

RATIONALE

THIS DOCUMENT IS A NEW DETAIL SHEET DESCRIBING THE REQUIREMENTS FOR EXTRA FLEXIBLE CONVOLUTED TUBING PROCESSED USING PFA MATERIAL.

NOTICE

THE REQUIREMENTS FOR ACQUIRING THE TUBING DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE IN EFFECT OF SAE AS81914.

SAE AS81914/10

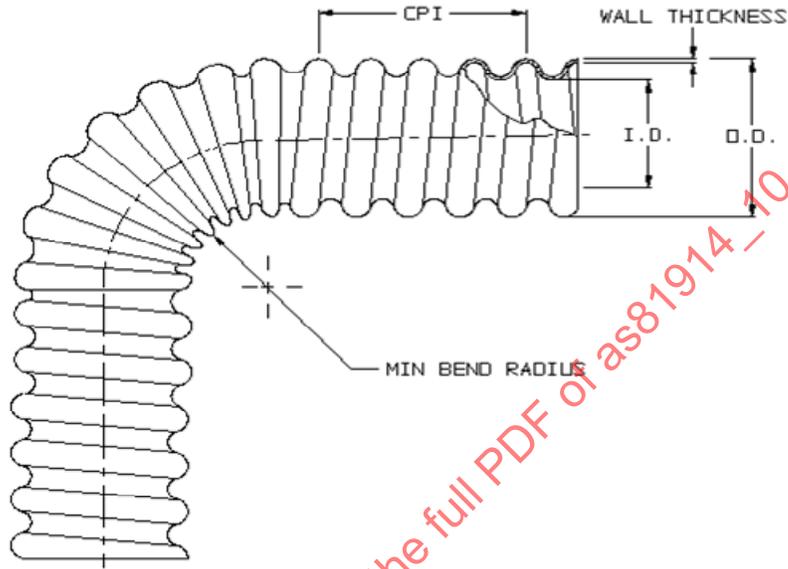
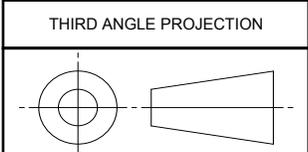


FIGURE 1 – DIMENSIONS AND CONFIGURATION

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**AEROSPACE STANDARD**

TUBING, PLASTIC, EXTRA FLEXIBLE, CONVOLUTED, HELICAL, PERFLUOROALKOXY (PFA), CLOSE CONVOLUTION

**SAE AS81914/10**  
SHEET 1 OF 4

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TABLE 1 - FIGURE 1 DIMENSIONS

DASH NUMBER	MAX INSIDE DIA. (I.D.)	MIN INSIDE DIA. (I.D.)	MAX OUTER DIA. (O.D.)	MAX WALL THICKNESS	CONVOLUTIONS PER INCH (CPI) ± 1	APPROX. WEIGHT LBS (KG) PER 100 FEET (30.5 M) REF.	MIN BEND RADIUS
01	.188 (4.78)	.181 (4.60)	.320 (8.13)	.018 (0.46)	10	1.7 (0.77)	.31 (7.9)
02	.281 (7.14)	.273 (6.93)	.414 (10.52)	.018 (0.46)	10	2.0 (0.91)	.41 (10.4)
03	.312 (7.92)	.306 (7.77)	.450 (11.43)	.018 (0.46)	10	2.1 (0.95)	.41 (10.4)
04	.375 (9.53)	.359 (9.12)	.510 (12.95)	.018 (0.46)	10	2.5 (1.13)	.50 (12.7)
05	.437 (11.10)	.427 (10.85)	.571 (14.50)	.018 (0.46)	10	3.9 (1.77)	.50 (12.7)
06	.500 (12.70)	.480 (12.19)	.650 (16.51)	.023 (0.58)	9	4.6 (2.09)	.75 (19.1)
07	.625 (15.88)	.603 (15.32)	.770 (19.56)	.023 (0.58)	9	5.5 (2.49)	.75 (19.1)
08	.750 (19.05)	.725 (18.42)	.930 (23.62)	.023 (0.58)	8	6.9 (3.13)	.93 (23.6)
09	.875 (22.23)	.860 (21.84)	1.073 (27.25)	.023 (0.58)	7	8.9 (4.04)	1.25 (31.8)
10	1.000 (25.40)	.970 (24.64)	1.226 (31.14)	.023 (0.58)	7	9.5 (4.31)	1.25 (31.8)
11	1.125 (28.58)	1.105 (28.07)	1.390 (35.31)	.023 (0.58)	7	10.5 (4.76)	1.43 (36.3)
12	1.250 (31.75)	1.205 (30.61)	1.539 (39.10)	.023 (0.58)	6.5	11.2 (5.08)	1.43 (36.3)
13	1.500 (38.10)	1.437 (36.50)	1.832 (46.53)	.023 (0.58)	5.5	12.0 (5.44)	1.75 (44.5)
14	1.750 (44.45)	1.688 (42.88)	2.082 (52.88)	.023 (0.58)	5.5	13.5 (6.12)	2.00 (50.8)
15	2.000 (50.80)	1.937 (49.20)	2.332 (59.23)	.023 (0.58)	5.5	15.5 (7.03)	2.25 (57.2)

