

REVISIONS

LTR	DESCRIPTION	DATE	APPROVED
A	Technical modifications to agree with SAE-AS22759/80. Editorial changes throughout. Update format. Added approved supplier.	3/1/2009	Abdo Abdouni
B	Added approved supplier.	8 September 2010	Abdo Abdouni
C	Technical modifications to agree with SAE-AS22759. Add SAE- AS22759/180. Amended paragraph section 3.5.3. Increase 2 to 3 J/g. Updated Table I finish wire weight. Amended the government and non-government contact information. Removed ASME Y14.100 and selected item drawing. Vendor name change.	26 June 2015	Abdo Abdouni

CURRENT DESIGN ACTIVITY CAGE
CODE 037Z3 HAS CHANGED NAMES TO:
DLA LAND AND MARITIME
COLUMBUS, OHIO 43218-3990



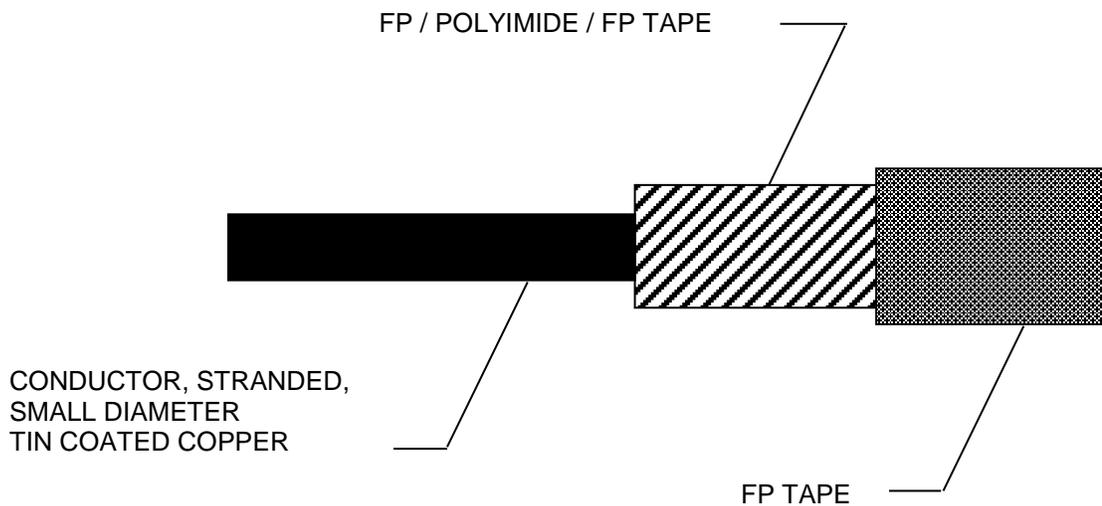
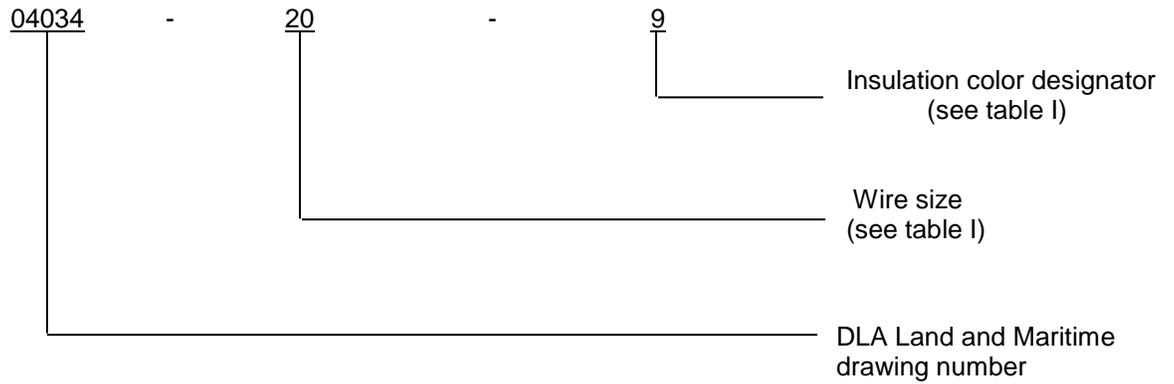
REV																		
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PMIC	PREPARED BY William Carpenter		DEFENSE SUPPLY CENTER, COLUMBUS COLUMBUS, OHIO 43218-3990	
Original date of drawing 12 July 2004	CHECKED BY Lee Surowiec		TITLE WIRE, ELECTRICAL, COMPOSITE, POLYTETRAFLUOROETHYLENE/POLYIMIDE INSULATED, SMOOTH SURFACE, LIGHT WEIGHT, COPPER CONDUCTOR, TIN COATED, 150°C, 600 VOLT	
	APPROVED BY Richard L. Taylor			
	SIZE A	CAGE CODE 037Z3	DWG. NO.	04034
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1 SCOPE

