



Designation: F 205 – 94 (Reapproved 1999)

Standard Test Method for Measuring Diameter of Fine Wire by Weighing¹

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1. Scope

1.1 This test method covers the measurement of the average diameter of fine wire by weighing a known length; it applies particularly to sizes up to 0.13 mm (0.005 in.) used in electron devices and lamps.

1.2 The values stated in SI units are to be regarded as the standard. The values given in inch-pound units apply only for the diameter.

1.3 *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:

F 180 Test Method for Density of Fine Wire and Ribbon for Electronic Devices²

3. Apparatus

3.1 The apparatus shall consist of a suitable torsion or other direct-reading balance capable of reading to 0.002 mg or 0.1 % of the weight to be weighed (whichever is larger), with an accuracy of 0.004 mg or 0.2 % (whichever is larger). The range of the balance (or the size of the specimen) shall be such that the reading will lie within the upper half of the scale.

4. Test Specimens

4.1 Test specimens shall be selected at least 1 m from the end of a spool or sufficiently far from the end to be free from kinks or other damage resulting in lack of straightness of the cut length.

4.2 The wire shall be drawn from the spool under a low even tension so that no elongation of the wire takes place.

4.3 Each test specimen shall be cut to a length of 200 ± 0.1 mm. To prevent stretching, care shall be taken so that the

tension is just sufficient to eliminate the sag and curl. Any disagreement concerning the amount of tension to be used in cutting shall be resolved between the manufacturer and the purchaser.

4.4 The test specimen shall be folded upon itself several times and twisted to make a compact bundle with loop consisting of a single strand for hanging it on the balance beam. In the case of multiple specimens, all specimens shall be twisted together and hung by a loop consisting of a single strand. The specimen shall be handled as little as possible. The operator's hands shall be clean and dry.

5. Number of Specimens

5.1 Weigh a single specimen if its weight lies within the upper half of the scale of the instrument. When the weight is less than half of the scale of the instrument, weigh a sufficient number of specimens, 200 mm in length, simultaneously so that the total weight will register in the upper half of the scale, preferably as close to the limit of the balance as possible. Use the lowest range instrument compatible with the weight of the 200-mm weight specimen to reduce the number of 200-mm lengths that must be weighed together.

6. Repetition of Weighing

6.1 If the corrected weight of a single specimen lies within ± 0.5 % of either the minimum or the maximum limit specified for the wire weight, cut and weigh two more specimens of wire in a similar manner. When two or more lengths of wire have been weighed simultaneously to produce a reading in the upper half of the scale because of the small size of the wire, cut and weigh two more sets of specimens in a similar manner.

7. Calibration and Checking of the Balance

7.1 Check the balance regularly in accordance with the recommendations of the manufacturer.

7.2 If a variety of weights are to be determined, calibrate the balance at five major points on the scale and at zero by determining the weights of calibrated check weights. If any point is in error by more than 1 %, remove the balance from service and repair it. Apply corrections determined by checking to the apparent readings to obtain corrected weights. Obtain

¹ This test method is under the jurisdiction of ASTM Committee F-1 on Electronics and is the direct responsibility of Subcommittee F01.03 on Metallic Materials.

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² *Annual Book of ASTM Standards*, Vol 10.04.