



Standard Test Method for Bond Strength of Electrical Insulating Varnishes by the Twisted-Coil Test¹

This standard is issued under the fixed designation D4882; 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 This test method covers the determination of the bond strength of an electrical insulating varnish when applied to a twisted coil of film-insulated magnet wire. The use of a particular type of film-insulated wire will show the values for that combination of film coating and varnish.

1.2 The values stated in inch-pound units are the standard. The values given in parentheses are for information only.

NOTE 1—Although this standard and Method C of IEC 61033 differ in approach or detail, data obtained using either are technically equivalent.

1.3 *This standard does not purport to address all, if any, 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. A specific precautionary statement is given in Section 7.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[D115 Test Methods for Testing Solvent Containing Varnishes Used for Electrical Insulation](#)

[D1711 Terminology Relating to Electrical Insulation](#)

[D2519 Test Method for Bond Strength of Electrical Insulating Varnishes by the Helical Coil Test](#)

[D6054 Practice for Conditioning Electrical Insulating Materials for Testing](#) (Withdrawn 2012)³

¹ This test method is under the jurisdiction of ASTM Committee D09 on Electrical and Electronic Insulating Materials and is the direct responsibility of Subcommittee D09.01 on Electrical Insulating Varnishes, Powders and Encapsulating Compounds.

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² 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.

³ The last approved version of this historical standard is referenced on www.astm.org.

2.2 *IEC Standard:*

[IEC 61033 Test Methods for the Determination of Bond Strength of Impregnating Agents to an Enamelled Wire Substrate](#)⁴

3. Terminology

3.1 *Definitions of Terms Specific to This Standard:*

3.1.1 *bond strength, n*—a measure of the force required to separate surfaces which have been bonded together.

3.2 Refer to Terminology [D1711](#) for definitions of other terms.

4. Summary of Test Method

4.1 Flexural strength tests are made on twisted coils to determine the force required to break the coils under specific conditions.

5. Significance and Use

5.1 Values obtained by flexural test can provide information with regard to the bond strength of the particular varnish in combination with a particular type of magnet wire, when measured under conditions described in this test method.

6. Apparatus

6.1 Coil winder as shown in [Fig. 1](#) and [Fig. 2](#).

6.2 Coil Twister as shown in [Fig. 3](#).

6.3 Test apparatus as described in Test Method [D2519](#).

7. Safety Precautions

7.1 It is unsafe to use varnish at temperatures above the flash point without adequate ventilation, especially if the possibility exists that flames or sparks are present. Store varnish in sealed containers.

8. Test Specimen Preparation

8.1 The test specimen is a wound coil made from film-insulated magnet wire, 28 AWG (0.320 mm). The coil shall be

⁴ Available from American National Standards Institute, 25 W. 43rd St., 4th Floor, New York, NY 10036.

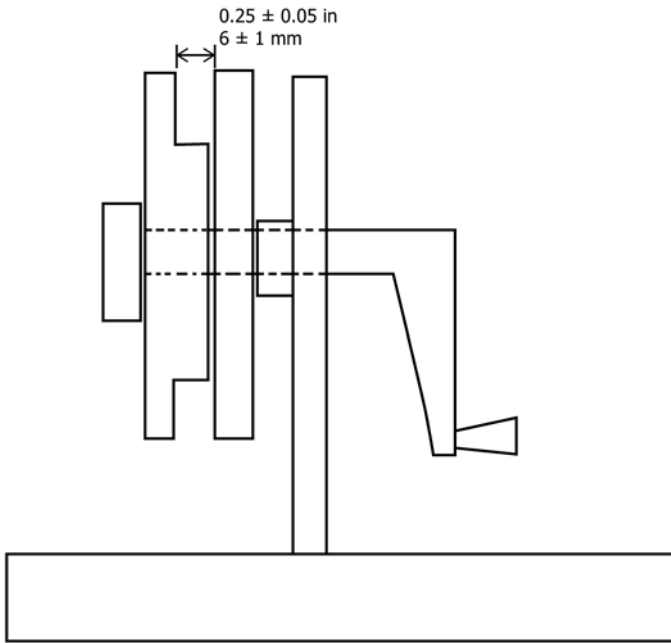


FIG. 1 Coil Winder

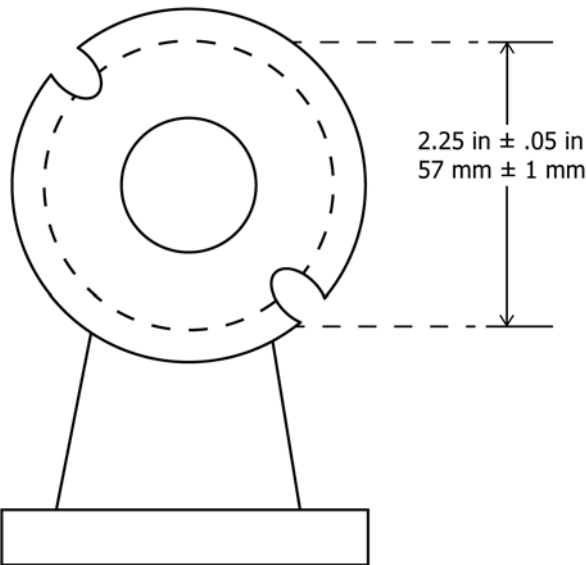


FIG. 2 Coil Winder, Front View

made by means of suitable winding equipment as shown in Fig. 1. To prevent opening of the coil after removal from the winding equipment, each end of the magnet wire, or short pieces of film-insulated wire, may be wrapped around the coil two or three times. For this purpose the winding equipment is provided with appropriate notches as shown in Fig. 2. For winding the coil the following dimensions apply:

Winding diameter	2.25 ± 0.05 in. (57 ± 1 mm)
Width of slot	.25 ± 0.05 in. (6 ± 1 mm)
Number of turns	100 (See Note 2)
Nominal wire diameter	28 AWG (0.320 mm)

NOTE 2—Instead of 100 turns of a single wire, 50 turns of two parallel wires may be used to provide a bifilar winding.

