MIL Sleeving (2:1) – Technical Data Sheet

Product Data

Storage:

Cool dry place out of direct sunlight
Recommended temp +10°C to 25°C

Recommended Printer & Ribbon:

Sumitag Printer:

300 DPI Printer	STP-XD4T-300-S-NC-S STP-SQX-300M-S-NC-510	
Ribbon	2020 series 173 Series	Black White

See Ribbon TDS for Print performance

Material:

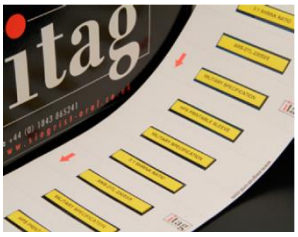
Flexible Polyolefin

Operating Temperature:

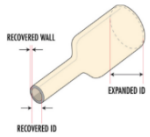
-55°C to +135°C

Application Method – Shrink on

HP (High Performance) sleeving (Also known as Mil Spec) is Very flexible, high temperature rated, highly flame retardant, heat shrinkable tubing (2:1 shrink ratio). Flexible polyolefin sleeves used for wire identification and insulation purposes. Markers are supplied roll form in a flattened format on a carrier designed for use with both dot matrix and transfer thermal printers. Can also be supplied on spools for continuous printing applications.



- Flame Retardant
- Self-Extinguishing
- Print onto Paper liner for QA
- Print Performance to Military requirements (See ribbon TDS)
- Available in 12 colours
- 12.5, 25 & 50mm Sleeve lengths



2:1 Sleeves:

Minimum ID Supplied (mm)	Maximum ID Recovered (mm)	Wall Thickness Recovered (Nom.)	Minimum Markers/Box	Order Code
2.4mm	1.2mm	0.41	1000	MIL-024-500-**-S-2X_V2
3.2mm	1.6mm	0.27	1000	MIL-032-500-**-S-2X_V2
4.8mm	2.4mm	0.27	1000	MIL-048-500-**-S-2X_V2
6.4mm	3.2mm	0.33	1000	MIL-064-500-**-S-2X_V2
9.5mm	4.8mm	0.33	500	MIL-095-500-**-S-2X_V2
12.7mm	6.4mm	0.33	500	MIL-127-500-**-S-2X_V2
19.1mm	9.5mm	0.43	500	MIL-191-500-**-S-2X_V2
25.4mm	12.7mm	0.48	300	MIL-254-500-**-S-2X_V2
38.1mm	19.1mm	0.50	100	MIL-381-500-**-S-2X_V2
50.8mm	25.4mm	0.50	100	MIL-508-500-**-S-2X_V2

2:1 Continuous Sleeving:

Minimum ID Supplied (mm)	Maximum ID Recovered (mm)	Wall Thickness Recovered (Nom.)	Minimum Spool length (M)	Order Code
2.4mm	1.2mm	0.41	30	MIL-024-30M-**-2X
3.2mm	1.6mm	0.27	30	MIL-032-30M-**-2X
4.8mm	2.4mm	0.27	30	MIL-048-30M-**-2X
6.4mm	3.2mm	0.33	30	MIL-064-30M-**-2X
9.5mm	4.8mm	0.33	30	MIL-095-30M-**-2X
12.7mm	6.4mm	0.33	30	MIL-127-30M-**-2X
19.1mm	9.5mm	0.43	30	MIL-191-30M-**-2X
25.4mm	12.7mm	0.48	20	MIL-254-20M-**-2X
38.1mm	19.1mm	0.50	20	MIL-381-20M-**-2X
50.8mm	25.4mm	0.50	15	MIL-508-15M-**-2X

** = See colour codes below

Colour Codes		Colour Codes	
BK	Black	BE	Blue
BN	Brown	VT	Violet
RD	Red	GY	Grey
OR	Orange	WE	White
YW	Yellow	PK	Pink
GN	Green		

Please contact us for any sizes not listed……..

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Product Properties

Property	Result	Test Method
Operating Temperature	-55 up to 135°C	SAE-AS23053
Flammability (30 SECONDS-60 DEGREE) Max burn length 3 inches Max Drip Exiting 3 Seconds	 1.4 Inches Average No drips	 FAR 25.853, App F, part 1. A.3
Longitudinal Change	0% - -2%	SAE-AS23053
Specific Gravity	1,34	ASTM D 792
Tensile Strength	≥ 14 MPa	ASTM D 638
Elongation at Break	≥ 400%	ASTM D 638
Secant Modulus	65 MPa	ASTM D 882
Min. Shrink Temperature	90°C	Shrink curve
Shrinking starts at	60°C	Shrink curve
Heat Shock (250°C x 4h)	Pass	SAE-AS23053
Elongation after heat ageing (175°C x 168h)	420%	SAE-AS23053
Low temperature flexibility (-55°C x 4h)	Pass	SAE-AS23053
Copper Corrosion (175°C x 16h)	Pass	SAE-AS23053
Colour stability (175°C x 24h)	Pass	SAE-AS23053
Flammability*	Pass	UL 224
Water Absorption	0,25%	ASTM D 570
Fluid Resistance (after immersion 24°C x 24h)	7,25 - 14 MPa	SAE-AS23053
Fungus Resistance	Pass	SAE-AS23053
Ozone resistance	Pass	NF F 00-608
Voltage Rating*	600V	UL 224
Dielectric Voltage Withstand (2.5kV x 60s)*	Pass	UL 224
Volume Resistivity	3,1 x 10^{14} Ω·cm	ASTM D 876
Dielectric Strength	≥ 30 kV/mm	ASTM D 876
UV Resistance Printed ink HPS 2X Sleeving	 No bleaching Slight Darkening	BS EN ISO 4892-3:2016

*Results Derived from UL registered product.

Business Management Accreditations

AS/EN 9100 Aviation Space and Defence CERTIFIED | EN 9120 Aviation Space and Defence CERTIFIED | ISO 14001 Environmental Management CERTIFIED | ISO 45001 Occupational Health and Safety Management CERTIFIED

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