



Designation: **F2633–07 F2633 – 13**

Standard Specification for Wrought Seamless Nickel-Titanium Shape Memory Alloy Tube for Medical Devices and Surgical Implants¹

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1. ~~Scope~~ Scope*

1.1 This specification covers the requirements for wrought nickel-titanium shape memory alloy tube, nominally ~~54.5 %~~ 54.5 to 57.0 mass/mass (weight) % nickel, in the superelastic condition, used for the manufacture of medical devices and surgical implants. Material shall conform to the applicable requirements of Specification **F2063**. This specification addresses those product variables that differentiate drawn medical grade tube from the raw material and mill product forms covered in Specification **F2063**.

1.2 This specification applies to tube with 10 mm (0.4 in.) and smaller nominal outside diameter and 2 mm (0.08 in.) and thinner nominal wall thickness.

1.3 The values stated in SI units are to be regarded as the standard. The values given in parentheses (inch-pound units) are for information only.

2. Referenced Documents

2.1 *ASTM Standards:*²

A632 Specification for Seamless and Welded Austenitic Stainless Steel Tubing (Small-Diameter) for General Service

F2004 Test Method for Transformation Temperature of Nickel-Titanium Alloys by Thermal Analysis

F2005 Terminology for Nickel-Titanium Shape Memory Alloys

F2063 Specification for Wrought Nickel-Titanium Shape Memory Alloys for Medical Devices and Surgical Implants

F2082 Test Method for Determination of Transformation Temperature of Nickel-Titanium Shape Memory Alloys by Bend and Free Recovery

F2516 Test Method for Tension Testing of Nickel-Titanium Superelastic Materials

2.2 *ISO Standard:*³

ISO 9001 Quality Management Systems—Requirements

ISO 13485 Quality Management Standard for Medical Devices

2.3 *American Society for Quality Standards:*⁴

ASQ C1 Specification of General Requirements for a Quality Program

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.2 See Terminology **F2005** for the definition of terms used in this specification that are specific to nickel-titanium alloys.

3.3 *individual wall thickness measurement, n*—any one of the wall thickness measurements taken around the circumference on any one transverse cross-section of a single sample of the tube.

3.4 *lot, n*—the total quantity of ~~tube~~ product produced from the same melt heat under the same conditions, at essentially the same time.

¹ This specification is under the jurisdiction of ASTM Committee **F04** on Medical and Surgical Materials and Devices and is the direct responsibility of Subcommittee **F04.12** on Metallurgical 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* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

3.4.1 *Discussion—*

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

For purposes of this specification, conversion from bar to tubular form by extrusion, gundrilling, or other method is included within the scope of this definition.

3.5 *lot average concentricity, n*—the arithmetic average of the sample concentricities measured on a statistically representative number of samples from the lot.

3.6 *lot average wall thickness, n*—the grand average of the sample average wall thicknesses measured on a statistically representative number of samples from the lot.

3.7 *nominal outside diameter (OD), n*—the outside diameter specified by the purchaser on the purchaser's order or engineering drawing without regard to tolerance.

3.8 *nominal wall thickness, n*—the wall thickness specified by the purchaser on the purchaser's order or engineering drawing without regard to tolerance.

3.9 *sample average wall thickness, n*—the arithmetic average of all individual wall thickness measurements measured on a single sample.

3.10 *sample concentricity, n*—two times the offset between the centers of the two circles representing the outside diameter (OD) and the inside diameter (ID) of the tube. For purposes of this specification, the sample minimum wall and the sample maximum wall measured on any one transverse cross section of a single sample shall be used to calculate concentricity. Also, for purposes of this specification, sample concentricity shall be expressed as a percent and shall be calculated using the following equation:

$$\text{Sample concentricity percent} = 2 \times \left[\frac{A - B}{A + B} \right] \times 100$$

where:

A = sample maximum wall, and

B = sample minimum wall.

3.10.1 Discussion—

For purposes of this specification, the sample minimum wall and the sample maximum wall measured on any one transverse cross section of a single sample shall be used to calculate concentricity. Also, for purposes of this specification, sample concentricity shall be expressed as a percent and shall be calculated using the following equation:

$$\text{Sample concentricity percent} = 2 \times \left[\frac{A - B}{A + B} \right] \times 100$$

where:

A = sample maximum wall, and

B = sample minimum wall.

3.11 *sample maximum wall thickness, n*—the largest individual wall thickness measurement taken around the circumference on any one transverse cross section of a single sample of tube.

3.11.1 Discussion—

In practice, the sample maximum wall thickness may be the largest of no less than four individual wall thickness measurements taken at uniformly spaced locations around the circumference of a single sample of the tube.

