

Convolute Rolled Tube Products – Phenolic Resins, Paper Substrates

Phenolic Resins – Paper Substrates				
Grade	RT610	RT628	RT629	RT630
Resin System	Phenolic			
NEMA ¹	X	XX		XXX
Color	NA/BK	NA	NA/BK	NA/BK

Inside Diameter		Wall Thickness ^{A,B,C}		Outside Diameter	Maximum
Minimum	Minimum	Minimum	Maximum	Maximum	Length ^D
0.094 ^F	0.187	0.031	0.203	0.500	18
0.188 ^F	0.374	0.031	0.250	0.750	36
0.375	0.624	0.031	1.000	2.625	48 ^E
0.625	1.249	0.031	1.000	3.250	48
1.250	2.999	0.031	1.000	5.000	48
3.000	4.874	0.047	1.000	6.875	48
4.875	8.999	0.062	1.000	11.000	48
9.000	23.999	0.094	1.000	26.000	48
24.000 ^F	29.999	0.125	1.000	32.000	48
30.000	48.000	0.156	1.000	50.000	48

I. Special Size Exceptions – (For tables above)		
A.	Walls less than 0.031" must be cleared by Department Manager for capability and cost.	
B.	Walls greater than 1.0" for paper, glass and some special cotton based materials, must be cleared by Department Manager.	
C.	Specifying Inside Diameter and Wall Thickness is not offered in any grade where lathe turning is required and the Outside Diameter exceeds 9.000".	
D.	<p>Supplied at:</p> <p>Random Length = No lengths less than 12" on a 18", 18" on a 24", 30" on a 36" or 42" on a 48" standard length.</p> <p>Non-Trimmed is considered a random length but not trimmed to allow for maximum customer yield.</p> <p>Minimum Length is considered the specified length with plus or minus 1.000" allowance</p> <p>Cut-To-Length is: (Tube must be a finished OD)</p> <p>6" - 48" cut length with maximum Outside Diameter of 0.250" - 5.000"; Tolerance of ± 0.125" (May cut all – 0.250" or all + 0.250")</p> <p>12" - 48" cut length with maximum Outside Diameter of 5.001" - 18.000"; Tolerance of ± 0.250" (May cut all – 0.500" or all + 0.500")</p> <p>18" - 48" cut length with maximum Outside Diameter of 18.001" - 24.000"; Tolerance of ± 0.250" (May cut all – 0.500" or all + 0.500")</p> <p>All grades of micro ID tubing (less than 0.187" ID) are offered as random length only.</p> <p>Maximum Outside Diameter is 36.000" for trimmed length.</p>	
E.	<p>IDs less than 0.375" are restricted to 36" maximum length.</p> <p>RTB320X (Maximum Length of 24" for IDs less than 0.375")</p>	
F.	<p>Additional Restrictions and Restricted Grades:</p> <p>Maximum OD of 0.625" with IDs less than 0.250".</p> <p>RT628 (Maximum ID 24.000")</p>	

II. Outside Diameter – Available Finishes		
Outside Diameter		
Minimum	Maximum	Finish^a
0.250	9.000	Centerless Ground (Standard)
9.001	24.000	As Wound (for Lathe Turned, contact Customer Service)
24.001	Maximum	As Wound (No Finishing Available)
^a Special Finish Requirements must be cleared by Department Manager and noted on manufacturing order.		

NOTE: Contact Customer Service for sizes and tolerances not listed. Micro ID Tubing (IDs less than 0.187") is offered in RT629 and RT630. Industrial Standards related to tolerance, finish and workmanship is assumed, unless otherwise specified. Walls over .500" are subject to check marks and/or cracks in the wall. Oil stabilized post cure (secondary cure), identified as grades with an "S" suffix, is available with any phenolic resin grades (Maximum raw OD 24.000"). Forced air post cure (secondary cure), identified as grades with an "H" suffix, is available with any resin grade excluding Melamine.

¹ For information on Specifications and Standards, see "Tube – Specification Cross Reference".