



Standard Test Methods for Flexible Treated Sleeving Used for Electrical Insulation¹

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This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 These test methods cover procedures for testing electrical insulating sleeving comprising a flexible tubular product made from a woven textile fibre base, such as cotton, rayon, nylon, or glass, thereafter impregnated, or coated, or impregnated and coated, with a suitable dielectric material.

1.2 The procedures appear in the following sections:

Procedures	Sections
Brittleness Temperature	18 to 21
Compatibility of Sleeving with Magnet Wire Insulation	45 to 59
Conditioning	6
Dielectric Breakdown Voltage	12 to 17
Dielectric Breakdown Voltage After Short-Time Aging	29 to 33
Dimensions	7 to 11
Effect of Push-Back After Heat Aging	73 to 78
Flammability	22 to 28
Hydrolytic Stability	66 to 72
Oil Resistance	34 to 37
Selection of Test Material	5
Solvent Resistance	60 to 65
Thermal Endurance	38 to 44

1.3 The values stated in inch-pound units, except for $^{\circ}\text{C}$, are to be regarded as the standard. The values in parentheses are provided for information only.

1.4 This is a fire-test-response standard. See Sections 22 through 28, which are the procedures for flammability tests.

1.5 These test methods can be used to measure and describe the properties of materials, products, or assemblies in response to heat and flame under controlled laboratory conditions, but should not be used to describe or appraise the fire hazard or fire risk of materials, products, or assemblies under actual fire conditions. However, results of this test may be used as elements of a fire risk assessment which take into account all of the factors which are pertinent to an assessment of the fire hazard of a particular end use.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.* For specific hazard

statements, see 45.2 and 63.1.1.

2. Referenced Documents

2.1 ASTM Standards:

D 149 Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies²

D 374 Test Methods for Thickness of Solid Electrical Insulation²

D 471 Test Method for Rubber Property—Effect of Liquids³

D 618 Practice for Conditioning Plastics and Electrical Insulating Materials for Testing⁴

D 746 Test Method for Brittleness Temperature of Plastics and Elastomers by Impact⁴

D 876 Test Methods for Nonrigid Vinyl Chloride Polymer Tubing Used for Electrical Insulation²

D 2307 Test Method for Relative Thermal Endurance of Film-Insulated Round Magnet Wire²

D 3487 Specification for Mineral Insulating Oil Used in Electrical Apparatus⁵

D 3636 Practice for Sampling and Judging Quality of Solid Electrical Insulating Materials⁶

D 5423 Specification for Forced-Convection Laboratory Ovens for Evaluation of Electrical Insulation⁶

E 145 Specification for Gravity-Convection and Forced-Ventilation Ovens⁷

2.2 IEEE Standard:

IEEE 101 Guide for the Statistical Analysis of Thermal Life Test Data⁸

3. Terminology

3.1 Descriptions of Terms Specific to This Standard:

3.1.1 *flammability*—a measure of the rate of travel of a flame down a specimen when ignited and held in a vertical position.

² Annual Book of ASTM Standards, Vol 10.01.

³ Annual Book of ASTM Standards, Vol 09.01.

⁴ Annual Book of ASTM Standards, Vol 08.01.

⁵ Annual Book of ASTM Standards, Vol 10.03.

⁶ Annual Book of ASTM Standards, Vol 10.02.

⁷ Annual Book of ASTM Standards, Vol 14.02.

⁸ Available from the Institute of Electrical and Electronics Engineers, Inc., 345 E. 47th St., New York, NY, 10017.

¹ These test methods are under the jurisdiction of ASTM Committee D-9 on Electrical and Electronic Insulating Materials and are the direct responsibility of Subcommittee D09.07 on Flexible and Rigid Insulating Materials.

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3.1.2 *size*—a numerical designation which indicates that the inside diameter of the sleeving lies within the limits prescribed in Table 1.

3.1.3 *wall thickness*—one half the difference between the outside diameter of the sleeving mounted on a loosely fitting gage rod and the diameter of the gage rod when measured in accordance with 9.2.

4. Apparatus and Materials

4.1 Ovens used in these test methods shall meet the requirements of Specification D 5423.

5. Selection of Test Material

5.1 In the case of sleeving on spools or in coils, not less than three turns of the product shall be removed before the selection of material from which test specimens are to be prepared.

5.2 In the case of sleeving offered in cut lengths, test specimens shall not be prepared from material closer than 1 in. (25 mm) from each end.

5.3 Specimens for test shall not show obvious defects unless the purpose of the test is to determine the effect of such defects.

5.4 Specimens shall be prepared from samples selected in accordance with Practice D 3636. The sampling plan and acceptance quality level shall be as agreed upon between the user and the producer.