3.12 *sample minimum wall thickness, n*—the smallest individual wall thickness measurement taken around the circumference on any one transverse cross section of a single sample of tube.

3.12.1 Discussion—

In practice, the sample minimum wall thickness may be the smallest of no less than four individual wall thickness measurements taken at uniformly spaced locations around the circumference of a single sample of the tube.

4. Ordering Information

4.1 Inquiries and orders for material under this specification may include the following information:

4.1.1 Quantity (total length or number of pieces),

4.1.2 This ASTM specification and date of issue,

4.1.3 Condition (see 5.2),

4.1.4 Active Austenite Finish Temperature (see 7.27.3),

- 4.1.5 Mechanical Properties (see **Table 1**),
- 4.1.6 Surface Finish (see **5.3**),
- 4.1.7 Nominal Dimensions including either OD and ID, OD and wall, or ID and wall, or engineering drawing number,
- 4.1.8 Length (exact or random, see **9.4**),
- 4.1.9 Dimensional Tolerances (see **Table 2** and **Table 3**),
- 4.1.10 Certification requirements (see **Section 11**), and
- 4.1.11 Special requirements or supplementary requirements, if any.

5. Materials and Manufacture

5.1 Method of Manufacture:

5.1.1 Seamless tube shall be made from bar, hollow bar, or tube raw material forms that meet the requirements of Specification **F2063**.

5.1.2 Seamless tube shall be made by a process in which the tube periphery is continuous at all stages of the process.

5.2 *Condition*—Tube shall be furnished in the superelastic condition or as agreed upon between purchaser and supplier.

5.3 Surface Finish:

5.3.1 The tube outer surface shall be furnished, as specified by the purchaser, with a uniform, adherent oxide of any color, pickled, chemically etched, ground, or mechanically polished finish. Other finishes may be agreed upon between purchaser and supplier.

5.3.2 The tube inner surface shall be furnished, as specified by the purchaser, with a uniform, adherent oxide of any color, pickled, chemically etched, or mechanically conditioned finish.

5.3.3 Inner and outer surface roughness and the method of measurement shall be as agreed upon between the purchaser and supplier.

6. Chemical Composition

6.1 Seamless tube shall be made from bar, hollow bar, or tube raw material forms that meet the chemical composition requirements of Specification **F2063**.

NOTE 1—Non-metallic inclusions shall be rated and reported on the starting bar, hollow bar, or tube raw material forms by the raw material supplier per Specification **F2063**. Alternate non-metallic inclusion requirements and rating methods may be agreed upon between purchaser and supplier.

6.2 Hydrogen content shall be analyzed and reported when required by the purchaser. The analysis shall be made on the finished tube.

7. Austenite Finish Transformation Temperature

7.1 ~~The austenite finish raw material manufacturer shall measure the ingot transformation temperature of the raw material (ingot A_f) shall be measured on fully annealed raw material by the raw material manufacturer samples per Test Method **F2004** or Test Method **F2082** as required in Specification **F2063**. The raw material supplier shall report the ingot austenite finish (ingot A_f) transformation temperature as well as any of ingot Martensite finish (M_f), Martensite peak (M_p), Martensite start (M_s), Austenite start (A_s), or Austenite peak A_p transformation temperatures as required by the raw material purchaser. Each ingot transformation temperature reported will be clearly labeled by transformation type.~~

7.2 The ingot A_f and any other appropriate ingot transformation temperature reported by the raw material supplier may be reported on the finished tube certification as the ingot transformation temperature when required by the finish tube purchaser. Each ingot transformation temperature reported will be clearly labeled by the transformation type.

7.3 The ~~austenite~~ Austenite finish temperature of the finished tube (active A_f) with outer diameter in the range of 0.3 to 3.0 mm (0.012 to 0.12 in.) shall be measured by the supplier on representative full round tube sample(s) using the bend and free recovery method described in Test Method **F2082** when required by the purchaser.

7.4 Alternate transformation temperatures and alternate measurement methods may be agreed upon between purchaser and supplier.

TABLE 1 Mechanical Properties

	UTS	Uniform Elongation	Upper Plateau Strength	Lower Plateau Strength	Residual Elongation
Condition	Min MPa (ksi)	Min % in 50 mm (2 in.) or 4D	Min MPa (ksi) at 3 % strain	Min MPa (ksi) at 2.5 % strain	Max % after 6 % strain
Superelastic ^A	1000 (145)	10	380 (55)	^B	0.3 %

^ASuperelastic properties are measured per Test Method **F2516** at room temperature.

^BLower plateau strength value may be measured and reported for information only.