1.1 Scope. This drawing covers the performance characteristics for a composite wire using a seamless polytetrafluoroethylene/ hydrolysis resistant polyimide tape wrap insulation system, with a light weight stranded conductor.

1.2 Part or Identifying Number (PIN). The complete PIN should be as follows:



FP – Fluorocarbon Polymer, modified Polytetrafluoroethylene (PTFE)

FIGURE 1. General configuration.

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TABLE I. Details of construction.

1/ PIN	Wire size (AWG)	Conductor			Finished wire			
		Stranding (number of strands X gauge (AWG) of strands)	Diameter (inches)		Resistance at 20°C ohms/1000ft. (max)	Diameter (inches)		2/ Weight lb/1000ft. (max)
			Min	Max		Min	Max	
04034-26-*	26	19 X 38	.0175	.0204	41.3	.030	.034	1.43/1.45
04034-24-*	24	19 X 36	.0225	.0244	26.2	.034	.038	1.93/2.00
04034-22-*	22	19 X 34	.0285	.0314	16.2	.040	.043	2.85/2.95
04034-20-*	20	19 X 32	.0365	.0394	9.88	.048	.051	4.38/4.45
04034-18-*	18	19 X 30	.0455	.0494	6.23	.056	.060	6.60/6.65
04034-16-*	16	19 X 29	.0515	.0554	4.81	.063	.067	8.30/8.35
04034-14-*	14	19 X 27	.0645	.0694	3.06	.076	.080	12.6/12.8
04034-12-*	12	37 X 28	.0835	.0894	2.02	.096	.100	19.6/20.3
04034-10-*	10	37 X 26	.106	.112	1.26	.119	.123	30.6/31.4

1/ The asterisks in the PIN column of table I should be replaced by color code designators (see 1.2.2). Example: 04034-26-93 is white with an orange stripe.

2/ The first/second numbers are the wire weight lb/1000ft. maximum for the SAE-AS22759/80 / SAE-22759/180 respectively.

1.2.1 Color. The wire insulation color should be indicated by the color designator (see 1.2) and as specified in the contract or purchase order. The insulation color should be in accordance with MIL-STD-681, system 1, differentiation color coding chassis wiring (3 numbers maximum). For laser marked wires, color limits should be in accordance with MIL-STD-104, class I, or in accordance with table V of this drawing.

2. APPLICABLE DOCUMENTS

2.1 Government documents.

2.2 Specifications, standards, and handbooks. The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those cited in the solicitation or contract.

DEPARTMENT OF DEFENSE STANDARDS

MIL-STD-104	-	Limits for Electrical Insulation Color
MIL-STD-2223	-	Test Methods for Insulated Electric Wire
MIL-STD-681	-	Identification Coding and Application of Hookup and Lead Wire

(Copies of these documents are available online at <http://quicksearch.dla.mil>)

2.3 Non-government publications. The following documents form a part of this document to the extent specified herein. Unless otherwise specified, the issues of these documents are those cited in the solicitation or contract.

ASTM INTERNATIONAL

ASTM B33	-	Standard Specification for Tinned Soft or Annealed Copper Wire for Electrical Purposes
ASTM D3032	-	Standard Test Methods for Hookup Wire Insulation
ASTM D4591	-	Standard Test Method for Determining Temperatures and Heats of Transitions of Fluoropolymers by Differential Scanning Calorimetry

(Copies of these documents are available from <http://www.astm.org>.)

