



# Standard Specification for Polymeric Resin Film for Electrical Insulation and Dielectric Applications<sup>1</sup>

This standard is issued under the fixed designation D5213; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

*This standard has been approved for use by agencies of the U.S. Department of Defense.*

## 1. Scope\*

1.1 This specification covers requirements for the material, dimensions and tolerances, and property values of film, in sheet or strip form, with or without heat-sealable coatings.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

NOTE 1—This document is similar to IEC 60674, Part 3, Sheets 2, 4, 5, 6, and 7.

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

[D149 Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies](#)

[D883 Terminology Relating to Plastics](#)

[D1711 Terminology Relating to Electrical Insulation](#)

[D2305 Test Methods for Polymeric Films Used for Electrical Insulation](#)

[D3636 Practice for Sampling and Judging Quality of Solid Electrical Insulating Materials](#)

[D4088 Practice for Preparation for Shipment of Solid Electrical Insulating Materials \(Withdrawn 2003\)<sup>3</sup>](#)

### 2.2 IEC Standards:

[Publication 60674-3 Specification for Electrical Films for Electrical Purposes<sup>4</sup>](#)

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee D09 on Electrical and Electronic Insulating Materials and is the direct responsibility of Subcommittee D09.07 on Flexible and Rigid Insulating Materials.

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<sup>2</sup> For referenced ASTM standards, visit the ASTM website, [www.astm.org](http://www.astm.org), or contact ASTM Customer Service at [service@astm.org](mailto:service@astm.org). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

<sup>3</sup> The last approved version of this historical standard is referenced on [www.astm.org](http://www.astm.org).

<sup>4</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

## 3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminologies [D1711](#) and [D883](#) unless otherwise specified.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *sheet, n*—material greater than 75 mm in width.

3.2.2 *strip, n*—material 75 mm or less in width.

## 4. Classification

4.1 This specification covers the following:

4.1.1 *Type I*—General purpose,

4.1.2 *Type II*—Heat sealable,

4.1.2.1 *Grade 1*—One side coated, and

4.1.2.2 *Grade 2*—Two sides coated.

4.2 *Materials:*

4.2.1 *Item A*—Poly(N,N'-p,p'-oxydiphenylene pyromellitimide),

4.2.2 *Item B*—Poly(N,N'-p,p'-oxydiphenylene biphenyltetracarboxylimide),

4.2.3 *Item C*—Poly(N,N'-p-phenylene biphenyltetracarboxylimide),

4.2.4 *Item D*—FEP-fluorocarbon, and

4.2.5 *Item E*—Polyethylene terephthalate.

4.2.6 *Item F*—Polyethylene naphthalate.

4.2.7 *Item G*—Polyetherimide.

## 5. Ordering Information

5.1 Order the film covered by this specification stating the type, grade, class, thickness, width, and roll dimensions.

## 6. Materials

6.1 Type I material is flexible, unsupported film.

6.2 Type II material is film meeting all of the requirements of Type I, and having a heat-sealable coating on one or both sides.

## 7. Requirements

7.1 The film covered by this specification shall meet the property requirements given in [Tables 1-7](#) and [Table 8](#) when tested by the methods given in Test Methods [D2305](#).