6. Conditioning

6.1 Unless otherwise specified, a standard laboratory atmosphere of 50 ± 5 % relative humidity and 23 ± 2°C (73.4 ± 3.6°F) shall be used in conducting all tests and for conditioning specimens for a period of at least 18 h prior to testing.

6.2 In the case of dielectric breakdown voltage tests after humidity conditioning, specimens shall be conditioned for 96 h in an atmosphere of 93 ± 3 % relative humidity and 23 ± 2°C (73.4 ± 3.6°F) before testing. If a conditioning cabinet is used, specimens shall be tested for dielectric breakdown voltage within 1 min after removal from the cabinet.

6.3 For details regarding conditioning, refer to Practice D 618.

DIMENSIONS

7. Apparatus

7.1 *Gage Rods*—Standard gage rods shall be made of steel and shall have smooth surfaces and rounded edges. One rod is required for each of the maximum and minimum diameters shown in Table 1 for each size. Each rod shall be within ±0.005 in. (±0.127 mm) of the values shown in Table 1.

8. Test Specimens

8.1 Five test specimens of at least 7 in. (180 mm) in length shall be cut from material obtained in accordance with Section 5.

9. Procedure

9.1 *Inside Diameter*—Pass the minimum gage rod for the size sleeving under test into the specimen for a distance of 5 in. (127 mm) without expanding the wall of the sleeving. If the rod has a snug fit, then consider the specimen as having an inside diameter equal to the diameter of the rod. If the minimum gage rod fits loosely, insert the maximum gage rod into the specimen. If the maximum gage rod passes freely into the specimen for a distance of 5 in. with a snug fit, or if it expands the wall of the specimen, then consider the sleeving to be of that size which falls within the limits of the maximum and minimum inside diameters as represented by the gage rods.

9.2 *Wall Thickness*—Insert in the specimen the largest standard gage rod that will pass freely into the sleeving. Apply a micrometer over the specimen and make thickness measurements as specified in Method C of Test Methods D 374 except that the force on the pressor foot shall be 3 oz (85 g). Obtain the average of five thickness readings taking the micrometer readings at approximately 90° intervals about the circumference of the specimen and spaced lineally approximately 0.25 in. (6 mm). Methods A and B of Test Methods D 374 can be used as alternative methods where agreed upon between the manufacturer and purchaser. Compute wall thickness as half the distance between the outside diameter of the mounted sleeving and the diameter of the gage rod.

10. Report

10.1 Report the following information:

- 10.1.1 Identification of the sleeving,
- 10.1.2 Method of measurement if other than Method C,
- 10.1.3 Size of sleeving, and
- 10.1.4 Wall thickness.

11. Precision and Bias

11.1 *Precision*—The overall estimates of the precision

TABLE 1 ASTM Standard Sizes for Flexible Sleeving

Size	Inside Diameter, in. (mm)	
	Max	Min
1 in.	1.036 (26.3)	1.000 (25.4)
7/8 in.	0.911 (23.1)	0.875 (22.2)
3/4 in.	0.786 (20.0)	0.750 (19.1)
5/8 in.	0.655 (16.6)	0.625 (15.9)
1/2 in.	0.524 (13.3)	0.500 (12.7)
7/16 in.	0.462 (11.7)	0.438 (11.1)
3/8 in.	0.399 (10.1)	0.375 (9.5)
No. 0	0.347 (8.8)	0.325 (8.3)
No. 1	0.311 (7.9)	0.289 (7.3)
No. 2	0.278 (7.1)	0.258 (6.6)
No. 3	0.249 (6.3)	0.229 (5.8)
No. 4	0.224 (5.7)	0.204 (5.2)
No. 5	0.198 (5.0)	0.182 (4.6)
No. 6	0.178 (4.5)	0.162 (4.1)
No. 7	0.158 (4.0)	0.144 (3.7)
No. 8	0.141 (3.6)	0.129 (3.3)
No. 9	0.124 (3.1)	0.114 (2.9)
No. 10	0.112 (2.8)	0.102 (2.6)
No. 11	0.101 (2.6)	0.091 (2.31)
No. 12	0.091 (2.31)	0.081 (2.06)
No. 13	0.082 (2.08)	0.072 (1.83)
No. 14	0.074 (1.88)	0.064 (1.63)
No. 15	0.067 (1.70)	0.057 (1.45)
No. 16	0.061 (1.55)	0.051 (1.30)
No. 17	0.054 (1.37)	0.045 (1.14)
No. 18	0.049 (1.24)	0.040 (1.02)
No. 20	0.039 (0.99)	0.032 (0.81)
No. 22	0.032 (0.81)	0.025 (0.64)
No. 24	0.027 (0.69)	0.020 (0.51)