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NCSL INTERNATIONAL

NCSL-Z540.3 - General Requirements for Calibration of Measuring and Test Equipment

(Copies of these documents are available online at <http://www.ncsli.org>.)

SAE INTERNATIONAL

SAE-AS4373 - Test Methods for Insulated Electric Wire
 SAE-AS22759 - Wire, Electrical, Fluoropolymer-Insulated, Copper or Copper Alloy
 SAE-AS22759/80 - Wire, Electrical, Polytetrafluoroethylene/polyimide Insulated, Lightweight, Tin-coated, copper conductor 150 °C, 600 Volts
 SAE-AS22759/180 - Wire, Electrical, Polytetrafluoroethylene/polyimide Insulated, Smooth Surface Lightweight, Tin-coated, copper conductor 150 °C, 600 Volts ROHS

(Copies of these documents are available from <http://www.sae.org>.)

3. REQUIREMENTS

3.1 DLA Land and Maritime requirements. Items described in this shall meet the requirements of SAE-AS22759, SAE-AS22759/80 and SAE-AS22759/180 except as specified herein. Any requirements included in this drawing shall be in addition to, or supersede those requirements included in SAE-AS22759, SAE-AS22759/80, and SAE-AS22759/180. In case of conflict between the requirements in this drawing, SAE-AS22759, SAE-AS22759/80, and SAE-AS22759/180, the requirements of this drawing shall take precedence.

3.2 Design configuration. The design, construction, and physical dimensions shall be as specified in this drawing.

3.2.1 Design documentation. Design documentation shall be retained by the manufacturer, and shall be available upon request for review by the contracting activity, DLA Land and Maritime, or contractor.

3.3 Material.

3.3.1 Conductor. Conductors shall be made of soft annealed copper wire in accordance with ASTM B33 and table I of this drawing. All strands shall be free from lumps, kinks, splits, scarred or corroded surfaces and skin impurities. Strands shall be tin coated in accordance with ASTM B33.

3.3.2 Insulation. Insulation shall be polytetrafluoroethylene and polytetrafluoroethylene/polyimide tape as specified in tables II and III. The polyimide tape shall be hydrolysis resistant.

TABLE II. Wire insulation materials. 1/

Tape code	Thickness nominal (inches)	Material
1	.0012	.00045 FP/.00065 polyimide/.0001 FP
2	.0020	FP (Unsintered)
3	.0025	FP (Unsintered)

1/ Physical properties of PTFE unsintered tape shall be in accordance with SAE-AS22759.

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TABLE III. Physical properties of FP/Polyimide/FP tapes.

Tensile strength	20,000 lb/in ² (average min)
Tensile modulus	400,000 lb/in ² (average min)
Elongation	40 percent (average min)
Dielectric strength	4,000 volts/mil (average min)
.00045 FP Layer	Distinguishable color (next to conductor)

3.4 Wire construction and physical dimensions. See figure 1 and tables I and IV.

TABLE IV. Tape overlap requirements. 1/

Wire size	Wrap 1			Wrap 2			Nominal wall thickness (mils)
	Tape code	Percent overlap		Tape code	Percent overlap		
		Min	Max		Min	Max	
26	1	50.5	54.0	2	50.5	54.0	5.8
24	1	50.5	54.0	2	50.5	54.0	5.8
22	1	50.5	54.0	2	50.5	54.0	5.8
20	1	50.5	54.0	2	50.5	54.0	5.8
18	1	50.5	54.0	2	50.5	54.0	5.8
16	1	50.5	54.0	2	50.5	54.0	5.8
14	1	50.5	54.0	2	50.5	54.0	5.8
12	1	50.5	54.0	3	50.5	54.0	6.7
10	1	50.5	54.0	3	50.5	54.0	6.7

1/ Wrap 1 is innermost tape which is in contact with the conductor, with the .00045 inch FP side of the tape against the conductor.