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

**TABLE 1 Property Values for Type I, Class A Film poly(N,N'-p-p'-oxydiphenylene pyromellitimide)**

	Average Property Value							
	Nominal Thickness, $\mu\text{m}$ (mils)							
	7.5 (0.3)	13 (0.5)	20 (0.8)	25 (1.0)	50 (2.0)	75 (3.0)	100 (4.0)	130 (5.0)
Tensile strength, min MPa (psi), machine direction and transverse direction	69 (10 000)	97 (14 000)	138 (20 000)	138 (20 000)	138 (20 000)	138 (20 000)	138 (20 000)	138 (20 000)
Elongation, min percent, machine and transverse direction	10	20	35	35	40	45	45	45
Shrinkage, max percent, after exposure to 200 °C (392 F), machine and transverse direction	...	...	0.30	0.30	0.35	0.35	0.35	0.35
Moisture absorption, max percent, 100 % RH	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Dielectric strength, min kV/mm (V/mil), 60 Hz <sup>A,B</sup>	120 (3000)	120 (3000)	180 (4500)	180 (4500)	150 (3800)	140 (3600)	100 (2500)	100 (2500)
Volume resistivity, min $\Omega\text{-cm}$ , <sup>B,C</sup>	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$
Permittivity, max at 1 kHz <sup>B</sup>	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Dissipation factor, max at 1 kHz <sup>B</sup>	0.007	0.005	0.005	0.004	0.004	0.004	0.004	0.004

<sup>A</sup>Use Type 3 electrodes in air of Table 1 of Test Method D149 (opposing 6.4-mm diameter rods).

<sup>B</sup>At 23 °C (73.4 °F), 50 % RH.

<sup>C</sup>The median value of 5 measurements shall be used for compliance.

**TABLE 2 Property Values for Type I, Class B Film poly(N,N'-p-p'-oxydiphenylene biphenyltetracarboxylimide)**

	Average Property Value								
	Nominal Thickness, $\mu\text{m}$ (mils)								
	7.5 (0.3)	13 (0.5)	20 (0.8)	25 (1.0)	40 (1.6)	50 (2.0)	75 (3.0)	100 (4.0)	130 (5.0)
Tensile strength, min MPa (psi), machine direction and transverse direction	110 (15 000)	138 (20 000)	196 (28 000)	196 (28 000)	196 (28 000)	196 (28 000)	196 (28 000)	196 (28 000)	196 (28 000)
Elongation, min percent, machine and transverse direction	24	40	80	80	80	80	80	80	80
Shrinkage, max percent, after exposure to 200 °C (392 °F), machine and transverse direction	...	...	0.30	0.30	0.35	0.35	0.35	0.35	0.35
Moisture absorption, max percent, 100 % RH	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
Dielectric strength, min kV/mm (V/mil), 60 Hz <sup>A,B</sup>	120 (3000)	120 (3000)	180 (4500)	180 (4500)	150 (3800)	140 (3500)	130 (3300)	100 (2500)	95 (2400)
Volume resistivity, min $\Omega\text{-cm}$ , <sup>B,C</sup>	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$
Permittivity, max at 1 kHz <sup>B</sup>	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Dissipation factor, max at 1 kHz <sup>B</sup>	0.007	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005

<sup>A</sup> Use Type 3 electrodes in air of Table 1 of Test Method D149 (opposing 6.4-mm diameter rods).

<sup>B</sup>At 23 °C (73.4 °F), 50 % RH.

<sup>C</sup>The median value of 5 measurements shall be used for compliance.

**TABLE 3 Property Values for Type I, Class C Film poly(N,N'-p-phenylene biphenyltetracarboxylimide)**

	Average Property Value								
	Nominal Thickness, $\mu\text{m}$ (mils)								
	7.5 (0.3)	13 (0.5)	20 (0.8)	25 (1.0)	40 (1.6)	50 (2.0)	75 (3.0)	100 (4.0)	130 (5.0)
Tensile strength, min MPa (psi), machine direction and transverse direction	133 (19 000)	176 (25 000)	241 (34 000)	241 (34 000)	241 (34 000)	241 (34 000)	241 (34 000)	241 (34 000)	241 (34 000)
Elongation, min percent, machine and transverse direction	25	25	25	25	25	25	25	25	25
Shrinkage, max percent, after exposure to 200 °C (392 °F), machine and transverse direction	...	...	0.15	0.15	0.15	0.20	0.20	0.20	0.20
Moisture absorption, max percent, 100 % RH	1.8	1.8	1.8	1.8	1.8	1.8	1.8	1.8	1.8
Dielectric strength, min kV/mm (V/mil), 60 Hz <sup>A,B</sup>	120 (3000)	120 (3000)	180 (4500)	180 (4500)	150 (3800)	140 (3500)	120 (3000)	100 (2500)	95 (2400)
Volume resistivity, min $\Omega\text{-cm}$ , <sup>B,C</sup>	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$
Permittivity, max at 1 kHz <sup>B</sup>	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0	4.0
Dissipation factor, max at 1 kHz <sup>B</sup>	0.007	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005

<sup>A</sup> Use Type 3 electrodes in air of Table 1 of Test Method D149 (opposing 6.4-mm diameter rods).

