

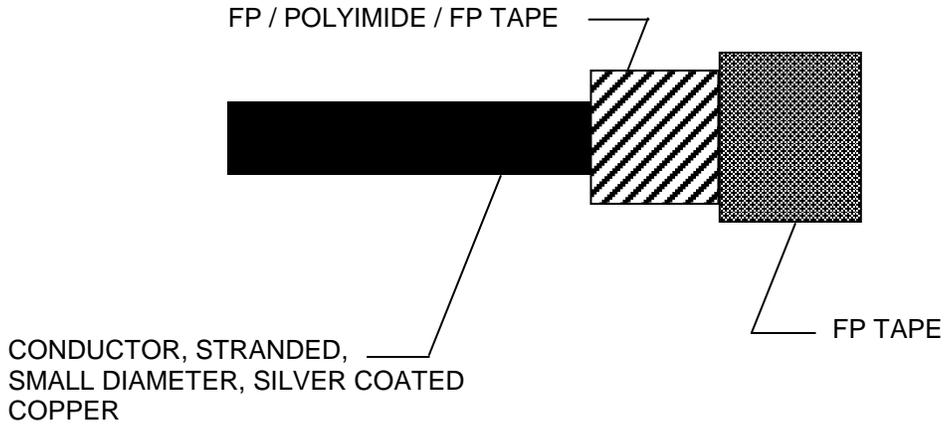
REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	Technical modifications to agree with SAE-AS22759/89. Editorial changes throughout. Update format.	6/11/07	Lee Surowiec
B	Added approved supplier. Editorial changes throughout.	12 March 2009	Abdo Abdouni
C	Added approved supplier.	8 September 2010	Abdo Abdouni
D	Technical modifications to agree with SAE-AS22759. Add SAE- AS22759/191. 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.	5 May 2016	Abdo Abdouni

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



REV																		
PAGE																		
REV STATUS OF PAGES	REV	D	C	C	C	C	C	C	C	C	D							
	PAGE	1	2	3	4	5	6	7	8	9	10							

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, SILVER COATED, COPPER CONDUCTOR, 200°C, 600 VOLT	
	APPROVED BY Richard L. Taylor	DWG. NO. 04045	
	SIZE A	CAGE CODE 037Z3	PAGE 1 OF 10
	REV D		



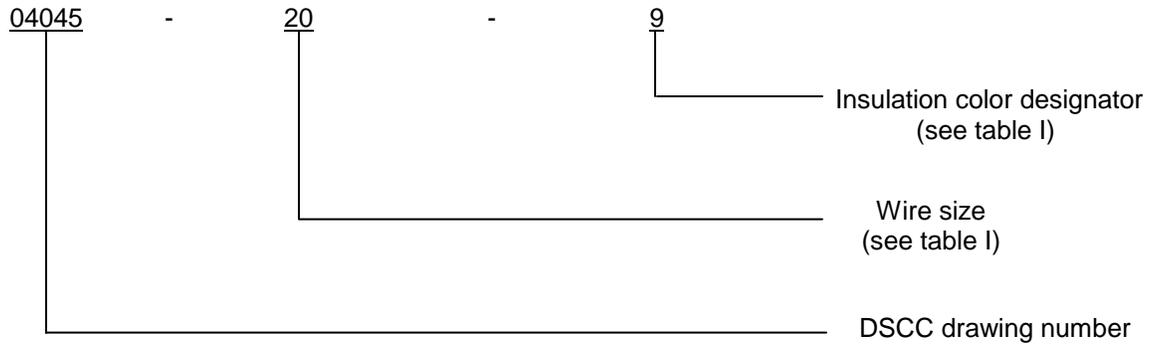
FP – Fluorocarbon Polymer, modified Polytetrafluoroethylene (PTFE)

FIGURE 1. General configuration.

1 SCOPE

1.1 Scope. This drawing covers the performance characteristics for a composite wire using a hydrolysis resistant, PTFE/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:



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TABLE I. Details of construction.

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)		Weight lb/1000ft. (max)
			Min	Max		Min	Max	
04045-26-*	26	19 X 38	.0175	.0194	38.4	.030	.034	1.45
04045-24-*	24	19 X 36	.0225	.0244	24.3	.034	.038	2.00
04045-22-*	22	19 X 34	.0285	.0304	15.1	.040	.043	2.95
04045-20-*	20	19 X 32	.0365	.0384	9.19	.048	.051	4.50
04045-18-*	18	19 X 30	.0455	.0484	5.79	.056	.060	6.70
04045-16-*	16	19 X 29	.0515	.0544	4.52	.063	.067	8.40
04045-14-*	14	19 X 27	.0645	.0684	2.88	.076	.080	12.9
04045-12-*	12	37 X 28	.0835	.0874	1.90	.096	.100	19.9
04045-10-*	10	37 X 26	.106	.110	1.19	.119	.123	30.8

* The asterisks in the PIN column should be replaced by color code designators (see 3.3.1.1).
 Example: 04045-26-93 is white with an orange stripe.

