



SURFACE VEHICLE STANDARD	J1958™	NOV2015
	Issued 1989-04 Reaffirmed 2002-10 Cancelled 2015-11	
Superseded by ISO 8535-1		
Diesel Engines - Steel Tubes for High-Pressure Fuel Injection Pipes (Tubing)		

RATIONALE

SAE J1958 has been cancelled because the content of this standard is fully covered by ISO 8535-1. Therefore, to eliminate such redundancy and confusion in coordinating the standards between ISO and SAE, this document is declared cancelled and superseded by ISO 8535-1.

CANCELLATION NOTICE

This Technical Report has been declared "CANCELLED" as of September 2015 and has been superseded by ISO 8535-1. By the action, this document will remain listed in the respective index, if applicable. Cancelled Technical Reports are available from SAE.

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1. **Scope**—This SAE Standard specifies dimensions and requirements for single-wall steel tubing intended for use as high-pressure fuel injection pipes on a wide range of engines (Class A), and for fuel injection pump testing (Class B, Reference SAE J1418). Tubing shall be cold drawn, annealed or normalized, seamless tubing suitable for cold swaging, cold upsetting, and cold bending.
2. **References**
 - 2.1 **Applicable Publications**—The following publications form a part of the specification to the extent specified herein. Unless otherwise indicated, the latest revision of SAE publications shall apply.
 - 2.1.1 SAE PUBLICATION—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.
SAE J1418—Fuel Injection Pumps—High Pressure Pipes (Tubing) for Testing
 - 2.1.2 ASTM PUBLICATION—Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.
ASTM A 370—Test Methods and Definitions for Mechanical Testing of Steel Products
3. **Dimensions and Tolerances**
 - 3.1 **Sizes**—The recommended outside diameter and inside diameter tubing sizes are shown on Figure 1. Other sizes may be available by agreement.

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3.2 Tolerances

3.2.1 INSIDE DIAMETER¹—Standard

$$\frac{\text{mm}}{\pm 0.06}$$

3.2.2 OUTSIDE DIAMETER—Standard

$$\frac{\text{mm}}{\pm 0.06}$$

3.2.3 DEGREE OF ECCENTRICITY—The degree of eccentricity of the outside diameter of the tube relative to the inside diameter is proportioned to the wall thickness as shown in Figure 2.

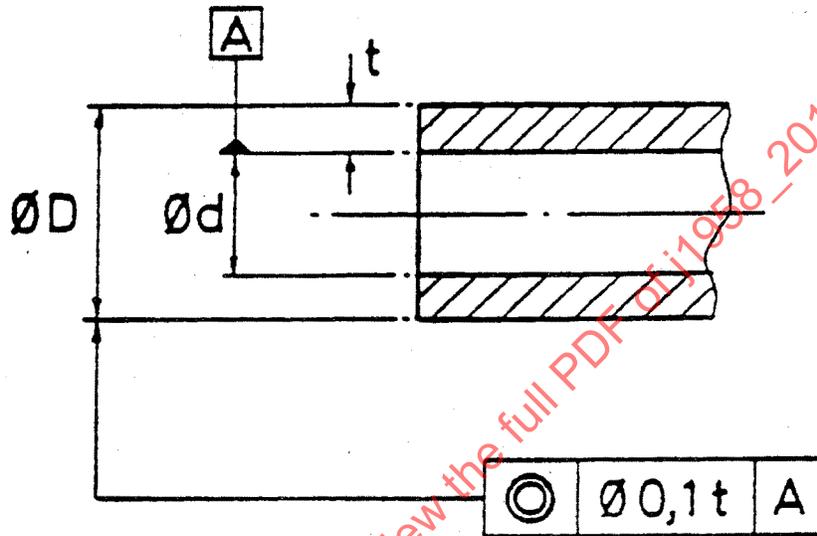


FIGURE 2—DEGREE OF WALL THICKNESS

3.2.4 LENGTH—Length and tolerance on length shall be by agreement between purchaser and supplier.

3.3 **Straightness**—Unless otherwise specified, the tubes shall be straight within a maximum error of 1 in 400 without any localized deformation.

4. Material Processing

4.1 **Material**—Tubing shall be manufactured from an unalloyed or low alloy steel produced by a steelmaking process providing a very homogeneous structure. Upon request, the supplier shall state the method of the steel making and deoxydation process used.

4.2 **Manufacturing of Tubes**—The tubing shall be cold drawn from steel hollows processed in a manner that allows the manufacturer to obtain tubes in conformance with agreed upon portions of this document. After forming, the tubing, if annealed, shall be processed in such a manner as to prevent formation of scale on the inside surface and produce a finished product which will meet all agreed to requirements of this document.

4.3 **Mechanical Properties**—The furnished tubing shall have mechanical properties² as tabulated in Table 1.

1. Refer to SAE J1418 for Class B.

2. Per ASTM A 370, Supplement II, Section T-2.

TABLE 1—MECHANICAL PROPERTIES

	Yield Strength Min	Tensile Strength	Elongation in 2 in (51 mm) % Min	Hardness Rockwell B Scale Max
Grade One	205 N/mm ² (29 730 psi)	310–379 N/mm ² (44 960 – 54 965 psi)	30	65
Grade Two	220 N/mm ² (31 905 psi)	360–480 N/mm ² (52 210–69 615 psi)	23	80
Grade Three	355 N/mm ² (51 485 psi)	490–630 N/mm ² (71 065–91 370 psi)	22	87

4.4 Surface Quality

4.4.1 **GENERAL**—The outside and inside surfaces of finished tubing shall be clean and free from scale, rust, seams, laps, laminations, deep pits, nonmetallics, or other injurious defects.

4.4.2 OD SURFACE

4.4.2.1 **Condition**—The outside surface of annealed or normalized tubes may have a slight discoloration, but shall be free from loose scale and represent a smooth cold-finished surface. Imperfections in any tube, heat treated or not, deeper than 0.13 mm will be a cause for rejection. Scratches resulting from a mechanical finishing process such as polishing or grinding are prohibited.

4.4.2.2 **Coatings**—The outside surface of the tubes may be coated utilizing a product and method agreed upon by purchaser and manufacturer. The inside surface of the tube shall remain uncoated.

4.4.3 **ID SURFACE**—The inside of tubing shall be clean and free from any contaminations which will impair the processing or serviceability of the tubing and shall be finished to ensure a smooth bore of accurate size and shall conform to one of the following bore designations described in Table 2.

Bore designation, as described in Table 2, shall be specified on the face of the order.

TABLE 2—BORE DESIGNATION

Bore Designation	Permitted Imperfections	Magnification
A	5 imperfections (max) between 0.08 to 0.13 mm deep in any cross section and no imperfections deeper than 0.13 mm	100 X
B	5 imperfections (max) over 0.05 mm to 0.08 mm maximum deep	200 X
C	5 imperfections (max) over 0.02 to 0.05 mm maximum deep	200 X
D	All imperfections less than 0.03 mm deep. As an alternate, an imperfection can be classified as having a depth that is at least twice the width.	200 X

4.4.3.1 **ID Bore Optional Requirement**—Inclusions occurring within 10% of the wall thickness as measured from the ID surface is to be considered as continuous to the ID.

De-carb (C.F.D. = Carbon Free Depth) of 0.050 mm maximum on the OD and 0.020 mm maximum on the ID C.F.D. shall be determined at 200 X.