



Standard Test Methods for Magnet-Wire Enamels¹

This standard is issued under the fixed designation D 3288/D 3288M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope*

- 1.1 These test methods cover testing liquid enamel coatings used to produce film-insulated magnet wire.
- 1.2 The values stated in either lbs/gal or SI units are to be regarded separately as standard.
- 1.3 The test methods appear as follows:

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1.4 There is no known IEC equivalent document.

1.5 This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

2. Referenced Documents

2.1 ASTM Standards:²

D 29 Test Methods for Sampling and Testing Lac Resins

D 56 Test Method for Flash Point by Tag Closed Cup Tester;

D 476 Specification for Titanium Dioxide Pigments² Classification for Dry Pigmentary Titanium Dioxide Products

D 1298 Practice Test Method for Density, Relative Density (Specific Gravity), or API Gravity of Crude Petroleum and Liquid Petroleum Products by Hydrometer Method

D 1475 Test Method for Density of Paint, Varnish, Lacquer, and Related Products Test Method For Density of Liquid Coatings, Inks, and Related Products

D 1638 Methods of Testing Urethane Foam Isocyanate Raw Materials Methods of Testing Urethane Foam Isocyanate Raw Materials³

D 1711 Terminology Relating to Electrical Insulation

D 5423 Specification for Forced-Convection Laboratory Ovens for Evaluation of Electrical Insulation

E 131 Terminology Relating to Molecular Spectroscopy

E 168 Practices for General Techniques of Infrared Quantitative Analysis

E 691 Practice for Conducting an Interlaboratory Study to Determine the Precision of a Test Method

¹ These test methods are under the jurisdiction of ASTM Committee D09 on Electrical and Electronic Insulating Materials and are the direct responsibility of Subcommittee D09.10 on Magnet Wire Insulation.

Current edition approved Apr. 10, 2003. Published June 2003. Originally approved in 1973. Last previous edition approved in 1997 as D3288-97.

Current edition approved Jan. 1, 2008. Published February 2008. Originally approved in 1973. Last previous edition approved in 2003 as D 3288 – 03.

² Annual Book of ASTM Standards, Vol 06.03.

³ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard.

3. Significance and Use

~~3.1 These tests are useful for specification and control purposes during the manufacture, purchase, and use of the magnet-wire enamels, and for determining uniformity of batches.~~ Terminology

3.1 Definitions:

3.1.1 For definitions of terms used in these test methods, refer to Terminology D 1711.

3.2 Definitions of terms specific to this standard:

3.2.1 For definitions of terms specific to this standard, see the individual test methods.

4. Significance and Use

4.1 These tests are useful for specification and control purposes during the manufacture, purchase, and use of the magnet-wire enamels, and for determining uniformity of batches.

5. Sampling

4.1 Take5.1 Take a representative sample of liquid enamel and store for future testing. Store the sample at room temperature in a tightly sealed, nearly full container, unless otherwise specified. Use a container that is inert and impermeable to the wire enamel. These precautions avoid either the escape of solvent or reaction with the container and atmosphere. Glass and some metals are suitable materials. Copper, iron, and aluminum are unsatisfactory. After removing test specimens, use care to restore these storage conditions.

DENSITY

5. Scope

~~5.1 This test method covers the determination of the density of magnet-wire enamel in terms of specific gravity or weight per gallon.~~

6. Significance and Use

~~6.1 Density is useful for specification and control purposes during the manufacture and use of magnet-wire enamel.~~

~~6.2 The preferred method is Procedure A, hydrometer method.~~ Scope

6.1 This test method covers the determination of the density of magnet-wire enamel in terms of specific gravity or weight per gallon.

7. Procedure A—Hydrometer Method

~~7.1 Determine the specific gravity of the magnet-wire enamel in accordance with Test Method D1298 at $25.0 \pm 0.1^\circ\text{C}$.~~

~~7.2 If weight per gallon is required, multiply the specific gravity by the weight per gallon of distilled water at the same temperature (8.31 lb/gal at 25.0°C).~~

8. Procedure B—Weight per Gallon Method

~~8.1 Determine the weight per gallon of the magnet-wire enamel in accordance with Test Method D1475 at $25.0 \pm 0.1^\circ\text{C}$.~~

9. Significance and Use

7.1 Density is useful for specification and control purposes during the manufacture and use of magnet-wire enamel.

7.2 The preferred method is Procedure A, hydrometer method.

8. Procedure A—Hydrometer Method

8.1 Determine the specific gravity of the magnet-wire enamel in accordance with Test Method D 1298 at $25.0 \pm 0.1^\circ\text{C}$.