8.1.1 After the coil has been wound, remove it from the winding equipment and stretch into an oval shape as shown in Fig. 4. Twist the coil two full turns around its longitudinal axis by means of a twisting device as shown in Fig. 3. The twisted coil formed is about 0.28 in. (7 mm) in diameter and 3.25 to 3.5 in. (85 to 90 mm) in length and serves as a substrate for the varnish.

8.2 The type of magnet wire and test conditions shall be mutually agreed upon between all involved parties.

8.3 Prepare six or more specimens for each condition to be investigated.

8.4 For solvent-containing varnishes, adjust the viscosity of the varnish by trial, to produce a dry film build of 0.0017 to 0.0021 in. (.043 to .053 mm) on a double-coated copper panel coated in accordance with Test Methods D115.

8.5 Do not adjust solventless varnishes.

8.6 Attach several twisted coils to a rack and immerse vertically in the varnish until bubbling stops. Withdraw them at 4 ± 0.2 in./min (100 ± 5 mm/min) and allow them to drain horizontally for solventless varnishes 10 to 12 min at standard laboratory atmosphere in accordance with Practice D6054. For solvent-containing varnishes drain vertically 10 to 12 min at standard laboratory atmosphere in accordance with Practice D6054. Place the coils in an oven in the same position as drained. Cure at the temperature and for the time recommended by the manufacturer. Reverse dip the coils following the preceding steps if testing a solvent-containing varnish.

8.7 When testing solventless varnishes the twisted coils are single dipped.

9. Procedure

9.1 Follow the procedure as required in Test Method D2519.

10. Report

10.1 Report the data as required in Test Method D2519.

11. Precision and Bias⁵

11.1 Precision—Data from an interlaboratory study of this test method are as follows:

Data from six laboratories, 10 individual values from each laboratory per condition tested.

	Tested at 25 °C	
Mean		51 lbf (227 N)
Standard Deviation		8.1 lbf (36 N)
95 % Confidence level		15.9 lbf (71 N)
	Tested at 150 °C	
Mean		31 lbf (138 N)
Standard Deviation		4.4 lbf (20 N)
95 % Confidence level		8.6 lbf (38 N)

11.2 Bias—This test method has no bias because the value for bond strength of electrical insulating varnishes by the twisted coil test is defined solely in terms of this test method.

⁵ Supporting data are available from ASTM Headquarters. Request RR:D-9-1027.

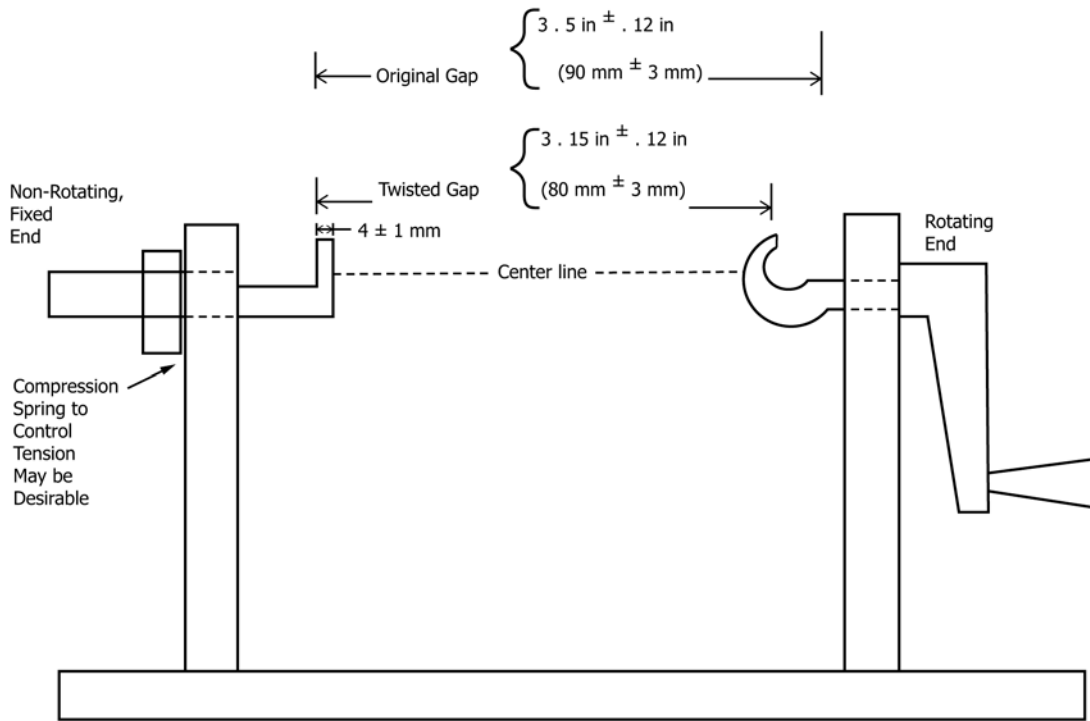


FIG. 3 Coil Twister



FIG. 4 Oval-Shaped Coil

12. Keywords

12.1 bond strength; electrical insulating; magnet wire; twisted coil; varnish

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