2. APPLICABLE DOCUMENTS

2.1 General. The documents listed in this section are specified in sections 3, 4, or 5 of this specification. This section does not include documents cited in other sections of this specification or recommended for additional information or as examples. While every effort has been made to ensure the completeness of this list, document users are cautioned that they must meet all specified requirements documents cited in sections 3, 4, or 5 of this specification, whether or not they are listed.

2.2 Government documents.

2.2.1 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-202 - Test Method Standard Electronic and Electrical Component Parts
- MIL-STD-681 - Identification Coding and application of Hookup and Lead Wire
- MIL-STD-2223 - Test Methods for Insulated Electric Wire

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

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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 B298 - Standard Specification for Silver Coated Soft or Annealed Copper Wire for Electronic Purposes
- ASTM D3032 - Wire, Insulation, Hookup Wire, Copper, Silver-Coated Soft or Annealed
- 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/>.)

NCSL INTERNATIONAL

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

(Copies of these documents are available from <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-AS22759/91 - Wire, Electrical, Polytetrafluoroethylene/polyimide Insulated, Light Weight, Silver Coated, Copper Conductor, 200°C, 600 Volts
- SAE-AS22759/191 - Wire, Electrical, Polytetrafluoroethylene/ Polyimide Insulated, Smooth Surface, Light Weight, Silver-Coated Copper Conductor, 200 °C, 600 Volts ROHS

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

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3. REQUIREMENTS

3.1 DLA Land and Maritime requirements. Items described in this drawing shall meet the requirements of SAE-AS22759, SAE-AS22759/91, and SAE-AS22759/191 except as specified herein. Any requirements included in this drawing shall be in addition to, or supersede those requirements included in SAE-AS22759, SAE-AS22759/91, and SAE-AS22759/191. In case of conflict between the requirements in this drawing, SAE-AS22759, SAE-AS22759/91, and SAE-AS22759/191, 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 B298 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 silver coated. The silver coating shall not be less than 50 microinches (1.27 μm) when tested in accordance with ASTM B298.

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

3.3.2 Insulation. Insulation shall be polytetrafluoroethylene and polytetrafluoroethylene/polyimide tape specified in tables II and III.

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.

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)

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

TABLE IV. Tape overlap requirements. 1/

Wire size (AWG)	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 the 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-AS22759/91, SAE-AS22759/191, 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 Solderability (conformance inspection test): The conductor shall meet the solderability requirements for stranded conductors in accordance with MIL-STD-202, method 208. The following details shall apply:

- a. Unless otherwise specified, five specimens shall be prepared and tested for solderability using method 208 of MIL-STD-202.
- b. The specimens shall be tested without steam aging using a type R flux.

3.5.3 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. Average the time to failure for all of the specimens evaluated.

3.5.4 Insulation state of sinter (conformance inspection 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.

3.5.5 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.

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3.5.6 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 20 AWG, in accordance with ASTM D3032, section 27.
- b. Length of insulation slugs shall be .25 inches.
- c. The strip force shall be as follows:

Wire size (AWG)	Minimum force (lbs)	Maximum force (lbs)
26 – 20	0.25	6.0

3.5.7 Ultraviolet (UV) laser marking (test required for initial qualification only). White FP materials shall be formulated in such a manner to achieve a 55% minimum contrast level when marked by an ultraviolet (UV) laser source operating at a fluence of $0.9 \pm 0.1 \text{ J/cm}^2$. Non-white insulation colors shall meet the Munsell color limit requirements shown in table V.

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. 200°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 specified in 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-AS22759/91 and SAE-AS22759/191. The requirements in 3.5 apply.

4.3 Conformance inspection. Conformance inspection shall be in accordance with SAE-AS22759, SAE-AS22759/91, SAE-AS22759/191, 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-AS22759/91, SAE-AS22759/191, 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.

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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.

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 to WireCable@dla.mil, telephone (614) 692-0530, or 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.

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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>
04045-26-*	12814	SMLM26-*	12515	HN1S26-*	F1868	DSM9126-*
04045-24-*	12814	SMLM24-*	12515	HN1S24-*	F1868	DSM9124-*
04045-22-*	12814	SMLM22-*	12515	HN1S22-*	F1868	DSM9122-*
04045-20-*	12814	SMLM20-*	12515	HN1S20-*	F1868	DSM9120-*
04045-18-*	12814	SMLM18-*	12515	HN1S18-*	F1868	DSM9118-*
04045-16-*	12814	SMLM16-*	12515	HN1S16-*	F1868	DSM9116-*
04045-14-*	12814	SMLM14-*	12515	HN1S14-*	F1868	DSM9114-*
04045-12-*	12814	SMLM12-*	12515	HN1S12-*	F1868	DSM9112-*
04045-10-*	12814	SMLM10-*	12515	HN1S10-*	F1868	DSM9110-*

1/ 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: 04045-26-93 is white with an orange stripe.

<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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