<sup>B</sup>At 23 °C (73.4 °F), 50 % RH.

<sup>C</sup>The median value of 5 measurements shall be used for compliance.

**TABLE 4 Property Values for Type I, Class D Film (FEP—Fluorocarbon)**

	Average Property Value												
	Nominal Thickness, $\mu\text{m}$ (mils)												
	13 (0.50)	25 (1.0)	51 (2.0)	76 (3.0)	102 (4.0)	127 (5.0)	254 (10.0)	356 (14.0)	508 (20.0)	762 (30.0)	1016 (40.0)	1524 (60.0)	2413 (95.0)
Tensile strength, min MPa (psi), machine direction and transverse direction	13.8 (2000)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)	17.25 (2500)
Elongation, min, %, machine direction and transverse direction	175	250	250	250	250	250	250	250	250	250	250	250	250
Shrinkage, max percent, after exposure to 200 °C (392 °F)	5.0	5.0	3.0	2.0	2.0	2.0	2.0	2.0	2.0	4.0	4.0	4.0	5.0
Moisture absorption, max percent, 100 %, RH	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
Dielectric strength, min at 60 Hz kV/mm (V/mil) <sup>A,B</sup>	160 (4000)	160 (4000)	140 (3500)	120 (3000)	110 (2750)	100 (2500)	72 (1800)	64 (1600)	56 (1400)	...	...	...	...
Volume resistivity, min, $\Omega\text{-cm}$ <sup>B,C</sup>	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$
Permittivity, max at 1 kHz <sup>B</sup>	2.15	2.15	2.15	2.15	2.15	2.15	2.15	2.15	2.15	2.15	2.15	2.15	2.15
Dissipation factor, max at 1 kHz <sup>B</sup>	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003	0.0003

<sup>A</sup> Use Type 3 electrodes in air of Table 1 of Test Method D149 (opposing 6.4-mm diameter rods).

<sup>B</sup> At 23 °C (73.4 °F), 50 % RH.

<sup>C</sup> The median value of 5 measurements shall be used for compliance.

**TABLE 5 Property Values for Type I, Class E Film (Polyethylene Terephthalate)**

	Average Property Value								
	Nominal Thickness, $\mu\text{m}$ (mils)								
	12 (0.48)	15 (0.60)	23 (0.92)	36 (1.42)	75 (3.00)	100 (4.00)	190 (7.50)	250 (10.00)	
Tensile strength, min MPa (psi), machine direction and transverse direction	145 (21 000)	145 (21 000)	138 (20 000)	138 (20 000)	138 (20 000)	138 (20 000)	138 (20 000)	110 (16 000)	
Elongation, min % machine direction and transverse direction	60	60	65	70	70	70	70	70	70
Shrinkage, max percent after exposure to 150 °C (302 °F), 30 min	3.5	3.0	3.0	3.0	3.0	3.0	3.0	2.0	
Moisture absorption, max %, 100 % RH	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8
Dielectric strength, min at 60 Hz, kV/mm (V/mil) <sup>A,B</sup>	208 (5300)	190 (4800)	174 (4400)	130 (3300)	105 (2700)	80 (2000)	60 (1500)	50 (1300)	
Volume resistivity, min, $\Omega\text{-cm}$ <sup>B,C</sup>	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$
Permittivity, max at 1 kHz <sup>B</sup>	3.5	3.5	3.5	3.5	3.5	3.5	3.5	3.5	3.5
Dissipation factor, max at 1 kHz <sup>B</sup>	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006

<sup>A</sup> Use Type 3 electrodes in air of Table 1 of Test Method D149 (opposing 6.4-mm diameter rods).

