



Standard Specification for FEP-Fluorocarbon Tube¹

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1. Scope*

1.1 The tubing is intended for electrical, mechanical, chemical, and medical applications manufactured from extrusion resins made from the copolymer of tetrafluoroethylene and hexafluoropropylene (FEP-fluorocarbon). This specification is for virgin material only and does not address recycled material as it is not appropriate for FEP tubing.

NOTE 1—Abbreviations are in accordance with Terminology **D1600**.
NOTE 2—There is no known ISO equivalent to this standard.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 The following safety hazards caveat pertains only to the test methods portion, Section 8, of this specification: *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.*

2. Referenced Documents

2.1 *ASTM Standards*:²

- D149** Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies
- D618** Practice for Conditioning Plastics for Testing
- D792** Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D883** Terminology Relating to Plastics
- D1600** Terminology for Abbreviated Terms Relating to Plastics
- D1675** Test Methods for Polytetrafluoroethylene Tubing
- D2116** Specification for FEP-Fluorocarbon Molding and Extrusion Materials

¹ This specification is under the jurisdiction of ASTM Committee **D20** on Plastics and is the direct responsibility of Subcommittee **D20.15** on Thermoplastic Materials (Section 20.15.12).

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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.

IEEE/ASTM SI 10 **American National Standard for Use of the International System of Units (SI): The Modern Metric System**

3. Terminology

3.1 *Definitions*—Definitions of terms used in this specification shall be in accordance with Terminology **D883**.

3.2 *Definitions of Terms Specific to This Standard*:

3.2.1 *lot, n*—one production run or uniform blend of two or more production runs.

4. Classification

4.1 This specification provides for three types of FEP-fluorocarbon tubing differentiated by size schedules as follows:

4.1.1 *Type I*—Tubing based upon the American Wire Gage (AWG) sizes.

4.1.2 *Type II*—Tubing based upon fractional inch sizes (see **Note 2**).

4.1.3 *Type III*—Tubing of all other sizes, as agreed by buyer and seller. This type shall conform to the Dimensional Tolerances for FEP Tubing, as listed in **Table 3**.

4.2 The types are further differentiated in accordance with increasing wall thicknesses as follows:

4.2.1 *Class A*—Tubing having walls tabulated in **Table 1** listed as light-weight wall.

4.2.2 *Class C*—Tubing having walls tabulated in **Table 1** listed as standard wall (see **Note 3**).

4.2.3 *Class D*—Tubing having walls tabulated in **Table 2** listed as chemical tubing.

4.2.4 *Class E*—Tubing having walls listed as heavy or conforming to the Dimensional Tolerances for FEP Tubing as listed in **Table 3**.

NOTE 3—Tubing having electrical internal diameters and wall thickness dimensions were deleted because of lack of demand.

NOTE 4—Class B has been deleted because of lack of demand.

4.3 A one-line system is used to specify materials in this specification. The system uses predefined cells to refer to specific aspects of this specification, as illustrated as follows:

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

TABLE 1 Dimensions and Tolerances for Type I FEP-Fluorocarbon Tubing—Dimensions, mm (in.)

AWG Size	Inside Diameter		Wall Thickness					
			Class A			Class C		
			Lightweight Wall			Standard Wall		
	min	max	nom	min	max	nom	min	max
24	0.51 (0.020)	0.69 (0.027)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.305 (0.012)	0.254 (0.010)	0.356 (0.014)
22	0.64 (0.025)	0.81 (0.032)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.305 (0.012)	0.254 (0.010)	0.356 (0.014)
20	0.81 (0.032)	1.02 (0.040)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
19	0.91 (0.036)	1.12 (0.044)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
18	1.02 (0.040)	1.25 (0.049)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
17	1.14 (0.045)	1.37 (0.054)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
16	1.30 (0.051)	1.55 (0.061)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
15	1.45 (0.057)	1.70 (0.067)	0.152 (0.006)	0.102 (0.004)	0.203 (0.008)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
14	1.63 (0.064)	1.88 (0.074)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
13	1.83 (0.072)	2.08 (0.082)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
12	2.06 (0.081)	2.31 (0.091)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
11	2.31 (0.091)	2.57 (0.101)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
10	2.59 (0.102)	2.85 (0.112)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.406 (0.016)	0.330 (0.013)	0.483 (0.019)
9	2.90 (0.114)	3.15 (0.124)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
8	3.28 (0.129)	3.58 (0.141)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
7	3.66 (0.144)	4.01 (0.158)	0.203 (0.008)	0.152 (0.006)	0.254 (0.010)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
6	4.12 (0.162)	4.52 (0.178)	0.254 (0.010)	0.178 (0.007)	0.330 (0.013)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
5	4.62 (0.182)	5.03 (0.198)	0.254 (0.010)	0.178 (0.007)	0.330 (0.013)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
4	5.18 (0.204)	5.69 (0.224)	0.254 (0.010)	0.178 (0.007)	0.330 (0.013)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
3	5.82 (0.229)	6.33 (0.249)	0.254 (0.010)	0.178 (0.007)	0.330 (0.013)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
2	6.55 (0.258)	7.06 (0.278)	0.254 (0.010)	0.178 (0.007)	0.330 (0.013)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
1	7.34 (0.289)	7.90 (0.311)	0.254 (0.010)	0.178 (0.007)	0.330 (0.013)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)
0	8.26 (0.325)	8.81 (0.347)	0.305 (0.012)	0.229 (0.009)	0.381 (0.015)	0.508 (0.020)	0.406 (0.016)	0.610 (0.024)

TABLE 2 Dimensions and Tolerances for Type II FEP-Fluorocarbon Tubing—Dimensions, mm (in.)