TABLE 2 Estimated Precision of Wall Thickness Measurement

Sleeving Type	Nominal Value, in. (mm)		$(S_r)_j$, in. (mm)		$(S_R)_j$, in. (mm)	
Acrylic	0.0213	(0.54)	0.0007	(0.018)	0.0017	(0.043)
PVC	0.0237	(0.60)	0.0007	(0.018)	0.0021	(0.053)
Silicone Rubber	0.0331	(0.84)	0.0012	(0.030)	0.0019	(0.048)

within laboratories (S_r)_j and the precision between laboratories (S_R)_j for the determination of wall thickness are given in Table 2 for three selected materials. These estimates are based on a round robin of the three materials with six laboratories participating.⁹

11.2 *Bias*—Since there is no accepted reference material suitable for determining the bias for the procedure for measuring wall thickness, bias has not been determined.

DIELECTRIC BREAKDOWN VOLTAGE

12. Significance and Use

12.1 The dielectric breakdown voltage of the sleeving is of importance as a measure of its ability to withstand electrical stress without failure. This value does not correspond to the dielectric breakdown voltage expected in service, but may be of considerable value in comparing different materials or different lots, in controlling manufacturing processes or, when coupled with experience, for a limited degree of design work. The comparison of dielectric breakdown voltage of the same sleeving before and after environmental conditioning (moisture, heat, and the like) gives a measure of its ability to resist these effects. For a more detailed discussion, refer to Test Method D 149.

13. Apparatus

13.1 *Inner Electrode*—A straight suitable metallic conductor which fits snugly into the sleeving, without stretching the wall, in such a manner that one end of the wire is exposed and can be used to support the specimen.

13.1.1 For specimens having an inside diameter greater than about size 8, it may be convenient to use either stranded conductors or a bundle of wires of smaller size, instead of a solid conductor.

13.2 *Outer Electrode*—Strips of soft metal foil 1-in. (25-mm) wide and not more than 0.001 in. (0.03 mm) in thickness.

14. Procedure A—Straight Specimens

14.1 *Test Specimens*—Ten specimens 7 in. (180 mm) long shall be prepared for each conditioning test (see Section 6) from material selected in accordance with Section 5.

14.2 Procedure:

14.2.1 After conditioning in accordance with 6.1, determine the dielectric breakdown voltage in accordance with Test Method D 149 except as specified in 14.2.2 and 14.2.3.

14.2.2 Mount a sleeving specimen on the inner electrode. Wrap the outer electrode tightly on the outside of the sleeving at a distance of not less than 1 in. (25 mm) from the ends of the specimens. Snugly wrap the foil over the sleeving. Wind two

more turns of foil over the first turn, leaving a free end of about 0.5 in. (13 mm) to which an electrical contact can be made.

14.2.3 Determine the breakdown voltage, in accordance with Test Method D 149 by the short time method, increasing the voltage from zero at a rate of 0.5 kV/s. Calculate the average breakdown voltage for the ten tests.

15. Procedure B—90° Bent Specimens

15.1 *Test Specimens*—Ten specimens 4 in. (100 mm) long shall be prepared for each conditioning test (see Section 6) from material selected in accordance with Section 5.

15.2 Procedure:

15.2.1 Mount a sleeving specimen on the inner electrode.

15.2.2 Bend the specimen through an angle of $90 \pm 2^\circ$ over a smooth mandrel having a diameter of ten times the nominal inside diameter of the specimen. Arrange the bend so that it is centrally located on the specimen.

15.2.3 Condition the samples as specified in 6.1.

15.2.4 Determine the dielectric breakdown voltage of the bent specimen using the following procedure:

15.2.4.1 Carefully wrap a strip of metal foil as in 14.2.2 snugly over the specimens at the bend. In accordance with Test Method D 149 apply a voltage starting at zero and increasing at a constant rate of 0.5 kV/s until breakdown. Calculate the average breakdown voltage of the ten specimens.

NOTE 1—Apply the foil electrode after exposure to conditioning.

16. Report

16.1 Report the following information:

16.1.1 Identification of the sleeving,

16.1.2 Conditioning before test,

16.1.3 Voltage breakdown for each puncture,

16.1.4 Average, minimum, and maximum voltage breakdown,

16.1.5 Procedure used (Method A or B), and

16.1.6 Temperature and relative humidity of test, if different from 6.1.

17. Precision and Bias

17.1 *Precision*—The overall estimates of the precision within laboratories (S_r)_j and the precision between laboratories (S_R)_j for the determination of Dielectric Breakdown Voltage by Procedure A are given in Table 3 for three selected materials. These estimates are based on a round robin of the three materials with six laboratories participating.⁹

17.2 *Bias*—This test method has no bias because the value for dielectric breakdown voltage is determined solely in terms of this test method.