8.2 If weight per gallon is required, multiply the specific gravity by the weight per gallon of distilled water at the same temperature (8.31 lb/gal at $25.0 \pm 0.1^\circ\text{C}$).

9. Procedure B—Weight per Gallon Method

9.1 Determine the weight per gallon of the magnet-wire enamel in accordance with Test Method D 1475 at $25.0 \pm 0.1^\circ\text{C}$.

10. Report

910.1 Report the following information:

910.1.1 Identification of the magnet-wire enamel, and

910.1.2 When using Procedure A, report the specific gravity to the third decimal place, or

910.1.3 When using Procedure B, report the weight per gallon.

FLASH POINT

10. Scope

~~10.1 This test method covers the determination of the flash point of magnet-wire enamel.~~

11. Scope

11.1 This test method covers the determination of the flash point of magnet-wire enamel.

12. Terminology

~~11.1~~*Definitions of Terms Specific to This Standard:*

~~11.1.1~~

12.1 *Definitions of Terms Specific to This Test Method:*

12.2 *flash point, of magnet-wire enamel, n*— the lowest temperature at which magnet-wire enamel gives off flammable vapor in sufficient quantity to ignite in air on application of a flame under specified conditions.

12. Significance and Use

~~12.1~~The flash point reveals the upper temperature limit at which a magnet-wire enamel may be stored or used without presenting a fire hazard.

13. Significance and Use

13.1 The flash point reveals the upper temperature limit that is permissible for storage or use of a magnet-wire enamel without presenting a fire hazard.

14. Procedure

14.1 Determine the flash point in accordance with Test Method D 56.

~~14.~~

15. Report

15.1 Report the following information:

15.1.1 Identification of magnet-wire enamel, and

15.1.2 Flash point, degrees Celsius or Fahrenheit, preferably in degrees Fahrenheit.

15. Scope

~~15.1~~This test method covers the determination of a particular measured value for the solids content in a magnet-wire enamel.

16. Scope

16.1 This test method covers the determination of a particular measured value for the solids content in a magnet-wire enamel.

17. Terminology

~~16.1~~*Definitions of Terms Specific to This Standard:*

~~16.1.1~~

17.1 *Definitions of Terms Specific to This Test Method:*

17.2 *determined solids, of magnet-wire enamel, n*—the portion of a magnet-wire enamel which is not volatilized when exposed to specified conditions.

~~17.~~

18. Significance and Use

18.1 Determined solids is one of the critical factors in a magnet-wire enamel that affects film build on a conductor.

~~17.2~~18.2 The determined solids is also useful for control purposes during the manufacture and use of magnet-wire enamel and in determining uniformity of batches.

~~17.3~~18.3 The Effective Solids Procedure 18.3 The stack loss (see 34.1 and 35.127.3) requires the Determined Solids value as an input.

~~18.~~

19. Apparatus

~~18.1~~

19.1 *Forced-Convection Oven*, capable of maintaining $200 \pm 2^\circ\text{C}$ 3 °C at the specified specimen location. Refer to Specification D 5423 Type II for a representative oven.

~~18.2~~19.2 *Weighing Dishes*, aluminum, approximately 2 in. (51 mm) in diameter, and 5/8 in. (16 mm) height.

~~18.3~~

19.3 Analytical Balance, capable of weighing to ± 0.1 mg.

19. Procedure

- 19.1 Preheat dishes to remove oil. Five minutes at 200°C is adequate.
- 19.2 Test not less than two specimens.
- 19.3 Place a 2.0 g specimen (± 0.1 mg) into a tared aluminum dish and weigh immediately.
- 19.4 The weighed specimen must thoroughly cover the entire bottom surface of the weighing dish. Accomplish this by warming the more viscous materials.
- 19.5 Place the dish and its contents in a $200 \pm 2^{\circ}\text{C}$ forced-convection oven for a predetermined period of time.
- 19.6 Remove the dish from the oven and cool to room temperature in a desiccator.
- 19.7 Weigh the dish and its contents (± 0.1 mg), capable of weighing to ± 0.1 mg.