3.5 Performance testing. Wire supplied to this drawing shall be qualified in accordance with SAE-AS22759/80, SAE-AS22759/180, and shall meet any additional requirements of this drawing.

3.5.1 Wet arc propagation resistance (test required for initial qualification only). When tested in accordance with MIL-STD-2223, method 3006, the following requirements shall apply:

- a. A minimum of 68 wires shall pass the impulse dielectric test of SAE-AS22759.
- b. Not more than two wires shall fail the impulse dielectric test in any one bundle.
- c. Actual damage to the wire shall be not more than 1.0 inch (25.4 mm) in length in any bundle when measured along the axis.

3.5.2 Forced hydrolysis (test required for initial qualification only). When tested in accordance with SAE-AS4373, method 602, the minimum average performance shall be 5000 hours at 70°C. The following details shall apply:

- a. Number of specimens: 5.
- b. Wire size to be tested: 20 AWG.
- c. A specimen is considered "failed" when it can no longer pass the dielectric test method of SAE-AS4373 method 602.
- d. Average the time to failure for all of the specimens evaluated.

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3.5.3 Insulation state of sinter (quality conformance test). FP layers shall be evaluated with a differential scanning calorimeter in accordance with ASTM D4591. The FP layers shall meet the following requirements:

- a. Insulation state of sinter: 3 J/g maximum.
- b. Bonding between FP layers shall be homogenous. No evidence of tape edges or seams shall be present on the outer FP layer when visually examined with the unaided eye. The outer surface will be smooth and free of tape edges at the overlap.

3.5.4 Lamination sealing (conformance inspection test). When tested in accordance with SAE-AS4373 method 809 at 200°C, there shall be no evidence of tape separation or lifting. There shall be no visible tape ridges that can contribute to tearing of the tape.

3.5.5 Strippability (conformance inspection test). There shall be no evidence of separation or elongation of FP layers when stripped with standard hand held tools designed for such use. No evidence of insulation shall be left on the conductor when viewed with the naked eye. The following details shall apply:

- a. Test size: 26 AWG to 14 AWG, in accordance with ASTM D3032, section 27.
- b. Length of insulation slugs shall be .25 inches (6.35 mm).
- c. The strip force shall be as follows:

Wire size (AWG)	Minimum force (lbs)	Maximum force (lbs)
20 - 26	0.25	6.0
18 to 14	0.50	7.0

3.5.6 Durability (PTFE outer layer) (Test required for initial qualification only). When tested as specified, the wire shall withstand an average of 100 cycles without failure due to tear or surface cut through of the outer layer. The following details shall apply:

- a. Wire size: 22 AWG.
- b. Temperature: 23°C.
- c. Weight: 300 grams (10.6 oz).
- d. Edged abrading rod diameter: .026 inch (0.66 mm) nominal.
- e. Test specimens shall be manufactured to emulate the wire construction specified herein, except the polyimide shall be replaced with an aluminum/Mylar film of similar thickness with the conductive (aluminum) side out. The conductive surface is used in a circuit path to determine when the abrading rod has penetrated the PTFE layer.
- f. Test method:
 - (1) Install a .026 inch (0.66 mm) edged abrading rod with the edged surface facing down (perpendicular with the test specimen).
 - (2) Remove approximately 1 inch (25.4 mm) of insulation from the end of the specimen and connect the circuit detection clip to the exposed conductor.
 - (3) Apply the appropriate weights to the fixture.
 - (4) Place the abrading rod on the specimen, ensuring the rod is level and perpendicular to the specimen surface.
 - (5) Zero the counter on the abrasion tester.
 - (6) Turn the tester on. The rod will begin to oscillate over the surface of the specimen with an approximate 1 inch (25.4 mm) stroke.
 - (7) The test will continue until the tester detects continuity between the abrading rod and the conductor.
 - (8) Record the number of cycles to failure.
 - (9) Repeat the procedure a minimum of 10 times (100 times preferred) to generate a statistically significant sample.
 - (10) Average the results.