## NOTES:

- DIMENSIONS ARE IN INCHES.
- UNLESS OTHERWISE SPECIFIED TOLERANCES SHALL BE: .XX = ± .010 (0.25 MM), .XXX = ± .005 (0.13 MM).
- METRIC EQUIVALENTS ARE GIVEN FOR GENERAL INFORMATION ONLY AND ARE BASED ON 25.4 MM = 1 INCH.
- METRIC DIMENSIONS IN PARENTHESES ARE SHOWN IN MILLIMETERS.

## REQUIREMENTS:

- DIMENSIONS AND CONFIGURATION: SEE FIGURE 1 AND TABLE 1.
- CONVOLUTION TYPE: HELICAL.
- LENGTHS SHALL BE SPECIFIED IN FEET BY THE PROCURING ACTIVITY AND DOES NOT FORM A PART OF THE IDENTIFYING PART NUMBER. MINIMUM ORDER LENGTH SHALL BE 3 FEET (0.914 M) AND THE TUBING ORDER LENGTH TOLERANCES SHALL BE AS SPECIFIED IN TABLE 2. TUBING SHALL BE PROCURED AS COILS.

 An SAE International Group	<b>AEROSPACE STANDARD</b>	<b>SAE AS81914/10</b> SHEET 2 OF 4
	TUBING, PLASTIC, EXTRA FLEXIBLE, CONVOLUTED, HELICAL, PERFLUOROALKOXY (PFA), CLOSE CONVOLUTION	

TABLE 2 - ORDER LENGTH TOLERANCES

ORDER LENGTH RANGE	
LENGTH IN FEET (METERS)	TOLERANCE IN INCHES (MM)
3 – 12 (0.914 M – 3.66 M)	+ 2.0 / - 0.0 (+ 50.8 MM / - 0.0 MM)
13 – 50 (3.96 M – 15.24 M)	+ 4.0 / - 0.0 (+ 101.6 MM / - 0.0 MM)
51 AND UP (15.55 M AND UP)	+ 6.0 / - 0.0 (+ 152.4 MM / - 0.0 MM)

4. CONTINUOUS OPERATING TEMPERATURE: -71 °C (-95 °F) TO 260 °C (+ 500 °F)
5. COLOR: UNLESS OTHERWISE SPECIFIED, THE SUPPLIED COLOR SHALL BE BLACK.
6. PHYSICAL PROPERTIES: GENERAL PHYSICAL REQUIREMENT VALUES ALONG WITH ASSOCIATED TEST CONDITIONS ARE LOCATED IN TABLE 3.
7. SHELF LIFE: THE STORAGE/SHELF LIFE SHALL BE UNLIMITED. SEE SAE AS81914.

TABLE 2 – PHYSICAL REQUIREMENTS

PROPERTY	REQUIREMENT
CONSTRUCTION DETAILS	IN ACCORDANCE WITH TABLE 1
STRESS IN PSI @ 10% STRAIN	150 TO 700
SPECIFIC GRAVITY	2.20 MAX
CRUSH RESISTANCE, HORIZONTAL	10 LBS (4.54KG) MIN.
LOW TEMPERATURE FLEXIBILITY	10 000 CYCLES, NO CRACKING
HEAT SHOCK	234/230°C (454/446°F) FOR 4 HOURS. 15% MAX LONGITUDINAL CHANGE. NO DRIPPING, FLOWING OR CRACKING
HEAT AGING	STRESS IN PSI @10% STRAIN, 80% OF INITIAL VALUE. 234/230 °C ( 454/446 °F) FOR 96 HOURS.
FLUID RESISTANCE	STRESS IN PSI @ 10% STRAIN 80% OF INITIAL VALUE
FLAMMABILITY	NON-FLAMMABLE <sup>1/</sup>
FUNGUS RESISTANCE	NON-NUTRIENT <sup>1/</sup>
DIELECTRIC BREAKDOWN	12 000 VOLTS, NO BREAKDOWN

<sup>1/</sup> PROPERTIES NOT TESTED FOR.