20. Procedure

- 20.1 Preheat dishes to remove oil. Five minutes at $200 \pm 3^{\circ}\text{C}$ is adequate.
- 20.2 Test a minimum of two specimens.
- 20.3 Place a 2.0 g specimen (± 0.1 mg) into a tared aluminum dish and weigh immediately.
- 20.4 The weighed specimen must thoroughly cover the entire bottom surface of the weighing dish. Accomplish this by warming the more viscous materials.
- 20.5 Place the dish and its contents in a $200 \pm 3^{\circ}\text{C}$ forced-convection oven for 2 ± 0.1 h.
- 20.6 Remove the dish from the oven and cool to room temperature in a desiccator.
- 20.7 Weigh the dish and its contents (± 0.1 mg).

21. Report

- 201.1 Report the following information:
 - 201.1.1 Ratio of the weight of residue to that of the specimen, expressed as a percentage, as the determined solids content, S , calculated as follows:

$$S = (\text{Weight of residue/weight of specimen}) \times 100 \quad (1)$$

- 201.1.2 Number of tests and individual values,
- 201.1.3 Average determined solids of all tests made, and
- 201.1.4 Identification of the magnet-wire enamel.

21.22. Precision and Bias

21.1

22.1 *Precision:*

22.1.1 The results of all measurements on the sample should typically agree within $\pm 0.5\%$.

22.2 *Bias:*

22.2.1 Statements of bias are not applicable in view of the unavailability of a standard reference material for this property.

STACK LOSS

22.

23. Scope

23.1 This test method covers the determination of the stack loss of magnet-wire enamel applied to AWG No. 18 (1.02-mm) electrical conductor using an inorganic material as a reference.

NOTE 1—With other sizes of electrical conductor, expect a variation in stack loss. This is particularly true with smaller diameter wire. Expect difficulty in removing the coating from fine wire.

23.

24. Terminology

23.1 *Definitions of Terms Specific to This Standard:*

23.1.1

24.1 *Definitions of Terms Specific to This Test Method:*

24.2 *stack loss, of magnet-wire enamel, n*— that portion of the magnet-wire enamel solids which are lost during the conductor-coating process.

24. Significance and Use

24.1 The stack loss of magnet-wire enamel will affect the increase in dimensions, the amount of enamel used, the weight increase, and the economies of applying the enamel to the conductor.

24.2 The Effective Solids procedure (see 33.1.1 and 34.1), requires the Stack Loss as an input but Stack Loss is in itself not an absolute value.

25. Apparatus and Reagent

25.1 Significance and Use

25.1 The stack loss of magnet-wire enamel will affect the increase in dimensions, the amount of enamel used, the weight increase, and the economics of applying the enamel to the conductor.

26. Apparatus and Reagent

26.1 Laboratory Magnet-Wire-Coating Equipment, that will duplicate production application conditions and a supply of bare conductor to be used for the test.

25.2

26.2 Laboratory Mixer or Drill Press.

25.3

26.3 Muffle Furnace, capable of maintaining 600°C.

25.4, capable of maintaining 600 °C.

26.4 Oven, forced-convection, capable of maintaining $110 \pm 5^\circ\text{C}$ (refer to Specification D5423).

25.5, forced-convection, capable of maintaining $110 \pm 2.5^\circ\text{C}$ (refer to Specification D 5423 Type II).

26.5 Analytical Balance, capable of weighing to the nearest 0.1 mg.

25.6

26.6 Balance, capable of weighing 2 kg (± 1 g)

25.726.7 Weighing Bottles, tall-form cylindrical, glass.

25.8

26.8 Crucibles, high-form, high-temperature.

25.9

26.9 Container, at least 2 L in capacity.

25.10

26.10 Titanium Dioxide (TiO₂), meeting the specifications outlined in Specification D 476, Type III.

26.

27. Procedure

26.1

27.1 Determine the optimum conditions for applying the magnet-wire enamel using laboratory coating equipment.

26.227.2 Condition the crucible in a muffle furnace maintained at $600 \pm 20^\circ\text{C}$ to a constant weight (Note 2), and immediately place it in a desiccator for storage.

NOTE 2—In practice, crucibles will come to constant weight at 600 °C, if held in the muffle furnace for 14 to 16 h (overnight).

26.327.3 Measure the determined solids of the magnet-wire enamel in accordance with Sections ~~15-2~~16-22, and the ash content of the solids in accordance with Test Methods D 29.