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3.5.7 UV laser marking (test required for initial qualification only). When marked with an ultraviolet (UV) laser source at 1.5 J/cm², white FP tape shall have a contrast level of 65% minimum average and colored FP tape shall have a 62% minimum average. This requirement applies to the outer most FP insulation layer. Non-white insulation colors shall meet the Munsell color limit requirements shown in table V. Contrast level is defined as:

$$CL = \frac{(\text{Reflectance of the background insulation} - \text{Reflectance of the laser mark})}{(\text{Reflectance of the background insulation})}$$

3.5.8 Color (conformance inspection test). Colors shall be in accordance with MIL-STD-104, class 1, except for UV laser markable wire as shown in table V. White is the preferred background insulation color. Color conformity to the limits of MIL-STD-104 shall not be required after oven exposure.

TABLE V. Munsell color limits for UV laser markable wire.

Color	Hue		Value		Chroma	
	From	To	Min	Max	From	To
Black	2.5RN	2.5RN	7	8.5	N/A	N/A
Blue	5PB	7.5B	7	8	4	6
Green	2.5G	7.5G	7	9	2	6
Red	10RP	5R	7	8	4	6
Yellow	5Y	10Y	8	9	4	6
Brown	2.5YR	7.5R	7	9	2	4
Orange	10R	2.5YR	6	7	8	10
Violet	2.5P	7.5R	7	8	4	8
Gray	Same as black					

3.5.9 Color striping or banding durability (conformance inspection test). Colored stripes or bands shall meet the durability of color marking requirements specified in SAE AS22759. The following shall apply to the durability of color marking test.

- a. Weight: 250 grams (8.82 oz).
- b. Strokes: 250 strokes (125 cycles).

3.6 Ratings.

3.6.1 Temperature rating. 150°C maximum continuous conductor temperature.

3.6.2 Voltage rating. 600 Vrms at sea level.

3.7 Marking. The finished wire shall be identified by a printed marking applied to the outer surface or the wire. The identification mark shall not be applied by hot stamp marking or other methods which significantly penetrate the insulation. The PIN shall be in accordance with 1.2 herein.

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4. VERIFICATION

4.1 Classification of inspections. The inspection requirements specified herein are classified as follows:

- a. Qualification inspection (see 4.2).
- b. Conformance inspection (see 4.3).

4.1.1 Equipment calibration. All test equipment and inspection facilities shall be maintained in accordance with NCSL Z540.3 or equivalent.

4.2 Qualification inspection. The product manufactured under this drawing shall be currently listed on the qualified products list QPL-22759 for wire type SAE-AS22759/80 and SAE AS22759/180. The requirements in paragraph 3.5 apply.

4.3 Conformance inspection. Conformance inspection shall be in accordance with SAE AS22759, SAE-AS22759/80, SAE AS22759/180, and 3.5 herein.

4.4 Certification. In order to be certified and listed as an approved source of supply for wire manufactured to this drawing, a manufacturer shall:

- a. Agree to make available to DLA Land and Maritime, upon request, all pertinent test data indicating compliance to the tests outlined in SAE AS22759, SAE-AS22759/80, SAE AS22759/180, and this drawing.
- b. Provide to DLA Land and Maritime-VAI, or its designated agent, upon request, free of charge and without obligation, current production samples of the types and quantities requested.
- c. Meet one of the following criteria:
 - (1) Currently be listed on QPL-22759 for at least one wire series (not necessarily the one for which this drawing applies).
 - (2) Be in current production of the subject part.

4.5 Certificate of compliance. A certificate of compliance shall be required from a manufacturer in order to be listed as an approved source of supply (see 6.7).

5 PACKAGING

5.1 Packaging. For acquisition purposes, the packaging requirements shall be as specified in the contract or order (see 6.2). When packaging of materiel is to be performed by DoD or in-house contractor personnel, these personnel need to contact the responsible packaging activity to ascertain packaging requirements. Packaging requirements are maintained by the Inventory Control Point's packaging activities within the Military Service or Defense Agency, or within the military service's system commands. Packaging data retrieval is available from the managing Military Department's or Defense Agency's automated packaging files, CD-ROM products, or by contacting the responsible packaging activity.

