating of thermoplastic adhesive.

#### 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 jacket only) Heat Shock

Statistical process control data may be used to demonstrate conformance for dimensions. Acceptance tests shall consist of:

#### **4.2. SAMPLING INSTRUCTIONS**

4.2.1. Qualification Test Samples

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

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Range of Sizes 1/8" through 1/4"

3/8" through 1" 1-1/2" through 4"

For the following property tests: Color stability, Specific gravity, Fungus resistance, and Volume resistivity, one size within the size range 3/16" through 3/4" shall qualify all sizes.

#### 4.2.2. Acceptance Test Samples

Acceptance test samples shall consist of not less than 5 m *(16 feet)* 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.

#### 4.2.3. Lot Formation

A lot shall consist of all tubing of the same size, from the same production run, and offered for inspection at the same time.

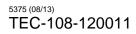
#### 4.3. TEST PROCEDURES

Dimensions can be found in TEC-108-120011 TAT-125 SCD or the specific drawing for the numbered size.

Unless otherwise specified, perform tests on specimens which have been fully recovered by conditioning for 5 minutes in a  $150 \pm 5^{\circ}$ C ( $302 \pm 9^{\circ}$ F) oven. Condition the test specimens (and measurement gauges, when applicable) for 3 hours at  $23 \pm 3^{\circ}$ C ( $73 \pm 5^{\circ}$ F) and  $50 \pm 5$  percent relative humidity prior to all testing. Use mechanical convection type ovens in which air passes the specimens at a velocity of 30 to 60 m (100 to 200 feet) per minute.

#### 4.3.1. Dimensions and Longitudinal Change

Measure three 6-inch (150 mm) specimens of tubing, as supplied, for length  $\pm 1$  mm ( $\pm 1/32$  inch), and inside diameter in accordance with ASTM D 2671. Condition the specimens for 5 minutes in a 150  $\pm$  5°C ( $302 \pm 9$ °F) oven, cool to 23  $\pm$  3°C ( $73 \pm 5$ °F) and then 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. Dimensions of adhesive thickness shall be taken from specimens which have been hung vertically in the oven during recovery. The adhesive thickness shall be the average determined by measuring a cross section taken 1 inch from each end of the suspended specimen. Care should be taken not to overheat the adhesive so that it drips or flows from the tubing.



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Calculate the longitudinal change as follows:

 $LC = ((L_1 - L_0) / L_0) \times 100$ 

- $\begin{array}{ll} \mbox{Where:} & \mbox{LC} = \mbox{Longitudinal Change [percent]} \\ & \mbox{L}_0 = \mbox{Length Before Conditioning [inches (mm)]} \\ & \mbox{L}_1 = \mbox{Length After Conditioning [inches (mm)]} \end{array}$
- 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 25-mm (1-inch) initial jaw separation, and jaw separation speed of  $500 \pm 50 \text{ mm}$  ( $20 \pm 2 \text{ inches}$ ) 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 Quality.

## 5. PREPARATION FOR DELIVERY

- 5.1. FORM
  - 5.1.1. The tubing shall be supplied in lengths of 1220 +25, -0 mm (48 +1, -0 inches) unless otherwise specified.

## 5.2. PACKAGING

- 5.2.1. Packaging shall be in accordance with good commercial practice.
- 5.3. MARKING
  - 5.3.1. Each container of tubing shall be permanently and legibly marked with the size, quantity, manufacturer's identification, part number and lot number.



# APPENDIX

Tubing Size	Mandrel	Mandrel Diameter	
_	mm.	in.	
1/8" to 1/4" inclusive	7.9	5/16	
3/8" to 3/4" inclusive	12.7	1/2	
1" to 4"	14.3	9/16	