<sup>B</sup> At 23 °C (73.4 °F), 50 % RH.

<sup>C</sup> The median value of 5 measurements shall be used for compliance.

7.1.1 Type II films, prior to coating, shall meet all of the requirements given in Table 1 for films of the thicknesses given in Table 9.

7.1.2 Type II films, after coating, shall meet all of the requirements given in Table 1 for elongation, before and after heating, and for shrinkage as given in Table 1 for films of the thicknesses given in Table 9.

### 7.2 Roll Diameters:

7.2.1 The outside diameters of rolls of film shall not vary from the value specified on the purchase order by more than  $\pm 6$  mm (0.25 in.).

7.2.2 The inside diameters of cores of standard rolls of film shall not vary from the value specified on the purchase order by more than  $\pm 1.5$  mm (0.060 in.).

7.3 The widths of film in rolls shall be within the following tolerances:

7.3.1 Twenty-five mm (1 in.) wide or less,  $\pm 0.4$  mm (0.015 in.).

7.3.2 Over 25 to 100 mm (over 1 to 4 in.),  $\pm 0.8$  mm (0.030 in.).

7.3.3 Over 100 mm (4 in.),  $\pm 1.6$  mm (0.062 in.).

7.4 The number of splices in standard rolls shall not exceed the values given in Table 10 for Type I film or Table 11 and Table 12 for Type II films.

7.5 The thicknesses shall be within the tolerances specified in Table 13 for Type I film or Table 3 for Type II film.

7.6 The color of the sheet or strip shall be uniform within a given lot, as determined by visual examination.

7.7 The film shall be uniform in appearance, as determined by visual examination. The film shall be clean and free from contamination, wrinkles, holes, scratches, and other defects that might affect either appearance or serviceability. The heat-sealable coating for Type II material shall be uniform in appearance.

**TABLE 6 Property Values for Type I, Class F Film (Polyethylene Naphthalate) Average Property Value**

	Nominal Thickness, $\mu\text{m}$ (mils)						
	12 (0.48)	16 (0.65)	25 (1.00)	38 (1.50)	50 (2.00)	75 (3.00)	100 (4.00) - 250 (10.00)
Tensile strength, min MPa (psi), machine direction and transverse direction	172 (25 000)	172 (25 000)	172 (25 000)	172 (25 000)	172 (25 000)	172 (25 000)	172 (25 000)
Elongation, min percent, machine and transverse direction	50	50	50	50	50	50	50
Shrinkage, max percent, after exposure to 150 °C (302 °F), 30 min	2.00	2.00	2.00	2.00	2.00	2.00	2.00
Moisture absorption, max %, at 100 % RH	0.6	0.6	0.6	0.6	0.6	0.6	0.6
Dielectric strength, min at 60 Hz, kV/mm (V/mil) <sup>A,B</sup>	215 (5500)	215 (5500)	195 (5000)	145 (3700)	145 (3700)	120 (3000)	120 (3000)
Volume resistivity, min, $\Omega\text{-cm}$ <sup>B,C</sup>	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$	$10^{15}$
Permittivity, max at 1 kHz <sup>B</sup>	3.4	3.4	3.4	3.4	3.4	3.4	3.4
Dissipation factor, max at 1 kHz <sup>B</sup>	0.006	0.006	0.006	0.006	0.006	0.006	0.006

<sup>A</sup> Use Type 3 electrodes in air of Table 1 of Test Method D149 (opposing 6.4-mm diameter rods).

<sup>B</sup> At 23 °C (73.4 °F), 50 % RH.

<sup>C</sup> The median value of 5 measurements shall be used for compliance.