6 NOTES

6.1 Intended use. Wires conforming to this drawing are intended for use when military specifications do not exist for wires that will perform the required function. This drawing is intended to prevent the proliferation of unnecessary duplicate specifications, drawings and stock catalog listings. When a military specification exists and the product covered by this drawing has been qualified for listing on QPL-22759, this drawing will be inactivated.

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6.1.1 Solderability. This wire is primarily intended for crimp connections. For solderability applications use the silver coated copper versions.

6.2 Acquisition requirements. The acquisition document should specify the following:

- a. Complete PIN (see 1.2).
- b. Requirements for delivery of a copy of the conformance inspection data for the lot being supplied, if applicable. This data should be supplied with each shipment.
- c. Requirements for certificate of compliance, if applicable.
- d. Requirements for packaging and packing.

6.3 Replaceability. Wires covered by this drawing will replace the same generic wires covered by a contractor-prepared specification or drawing.

6.4 Comments. Comments on this drawing should be directed to DLA Land and Maritime-VAI, Post Office Box 3990, Columbus, Ohio 43218-3990 or e-mail WireCable@dla.mil, telephone (614) 692-0530, facsimile (614) 692-6939.

6.5 Certificate of compliance. The certificate of compliance submitted to DLA Land and Maritime-VAI, prior to listing as an approved source of supply, should state that the manufacturer's product meets the requirements of this drawing.

6.6 Generic test data. Generic test data may be used to satisfy the requirements of 4.3. Generic test data should be on date coded wire no more than 1 year old when the wire is made of the same material, of the same design, and is made using the same manufacturing processes. The vendor is required to retain the generic data for a period of not less than 3 years from the date of shipment.

6.7 Approved sources of supply. Approved sources of supply are listed herein. Additional sources will be added as they become available. The vendors listed have agreed to the contents of this drawing and a certificate of compliance has been submitted to DLA Land and Maritime-VAI.

DLA Land and Maritime drawing PIN	Vendor CAGE number	Vendor similar PIN <u>1/</u>	Vendor CAGE number	Vendor similar PIN <u>1/</u>	Vendor CAGE number	Vendor similar PIN <u>1/</u>
04034-26-*	12814	SMLA26-X	12515	HN1T26-*	F1868	DSM8026-*
04034-24-*	12814	SMLA24-X	12515	HN1T24-*	F1868	DSM8024-*
04034-22-*	12814	SMLA22-X	12515	HN1T22-*	F1868	DSM8022-*
04034-20-*	12814	SMLA20-X	12515	HN1T20-*	F1868	DSM8020-*
04034-18-*	12814	SMLA18-X	12515	HN1T18-*	F1868	DSM8018-*
04034-16-*	12814	SMLA16-X	12515	HN1T16-*	F1868	DSM8016-*
04034-14-*	12814	SMLA14-X	12515	HN1T14-*	F1868	DSM8014-*
04034-12-*	12814	SMLA12-X	12515	HN1T12-*	F1868	DSM8012-*

1/ Caution. Parts must be purchased to this DLA Land and Maritime PIN to assure that all performance requirements and tests are met.

* Color code designators in accordance with MIL-STD-681 should replace the asterisks in the PIN column of table.
Example: 04034-26-93 is white with an orange stripe.

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<u>Vendor CAGE number</u>	<u>Vendor name and address</u>
12814	Thermax/CDT 235 North Freeport Drive Nogales, AZ 85621-2428
12515	Nexans Aerospace USA LLC 600 South Parker Street, P.O. Box 909 Elm City, NC 27822
F1868	Draka Fileca Route Nationale 1 60730 Sainte Genevieve France

6.8 Environmentally preferable material. Environmentally preferable materials should be used to the maximum extent possible to meet the requirements of this specification. As of the dating of this document, the U.S. Environmental Protection Agency (EPA) is focusing efforts on reducing 31 priority chemicals. The list of chemicals and additional information is available on their website <http://www.epa.gov/osw/hazard/wastemin/priority.htm>. Included in the EPA list of 31 priority chemicals are cadmium, lead, and mercury. Use of these materials should be minimized or eliminated unless needed to meet the requirements specified herein (see Section 3).

6.9 Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

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