ID Size Fractions	Class D			Class D	
	Inside Diameter			Wall Dimensions	
	nom	max	min	Thickness	Tolerances
0.79 (1/32)	0.79 (0.031)	0.89 (0.035)	0.69 (0.027)	0.41 (0.016)	±0.076 (±0.003)
1.59 (1/16)	1.59 (0.062)	1.70 (0.067)	1.45 (0.057)	0.76 (0.030)	±0.127 (±0.005)
2.38 (3/32)	2.38 (0.094)	2.51 (0.099)	2.26 (0.089)	0.76 (0.030)	±0.127 (±0.005)
3.18 (1/8)	3.18 (0.125)	3.30 (0.130)	3.05 (0.120)	0.76 (0.030)	±0.127 (±0.005)
4.76 (3/16)	4.76 (0.188)	4.90 (0.193)	4.65 (0.183)	0.76 (0.030)	±0.127 (±0.005)
6.35 (1/4)	6.35 (0.250)	6.53 (0.257)	6.17 (0.243)	0.76 (0.030)	±0.127 (±0.005)
7.94 (5/16)	7.94 (0.312)	8.13 (0.320)	7.72 (0.304)	0.76 (0.030)	±0.127 (±0.005)
9.52 (3/8)	9.52 (0.375)	9.73 (0.383)	9.32 (0.367)	0.76 (0.030)	±0.127 (±0.005)
11.11 (7/16)	11.11 (0.438)	11.38 (0.448)	10.87 (0.428)	0.76 (0.030)	±0.152 (±0.006)
12.70 (1/2)	12.70 (0.500)	12.95 (0.510)	12.45 (0.490)	0.76 (0.030)	±0.152 (±0.006)
14.29 (9/16)	14.29 (0.563)	14.58 (0.574)	14.02 (0.552)	0.76 (0.030)	±0.152 (±0.006)
15.88 (5/8)	15.88 (0.625)	16.18 (0.637)	15.57 (0.613)	0.76 (0.030)	±0.152 (±0.006)
17.46 (1 1/16)	17.46 (0.688)	17.78 (0.700)	17.17 (0.676)	0.81 (0.032)	±0.152 (±0.006)
19.05 (3/4)	19.05 (0.750)	19.41 (0.764)	18.69 (0.736)	1.02 (0.040)	±0.178 (±0.007)
22.23 (7/8)	22.23 (0.875)	22.63 (0.891)	21.82 (0.859)	1.14 (0.045)	±0.178 (±0.007)
25.40 (1)	25.40 (1.000)	25.91 (1.020)	24.89 (0.980)	1.27 (0.050)	±0.203 (±0.008)
31.75 (1 1/4)	31.75 (1.250)	32.26 (1.270)	31.24 (1.230)	1.27 (0.050)	±0.203 (±0.008)
38.10 (1 1/2)	38.10 (1.500)	38.74 (1.525)	37.47 (1.475)	1.27 (0.050)	±0.203 (±0.008)
50.80 (2)	50.80 (2.000)	51.44 (2.025)	50.17 (1.975)	1.27 (0.050)	±0.203 (±0.008)

TABLE 3 Dimensions and Tolerances for Type III FEP-Fluorocarbon Tubing—Dimensions, mm (in.)

Class E Inside Diameter		Class E Wall Thickness	
Nominal Inside Diameter mm (in.)	Inside Diameter Tolerance mm (in.)	Nominal Thickness mm (in.)	Thickness Tolerance mm (in.)
0 to 0.25 (0.000 to 0.010)	±0.03 (0.001)	0 to 0.13 (0.000 to 0.005)	±0.025 (0.001)
0.28 to 0.51 (0.011 to 0.020)	±0.05 (0.002)	0.15 to 0.31 (0.006 to 0.012)	±0.051 (0.002)
0.53 to 0.76 (0.021 to 0.030)	±0.08 (0.003)	0.33 to 0.48 (0.013 to 0.019)	±0.076 (0.003)
0.79 to 2.54 (0.031 to 0.100)	±0.10 (0.004)	0.51 to 0.74 (0.020 to 0.029)	±0.102 (0.004)
2.57 to 4.32 (0.101 to 0.170)	±0.13 (0.005)	0.76 and > (0.030 and >)	±0.127 (0.005)
4.34 to 6.35 (0.171 to 0.250)	±0.15 (0.006)		
6.38 to 19.05 (0.251 to 0.750)	±0.18 (0.007)		
19.08 to 25.38 (0.751 to 0.999)	±0.25 (0.010)		
25.4 and (1.000 and >)	±0.38 (0.015)		