

INTERNATIONAL STANDARD



**Winding wires – Test methods –
Part 1: General**

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IEC 60851-1

Edition 3.1 2025-01
CONSOLIDATED VERSION

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INTERNATIONAL
ELECTROTECHNICAL
COMMISSION

ICS 29.060.10

ISBN 978-2-8327-0128-7

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CONTENTS

FOREWORD.....	3
INTRODUCTION.....	5
1 Scope.....	6
2 Normative references	6
3 Terms, definitions and general notes on methods of test	6
3.1 Terms and definitions.....	6
3.2 General notes on methods of test	8
Annex A (informative) Contents of IEC 60851-2 to IEC 60851-6 with indication of tests
 A.1 General.....
 A.2 IEC 60851-2
 A.3 IEC 60851-3
 A.4 IEC 60851-4
 A.5 IEC 60851-5
 A.6 IEC 60851-6
Bibliography.....	15

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

WINDING WIRES – TEST METHODS –

Part 1: General

FOREWORD

- 1) The International Electrotechnical Commission (IEC) is a worldwide organization for standardization comprising all national electrotechnical committees (IEC National Committees). The object of IEC is to promote international co-operation on all questions concerning standardization in the electrical and electronic fields. To this end and in addition to other activities, IEC publishes International Standards, Technical Specifications, Technical Reports, Publicly Available Specifications (PAS) and Guides (hereafter referred to as “IEC Publication(s)”). Their preparation is entrusted to technical committees; any IEC National Committee interested in the subject dealt with may participate in this preparatory work. International, governmental and non-governmental organizations liaising with the IEC also participate in this preparation. IEC collaborates closely with the International Organization for Standardization (ISO) in accordance with conditions determined by agreement between the two organizations.
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This consolidated version of the official IEC Standard and its amendment has been prepared for user convenience.

IEC 60851-1 edition 3.1 contains the third edition (2021-06) [documents 55/1913/FDIS and 55/1916/RVD] and its amendment 1 (2025-01) [documents 55/2057/FDIS and 55/2059/RVD].

In this Redline version, a vertical line in the margin shows where the technical content is modified by amendment 1. Additions are in green text, deletions are in strikethrough red text. A separate Final version with all changes accepted is available in this publication.

IEC 60851-1 has been prepared by IEC technical committee 55: Winding wires. It is an International Standard.

This third edition cancels and replaces the second edition published in 1996, and its amendment 1:2003 and amendment 2:2009. This edition constitutes a technical revision.

This edition includes the following significant technical changes with respect to the previous edition:

- a) revision to Clause 2 to update the list of normative references;
- b) revision to 3.2 atmospheric conditions for testing;
- c) addition to 3.2 with remarks concerning frequency and management of tests;
- ~~d) revision to Annex A to update the contents list of IEC 60851 series of tests.~~

The language used for the development of this International Standard is English.

This document was drafted in accordance with ISO/IEC Directives, Part 2, and developed in accordance with ISO/IEC Directives, Part 1 and ISO/IEC Directives, IEC Supplement, available at www.iec.ch/members_experts/refdocs. The main document types developed by IEC are described in greater detail at www.iec.ch/standardsdev/publications.

~~Annex A is for information only.~~

A list of all parts in the IEC 60851 series, published under the general title *Winding wires – Test methods*, can be found on the IEC website.

The committee has decided that the contents of this document and its amendment will remain unchanged until the stability date indicated on the IEC website under webstore.iec.ch in the data related to the specific document. At this date, the document will be

- reconfirmed,
- ~~withdrawn,~~ or
- revised.

IMPORTANT – The 'colour inside' logo on the cover page of this publication indicates that it contains colours which are considered to be useful for the correct understanding of its contents. Users should therefore print this document using a colour printer.

INTRODUCTION

This Part of IEC 60851 forms an element of a series of standards which deals with insulated wires used for windings in electrical equipment. It is composed of the following series:

- 1) *Winding wires – Test methods* (IEC 60851 series);
- 2) *Specifications for particular types of winding wires* (IEC 60317 series);
- 3) *Packaging of winding wires* (IEC 60264 series).