#### TABLE 1 MANDREL DIMENSIONS FOR BEND TESTING

#### TABLE 2 REQUIREMENTS

PROPERTY	UNIT	REQUIREMENT		TEST METHOD
		TYPE 1	TYPE 2	
PHYSICAL				Section 4.3.1
Dimensions		TAT-125 SCD	TAT-125 SCD	ASTM D 2671
Longitudinal Change	Percent	+1, -5	+1, -5	ASTM D 2671
Tensile Strength based on Outer	MPa <i>(psi)</i>	10.3 min	10.3 min	Section 4.3.2
Jacket		(1500)	(1500)	ASTM D 2671
Ultimate Elongation	Percent	200 minimum	200 minimum	
Secant Modulus (Expanded)	MPa <i>(psi)</i>	172 max	172 max	ASTM D 882, 2%
based on Outer Jacket		(2.5 x 10⁴)	(2.5 x 10⁴)	strain
Cold Impact		No more than	No more than	ASTM D 746
at -55 ± 2°C <i>(</i> -67 <i>±</i> 4° <i>F)</i>		5 of 10 crack	5 of 10 crack	Proc. A
Heat Shock		No dripping,	No dripping,	Table 2 mandrels
4 hours at 250 ± 3°C <i>(4</i> 82 ± 5°F)		flowing or	flowing or	ASTM D 2671
		cracking of	cracking of	
		outer wall	outer wall	
Heat Resistance				ASTM D 2671
168 hours at 175 ± 2°C (347 ± 4°F)				Table 2 mandrels
Followed by test for mandrel bend				360 ° bend in 10 ±
				2 seconds
Color Stability		MIL-STD-104		ASTM D 2671
48 hours at 175 ± 2°C (347 ± 4°F)				
ELECTRICAL		40.000	40.000	NOTE
Dielectric Strength	Volts/mm	19,680 min	19,680 min	NOTE 1
	(Volts/mil)	<i>(500)</i> on dual	<i>(500)</i> on dual	ASTM D 2671
Malana David'i '		wall specimen	wall specimen	
Volume Resistivity	ohm-cm	1 X 10 <sup>14</sup>	1 X 10 <sup>14</sup>	ASTM D 2671
		minimum on	minimum on	
		dual wall	dual wall	
		specimen	specimen	

Requirements are continued on next page.



## **REQUIREMENTS (continued)**

PROPERTY	UNIT	REQUIREMENT		TEST METHOD
CHEMICAL				
Copper Mirror Corrosion 16 hours at		No removal of	No removal of	ASTM D 2671
121 ± 2°C (250 ± 4°F)		copper	copper	Procedure A
Copper Contact Corrosion		No pitting or	No pitting or	ASTM D 2671
16 hours at 121 ± 2°C <i>(250± 4°F)</i>		blackening of	blackening of	Procedure B
		copper	copper	
Flammability (jacket only)		Self-		ASTM D 2671
		extinguishing		Procedure B
		within		
		1 minute, 25%		
		maximum flag		
Water Absorption	Percent	burn 0.5 maximum	0.2 maximum	ASTM D 2671
24 hours at 23°C $\pm$ 2°C (73°F $\pm$ 4°F)	Percent	0.5 maximum	0.2 maximum	ASTIVI D 2071
Fluid Resistance				ASTM D 2671
24 hours at 24°C $\pm$ 3°C (75°F $\pm$ 5°F)				
in:				
JP-8 Turbine Fuel (MIL-T-83133)				
Skydrol 500B*				
Hydraulic Fluid (MIL-PRF-5606)				
Avaiation Gasoline (ASTM D910Mi)				
5% NaCl Water				
Followed by tests for:				
Dielectric Strength	Volts/mm	15,760 min	15,760 min	
	(Volts/mil)	(400)	(400)	-
Tensile Strength	MPa <i>(psi)</i>	6.9 min	6.9 min	
		(1000)	(1000)	100.040
Fungus Resistance				ISO 846
Followed by tests for:				Method B
Tensile Strength	MPa <i>(psi)</i>	10.3 min	10.3 min	Section 4.3.2
		(1500)	(1500)	ASTM D 2671
Ultimate Elongation	percent	200 minimum	200 minimum	
Dielectric Strength	Volts per mm	19,680 min	19,680 min	
5	(Volts per mil)	(500)	(500)	
				OR
		No Growth	No Growth	ASTM G 21

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NOTE 1: Recover the specimens on the metal mandrels for 10 minutes, minimum, at  $150 \pm 3^{\circ}$ C ( $302 \pm 5^{\circ}$ F) or until the tubing is completely shrunk on the mandrels.