

# INTERNATIONAL STANDARD

## NORME INTERNATIONALE

Specifications for particular types of winding wires –  
Part 23: Solderable polyesterimide enamelled round copper wire, class 180  
(standards.iteh.ai)

Spécifications pour types particuliers de fils de bobinage –  
Partie 23: Fil brasable de section circulaire en cuivre émaillé avec  
polyesterimide, classe 180  
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## INTERNATIONAL ELECTROTECHNICAL COMMISSION

## SPECIFICATIONS FOR PARTICULAR TYPES OF WINDING WIRES –

**Part 23: Solderable polyesterimide enamelled  
round copper wire, class 180**

## FOREWORD

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International Standard IEC 60317-23 has been prepared by IEC technical committee 55: Winding wires.

This third edition cancels and replaces the second edition published in 1990, Amendment 1:1997 and Amendment 2:1999. This edition constitutes a technical revision.

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

- new 3.2.2 containing general notes on winding wire, formerly a part of the scope;
- revision to references to IEC 60317-0-1:2013 to clarify that their application is normative;
- consolidation of 17.1 and 17.2 of the solderability requirements;
- modification to Clause 19, Dielectric dissipation factor;
- new Clause 23, Pin hole test.

The text of this standard is based on the following documents:

|              |                  |
|--------------|------------------|
| FDIS         | Report on voting |
| 55/1413/FDIS | 55/1434/RVD      |

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.

A list of all parts in the IEC 60317 series, published under the general title *Specifications for particular types of winding wires*, can be found on the IEC website.

The numbering of clauses in this standard is not continuous from Clauses 20 and 30 in order to reserve space for possible future wire requirements prior to those for wire packaging.

The committee has decided that the contents of this publication will remain unchanged until the stability date indicated on the IEC web site under "http://webstore.iec.ch" in the data related to the specific publication. At this date, the publication will be

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- withdrawn,
- replaced by a revised edition, or
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## INTRODUCTION

This part of IEC 60317 is one of a series of standards which deals with insulated wires used for windings in electrical equipment. The series has three groups describing:

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

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## SPECIFICATIONS FOR PARTICULAR TYPES OF WINDING WIRES –

### Part 23: Solderable polyesterimide enamelled round copper wire, class 180

#### 1 Scope

This part of IEC 60317 specifies the requirements of solderable enamelled round copper winding wire of class 180 with a sole coating based on polyesterimide resin, which may be modified providing it retains the chemical identity of the original resin and meets all specified wire requirements.

NOTE A modified resin is a resin that has undergone a chemical change, or contains one or more additives to enhance certain performance or application characteristics.

The range of nominal conductor diameters covered by this standard is:

- Grade 1: 0,020 mm up to and including 1,600 mm;
- Grade 2: 0,020 mm up to and including 1,600 mm.

The nominal conductor diameters are specified in Clause 4 of IEC 60317-0-1:2013.

#### 2 Normative references (standards.iteh.ai)

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60317-0-1:2013, *Specifications for particular types of winding wires – Part 0-1: General requirements – Enamelled round copper wire*

#### 3 Terms, definitions, general notes and appearance

##### 3.1 Terms and definitions

Subclause 3.1 of IEC 60317-0-1:2013 applies.

##### 3.2 General notes

###### 3.2.1 Methods of test

Subclause 3.2.1 of IEC 60317-0-1:2013 applies. In case of inconsistencies between IEC 60317-0-1:2013 and this part of IEC 60317, the latter shall prevail.

###### 3.2.2 Winding wire

Class 180 is a thermal class that requires a minimum temperature index of 180 and a heat shock temperature of at least 200 °C.

The temperature in degrees Celsius corresponding to the temperature index is not necessarily that at which it is recommended that the wire be operated and this will depend on many factors, including the type of equipment involved.



### 3.3 Appearance

Subclause 3.3 of IEC 60317-0-1:2008 applies.

### 4 Dimensions

Clause 4 of IEC 60317-0-1:2008 applies.

### 5 Electrical resistance

Clause 5 of IEC 60317-0-1:2008 applies.

### 6 Elongation

Clause 6 of IEC 60317-0-1:2008 applies.

### 7 Springiness

Clause 7 of IEC 60317-0-1:2008 applies.

### 8 Flexibility and adherence

Clause 8 of IEC 60317-0-1:2008 applies. For 8.4, the constant  $K$  used for the calculation of the number of revolutions for the peel test shall be 110 mm.

