



Standard Test Methods for Flexible Treated Sleeving Used for Electrical Insulation¹

This standard is issued under the fixed designation D 350; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

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 °C, are to be regarded as the standard. The values in parentheses are provided for information only.~~

1.3 The values stated in inch-pound units, except for °C, are to be regarded as the standard. The values in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

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.~~

1.5 This standard measures and describes the response of materials, products, or assemblies to heat and flame under controlled conditions, but does not by itself incorporate all factors required for fire hazard or fire risk assessment of the materials, products or assemblies under actual fire conditions.

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.

NOTE 1—This standard resembles IEC 60684-2, Specification for Flexible Insulating Sleeving—Part 2 Methods of Test, in a number of ways, but is not consistently similar throughout. The data obtained using either standard may not be technically equivalent.

2. Referenced Documents

2.1 *ASTM Standards:*²

¹ These test methods are under the jurisdiction of ASTM Committee D09 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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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* Vol 10.01, volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard.

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

D 374 Test Methods for Thickness of Solid Electrical Insulation

D 471 Test Method for Rubber Property—Effect of Liquids

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

~~D 876 Test Methods for Nonrigid Vinyl Chloride Polymer Tubing Used for Electrical Insulation~~² Test Methods for Nonrigid Vinyl Chloride Polymer Tubing Used for Electrical Insulation

D 1711 Terminology Relating to Electrical Insulation

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

D 3487 Specification for Mineral Insulating Oil Used in Electrical Apparatus

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

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

D 6054 Practice for Conditioning Electrical Insulating Materials for Testing

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

E 176 Terminology of Fire Standards

2.2 *IEEE Standard:*

IEEE 101 Guide for the Statistical Analysis of Thermal Life Test Data³

2.3 *IEC Standard:*

~~IEC 60684-2 Specification for Flexible Insulating Sleeving—Part 2 Methods of Test~~

IEC 60684-2 Specification for Flexible Insulating Sleeving—Part 2 Methods of Test⁴

2.4 *ISO Standard:*

ISO 13943 Fire Safety—Vocabulary

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

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

~~3.1.2 *Definitions:*~~

~~3.1.1 Use Terminology E 176 and ISO 13943 for definitions of terms used in this test method and associated with fire issues.~~

Where differences exist in definitions, those contained in Terminology E 176 shall be used. Use Terminology D 1711 for definitions of terms used in this test method and associated with electrical insulation materials.

3.2 *Definitions of Terms Specific to This Standard:*

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

3.1.3

3.2.2 *wall thickness, n*—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,

² Annual Book of ASTM Standards, Vol 09.01.

³ Available from Institute of Electrical and Electronics Engineers, Inc. (IEEE), 445 Hoes Ln., P.O. Box 1331, Piscataway, NJ 08854-1331, <http://www.ieee.org>.

⁴ Annual Book of ASTM Standards, Vol 08.01.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

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) |

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 6054.

<https://standards.iteh.ai/catalog/standards/sist/29566ed9-9e7c-44b5-859a-a0520333b752/astm-d350-08>

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. (± 6.012 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.

TABLE 2 Estimated Precision of Wall Thickness Measurement

| Sleeving Type | Nominal Value, | | $(Sr)_i$, | | $(SR)_j$, | |
|-----------------|----------------|--------|------------|---------|------------|---------|
| | in. (mm) | | in. (mm) | | 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) |

11. Precision and Bias

11.1 *Precision*—The overall estimates of the precision within laboratories $(Sr)_i$ and the precision between laboratories $(SR)_j$ 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.⁵

11.2 *Bias*—This test method has no bias because the value for wall thickness is determined solely in terms of this test method itself.

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~~ is a 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*:

⁵ Annual Book of ASTM Standards, Vol 10.05.

⁵ Supporting data have been filed at ASTM International Headquarters and may be obtained by requesting Research Report RR: D09-1024.

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 2—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 (Sr)_i and the precision between laboratories (SR)_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.⁵

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.

BRITTLINESS 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.~~

18.2 Results of this test have not been found to correlate with those obtained by bending or flexing around mandrels at low temperatures. Brittleness temperatures determined for sleeving materials by this test are affected by differences in cross-sectional dimensions and in specimen configuration, even if the materials have the same composition.

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.

TABLE 3 Estimated Precision of Dielectric Breakdown Voltage Measurement

| Sleeving Type | Nominal Value, Volts | (Sr) _i , Volts | (SR) _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 |

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 information has been presented to ASTM upon which to base a statement of precision. No activity has been planned to develop such information.

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.