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WINDING WIRES – TEST METHODS –

Part 1: General

1 Scope

This part of IEC 60851 specifies the general notes on methods of test for winding wires. It also gives the definitions for terms used in IEC 60851 (all parts). ~~A survey of the contents of IEC 60851-2 to IEC 60851-6 is given in Annex A.~~

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60317 (all parts), *Specifications for particular types of winding wires*

IEC 60851-2:2009¹, *Winding wires – Test methods – Part 2: Determination of dimensions*
IEC 60851-2:2009/AMD1:2015
IEC 60851-2:2009/AMD2:2019

IEC 60851-3:2009², *Winding wires – Test methods – Part 3: Mechanical properties*
IEC 60851-3:2009/AMD1:2013
IEC 60851-3:2009/AMD2:2019

IEC 60851-4:2016, *Winding wires – Test methods – Part 4: Chemical properties*

IEC 60851-5:2008³, *Winding wires – Test methods – Part 5: Electrical properties*
IEC 60851-5:2008/AMD1:2011
IEC 60851-5:2008/AMD2:2019

IEC 60851-6:2012, *Winding wires – Test methods – Part 6: Thermal properties*

3 Terms, definitions and general notes on methods of test

3.1 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

¹ A consolidated version of IEC 60851-2:2009 and its amendments exists.

² A consolidated version of IEC 60851-3:2009 and its amendments exists.

³ A consolidated version of IEC 60851-5:2008 and its amendments exists.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

**3.1.1
bonding layer**

material which is deposited on an enamelled wire and which has the specific function of bonding wires together

**3.1.2
bunched wire**

winding wire consisting of a quantity of small diameter insulated wires laid-up together without predetermined geometrical position and with or without additional covering

**3.1.3
class**

thermal performance of a wire expressed by the temperature index and the heat shock temperature

**3.1.4
coating**

material which is deposited on a conductor or wire by suitable means and then dried and/or cured

**3.1.5
conductor**

bare metal after removal of the insulation

**3.1.6
covering**

material which is wound, wrapped or braided around a bare or insulated conductor

**3.1.7
crack**

opening in the insulation which exposes the conductor to view at the stated magnification

**3.1.8
cure**

process of converting a reactive compound into a stable, usable condition by polymerization (polycondensation and polyaddition) and/or crosslinking

[SOURCE: IEC 60050-212:2010, 212-13-07, modified – At the beginning of the definition, "convert a reactive compound" has been replaced by "process of converting a reactive compound" to define the term as a process.]

**3.1.9
dual coating**

insulation composed of two different materials, an underlying and a superimposed coating

**3.1.10
enamelled wire**

wire coated with an insulation of cured resin

**3.1.11
grade**

range of increase in dimension of the wire due to insulation

3.1.12**insulation**

coating or covering of the conductor with the specific function of withstanding voltage

3.1.13**nominal conductor dimension**

designation of the conductor size in accordance with the specification sheet in the IEC 60317 series

3.1.14**sole coating**

insulation composed of one material

3.1.15**winding wire**

wire used for winding a coil to provide a magnetic field

3.1.16**wire**

conductor coated or covered with an insulation

3.1.17**normal vision**

20/20 vision, with corrective lenses, if necessary

3.1.18**zero-defect wire**

winding wire that exhibits no electrical discontinuities when tested under specific conditions

3.2 General notes on methods of test

Unless otherwise specified, all tests shall be carried out at a temperature from 15 °C to 40 °C and a relative humidity of 25 % to 75 %. Before measurements are made, the specimens shall be preconditioned under these atmospheric conditions for a time sufficient to allow the wire to reach stability.

The wire to be tested shall be removed from the packaging in such a way that the wire will not be subjected to tension or to unnecessary bends. Before each test, sufficient wire shall be discarded to ensure that any damaged wire is not included in the test specimens.

Normally, all mandatory requirements for a method of test are given in the description, and diagrams are intended only to illustrate one possible arrangement for conducting the test.

In case of inconsistencies between the IEC 60317 specification sheet and this document, the specification sheet shall prevail.

When the test is restricted only to certain types of winding wires, this is specified with the test.

Those tests of IEC 60851-2, IEC 60851-3, IEC 60851-4, IEC 60851-5 and IEC 60851-6 ~~which in Annex A are marked with an asterisk~~ are periodic conformance tests. These tests are carried out at a frequency agreed upon request of the end user.

The test numbers used in IEC 60851-2, IEC 60851-3, IEC 60851-4, IEC 60851-5 and IEC 60851-6 correspond with the clause numbers in the IEC 60317 series.