TABLE 3 Estimated Precision of Dielectric Breakdown Voltage Measurement

Sleeving Type	Nominal Value, Volts	$(S_r)_j$, Volts	$(S_R)_j$, Volts
	Conditioned 18 h/23°C/50 % RH		
Acrylic	8480	802	1126
PVC	10980	983	1528
Silicone Rubber	10770	904	1616
Conditioned 96 h/23°C/93 % RH			
Acrylic	2048	197	828
PVC	8100	1003	2137
Silicone Rubber	8540	1367	2550

⁹ Supporting data are on file at ASTM Headquarters. Request RR: D-9-1024.

BRITTLENESS TEMPERATURE

18. Significance and Use

18.1 This test method serves to measure the brittleness temperature of the sleeving. It is useful for comparative and quality control purposes.

18.2 Results of this test have not been found to correlate with those obtained by bending or flexing around mandrels at low temperatures. The temperature as determined may vary for different sleeving sizes for materials of the same composition due to differences in cross-sectional dimensions and in specimen configuration.

19. Procedure

19.1 Determine the brittleness temperature in accordance with Test Method D 746, except as specified in 19.1.1-19.1.4.

19.1.1 For sleeving sizes 20 through 8, cut specimens in full section and 1.5 in. (38 mm) long.

19.1.2 For sleeving sizes 7 through 1 in. inside diameter, cut specimens 0.25 in. (6.4 mm) wide and 1.5 in. (38 mm) long with the longer dimension parallel to the axis of the sleeving. Take care to avoid cutting the specimens from the edges of sleeving that has been flattened during manufacture or storage.

19.1.3 Use only motor-driven or gravity-fall apparatus, such as described in Test Methods D 876. Mount specimens so that the striking edge of the apparatus contacts the film, and not the braid.

19.1.4 Failure of a specimen is indicated by cracking of the film completely through to the braid, as determined by visual examination.

20. Report

20.1 Report the following information:

20.1.1 Identification of the sleeving,

20.1.2 Brittleness temperature to the nearest °C,

20.1.3 Method of calculation (see Test Method D 746),

20.1.4 Type of apparatus used, and

20.1.5 Number of specimens tested.

21. Precision and Bias

21.1 *Precision*—This test method has been in use for many years, but no statement of precision has been made and no activity is planned to develop such a statement.

21.2 *Bias*—This test method has no bias because the value for brittleness temperature is determined solely in terms of this test method.

FLAMMABILITY—METHOD A

22. Procedure

22.1 Determine the flammability in accordance with Test Methods D 876. The results of this test give an indication of the tendency of the material to burn in case of fire.

FLAMMABILITY—METHOD B

23. Significance and Use

23.1 This test gives an indication of the relative rate at which materials that will burn will propagate a flame.

24. Apparatus

24.1 *Bunsen burner.*

24.2 *Stopwatch.*

25. Test Specimens

25.1 Cut at least three specimens from the material selected in accordance with Section 5.

26. Procedure

26.1 Mark a gage length of 1 in. (25 mm) on each test specimen approximately 0.5 in. (13 mm) from one end of the specimen. Using a method that will not distort the test area, close the other end to prevent passage of air through the specimen during the test.

26.2 Insert the open end of the sleeving into the side of the burner flame with the lower side of the sleeving about 0.5 in. (13 mm) above the top of the burner. Rotate the specimen in the flame to ignite it uniformly. Remove the sleeving from the flame and hold vertically in the air with the burning end uppermost.

26.3 Start the timer when the leading edge of the flame reaches the upper gage mark and observe the time in seconds for the leading edge of the flame to travel down the specimen to the lower gage mark.

27. Report

27.1 Report the following information:

27.1.1 Identification of the sleeving, and

27.1.2 For each specimen, the time in seconds required to burn 1 in. (25.4 mm).

28. Precision and Bias

28.1 No statement is made about either the precision or the bias of this test method since the result merely states whether there is conformance to the criteria for success as specified in the procedure.

DIELECTRIC BREAKDOWN VOLTAGE AFTER SHORT-TIME AGING

29. Significance and Use

29.1 This test method serves to indicate the resistance of sleeving to the effects of short-time exposure to elevated temperatures. While this test method provides a means of determining continuity of quality and is useful as a lot acceptance test, it is not intended to provide information regarding the thermal endurance of the sleeving (see Sections 38 to 44).

30. Test Specimens

30.1 Prepare five 90° bent test specimens as described in 15.2.1 and 15.2.2.

31. Procedure

31.1 Condition the test specimens in an oven for a period of 96 h at a temperature 50°C (90°F) higher than the nominal temperature index of the sleeving. Remove the specimens and allow to cool to room temperature. Apply the outer electrode and determine the dielectric breakdown voltage in accordance with 14.2.