[IEC 60317-23:2013](https://standards.iteh.ai/catalog/standards/sist/3adf87cc-3f7c-4955-874f-f6bab70cdb1d/iec-60317-23-2013)

### 9 Heat shock

<https://standards.iteh.ai/catalog/standards/sist/3adf87cc-3f7c-4955-874f-f6bab70cdb1d/iec-60317-23-2013>

Clause 9 of IEC 60317-0-1:2008 applies. The minimum heat shock temperature shall be 200 °C.

### 10 Cut-through

No failure shall occur within 2 min at 265 °C.

### 11 Resistance to abrasion (nominal conductor diameters from 0,250 mm up to and including 1,600 mm)

The wire shall meet the requirements given in Table 1.

For intermediate nominal conductor diameters, the value of the next larger nominal conductor diameter shall be taken.

**Table 1 – Resistance to abrasion**

| Nominal conductor diameter<br>mm | Grade 1                               |   | Grade 2                               |   |
|----------------------------------|---------------------------------------|---|---------------------------------------|---|
|                                  | Minimum average force to failure<br>N | Minimum force to failure of each measurement<br>N | Minimum average force to failure<br>N | Minimum force to failure of each measurement<br>N |
| 0,250                            | 2,85                                  | 2,45  | 4,70                                  | 4,00  |
| 0,280                            | 3,10                                  | 2,60  | 5,05                                  | 4,30  |
| 0,315                            | 3,35                                  | 2,80  | 5,45                                  | 4,60  |
| 0,355                            | 3,60                                  | 3,05  | 5,85                                  | 4,95  |
| 0,400                            | 3,85                                  | 3,25  | 6,25                                  | 5,30  |
| 0,450                            | 4,15                                  | 3,50  | 6,75                                  | 5,70  |
| 0,500                            | 4,45                                  | 3,75  | 7,20                                  | 6,10  |
| 0,560                            | 4,75                                  | 4,05  | 7,70                                  | 6,50  |
| 0,630                            | 5,10                                  | 4,35  | 8,25                                  | 7,00  |
| 0,710                            | 5,45                                  | 4,65  | 8,85                                  | 7,50  |
| 0,800                            | 5,85                                  | 4,95  | 9,50                                  | 8,05  |
| 0,900                            | 6,30                                  | 5,35  | 10,2                                  | 8,60  |
| 1,000                            | 6,75                                  | 5,75  | 10,9                                  | 9,20  |
| 1,120                            | 7,35                                  | 6,20  | 11,6                                  | 9,80  |
| 1,250                            | 7,90                                  | 6,70  | 12,5                                  | 10,5  |
| 1,400                            | 8,50                                  | 7,20  | 13,3                                  | 11,3  |
| 1,600                            | 9,20                                  | 7,80  | 14,3                                  | 12,1  |

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**12 Resistance to solvents**

Clause 12 of IEC 60317-0-1:2013 applies.

**13 Breakdown voltage**

Clause 13 of IEC 60317-0-1:2013 applies. The elevated temperature shall be 180 °C.

**14 Continuity of insulation**

Clause 14 of IEC 60317-0-1:2013 applies.

**15 Temperature index**

Clause 15 of IEC 60317-0-1:2013 applies. The minimum temperature index shall be 180.

**16 Resistance to refrigerants**

Test inappropriate.

## 17 Solderability

### 17.1 Nominal conductor diameters up to and including 0,100 mm

The temperature of the solder bath shall be  $(470 \pm 5)$  °C. The maximum immersion time shall be 3 s.

The surface of the tinned wire shall be smooth and free from holes and enamel residues.

### 17.2 Nominal conductor diameters over 0,100 mm

The temperature of the solder bath shall be  $(470 \pm 5)$  °C. The maximum immersion time (in seconds) shall be the following multiple of the nominal conductor diameter (in millimetres) with a minimum of 3 s.

| Grade 1 | Grade 2 |
|---------|---------|
| 8 s/mm  | 12 s/mm |

The surface of the tinned wire shall be smooth and free from holes and enamel residues.

## 18 Heat or solvent bonding

Test inappropriate.

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## 19 Dielectric dissipation factor

Test inappropriate. <https://standards.iteh.ai/catalog/standards/sist/3adf87cc-3f7c-4955-874f-f6bab70cdb1d/iec-60317-23-2013>

## 20 Resistance to transformer oil

Test inappropriate.

## 21 Loss of mass

Test inappropriate.

## 23 Pin hole test

Clause 23 of IEC 60317-0-1:2013 applies.

## 30 Packaging

Clause 30 of IEC 60317-0-1:2013 applies.