26.427.4 Weigh into the container 1000 ± 1 g of the magnet-wire enamel.

26.527.5 Weigh into the container an amount of TiO₂ equal to the weight (± 1.0 g) of the solids in the 1000-g specimen of the magnet-wire enamel.

26.627.6 Mix the contents in the container until the TiO₂ is completely dispersed in the wire enamel.

26.727.7 Apply this enamel in accordance with ~~26.1~~27.1, using the same conditions and obtaining the same increase in build. Within 2 h of applying the enamel to the conductor, completely stir the enamel to ensure dispersion.

26.827.8 Remove this coating from the wire by snapping and twisting the wire or by other suitable means. Place the removed coating in a weighing bottle. For the coatings that are difficult to remove, try chilling the wire before snapping. In all cases, take care to prevent including any of the metal conductor.

26.927.9 To remove moisture, place the weighing bottle containing the coating in a $110 \pm 2.5^\circ\text{C}$ forced-convention oven for 60 ± 2 min.

26.1027.10 Remove the weighing bottle and contents from the oven and allow it to cool to room temperature in a desiccator.

26.1127.11 Weigh two conditioned crucibles and weigh into each 0.5 to 0.6 g of the dried coating from the weighing bottle. Make all weighings to the nearest 0.1 mg.

26.1227.12 Weigh two conditioned crucibles and weigh into each 0.5 to 0.6 g of TiO₂.

26.1327.13 Place all four crucibles in the cold muffle furnace. Start the furnace, allowing the temperature to come to 600 °C in 1 to 2 h.

26.1427.14 Leave the crucibles in the muffle furnace at $600 \pm 20^\circ\text{C}$ until they reach a constant weight (Note 2). Remove the crucibles and allow them to cool in a desiccator to room temperature.

26.15 Weigh the crucibles.

27.

27.15 Weigh the crucibles.

28. Calculation

278.1 Calculate the percent stack loss, L , of the magnet-wire enamel as follows:

$$\text{Let } F = E[A/AB + CD] \quad (2)$$

$$F = (EA)/(AB + CD)$$

$$\text{Let } R = 100[G - F/F]$$

$$R = (100/F)(G - F)$$

$$\text{Then } L = 100 - R$$

where:

- A = TiO_2 mixed with the wire enamel, g,
- B = percent of TiO_2 ash, expressed as a decimal,
- C = solids in the wire-enamel specimen, g,
- D = percent ash of the wire-enamel solids, expressed as a decimal,
- E = weight of ash in the coating specimen, g
- F = corrected ash weight, g,
- G = original weight of coating specimen before ashing, g, and
- R = retention of coating.

28. Report

28.1 Report the following information:

- 28.1.1 Identification of magnet-wire enamel,
- 28.1.2 Determined solids content of the magnet-wire enamel,
- 28.1.3 Percent ash content of the magnet-wire enamel solids,
- 28.1.4 Average percent retention of coating to two decimal places, and
- 28.1.5 Average percent stack loss to two decimal places.

29. Report

29.1 Report the following information:

- 29.1.1 Identification of magnet-wire enamel, [ASTM D3288/D3288M-08](#)
- 29.1.2 Determined solids content of the magnet-wire enamel, [c92-4aab-80d9-3d5a58fedd31/astm-d3288-d3288m-08](#)
- 29.1.3 Percent ash content of the magnet-wire enamel solids.
- 29.1.4 Average percent retention of coating to two decimal places, and
- 29.1.5 Average percent stack loss to two decimal places.

30. Precision and Bias

29.1 This 30.1 This test method has been in use for many years, but no statement of precision has been made and no activity is planned to develop such a statement.

EFFECTIVE SOLIDS

30. Scope

30.1 This test method covers the determination of the percentage of liquid enamel that will be retained on the metal conductor in the finished product.

31. Scope

31.1 This test method covers the determination of the percentage of liquid enamel that will be retained on the metal conductor in the finished product.

32. Terminology

31.1 Definitions of Terms Specific to This Standard:

31.1.1

32.1 Definitions of Terms Specific to This Test Method:

32.2 effective solids, of magnet-wire enamel, n —the percentage of the liquid enamel retained after the removal of the solvents and the additional oven bakes that simulate the stack loss that occurs during the enameling manufacturing process for magnet wire.