**TABLE 7 Property Values for Type 1, Class G Film (Polyetherimide)**

	Average Property Value				
	Nominal Thickness, $\mu\text{m}$ (mils)				
	25 (1.00)	50 (2.00)	75 (3.00)	100 (4.00)	125 (5.00)
Tensile Strength, min Mpa (psi), machine direction and transverse direction	93 (13500)	93 (13500)	93 (13500)	93 (13500)	93 (13500)
Elongation, min percent, machine direction and transverse direction	100.00	100.00	100.00	100.00	100.00
Shrinkage, max percent, after exposure to 200 °C (392 °F)	0.60	0.60	0.50	0.40	0.40
Moisture Absorption, max percent 100 % RH	1.20	1.20	1.20	1.20	1.20
Dielectric strength, min kV/mm (V/mil) <sup>A,B</sup>	284 (7100)	196 (4900)	148 (3700)	124 (3100)	108 (2400)
Volume Resistivity, min $\Omega\text{-cm}$ <sup>B,C</sup>	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$	$10^{17}$
Permittivity, max at 1kHz <sup>B</sup>	3.40	3.40	3.40	3.40	3.40
Dissipation Factor, max at 1kHz <sup>B</sup>	0.0080	0.0080	0.0080	0.0080	0.0080

<sup>A</sup> Use Type 3 electrodes in air of Table 1 of Test Method D149 (opposing 6.4-mm diameter rods).

<sup>B</sup> At 23 °C (73.4 °F), 50 % RH.

<sup>C</sup> The median value of 5 measurements shall be used for compliance.

**TABLE 8 Additional Property Values for Type II, Class A, B and C Films**

Grade	Total Nominal Thickness $\mu\text{m}$ (mils) <sup>A</sup>	Dielectric Strength, min kV/mm (V/mil)	Heat Seal Strength, min at 350 °C $\pm$ 2 °C (662 $\pm$ 3.6 °F) g/25 mm (in.) width	
			Coated Side to Uncoated Side	Coated Side to Coated Side
1	25 (1.0)	120 (3000)	450	450
1	38 (1.5)	140 (3500)	450	800
1	50 (2.0)	120 (3000)	450	800
1	60 (2.5)	100 (2500)	450	800
1	75 (3.0)	100 (2500)	450	800
1	100 (4.0) <sup>B</sup>	80 (2000)	450	800
1	100 (4.0) <sup>C</sup>	105 (2700)	450	800
1	150 (6.0)	85 (2100)	450	800
2	30 (1.2)	155 (3900)	...	500
2	38 (1.5)	120 (3000)	...	800
2	50 (2.0)	120 (3000)	...	800
2	75 (3.0) <sup>D</sup>	100 (2500)	...	800
2	75 (3.0) <sup>C</sup>	80 (2000)	...	600
2	130 (5.0)	90 (2200)	...	800

<sup>A</sup> See Table 3A for nominal thicknesses of polyimide and FEP-Fluorocarbon layers.

<sup>B</sup> FEP-Fluorocarbon coating is 50  $\mu\text{m}$  (2.0 mils) in nominal thickness.

<sup>C</sup> FEP-Fluorocarbon coating is 25  $\mu\text{m}$  (1.0 mils) in nominal thickness.

<sup>D</sup> FEP-Fluorocarbon coating is 12  $\mu\text{m}$  (0.5 mils) in nominal thickness.

## 8. Sampling

8.1 Sample in accordance with Practice D3636, unless otherwise agreed upon between the supplier and the purchaser.

8.2 For purposes of sampling, an inspection lot for examination shall consist of all film of the same type, grade, class, and nominal thickness submitted for inspection at one time. If a single shipment contains film having different lot numbers assigned by the film manufacturer, sample each lot number separately.

8.3 The total quantity of material to be taken from each lot shall be approximately twice that estimated to be required for the tests that are to be made, in order to permit repeat tests without resampling.

8.4 These materials are normally made in master rolls of approximately 360 kg (800 lb) in weight. Take samples for examination and testing from the end of the master rolls.

## 9. Number of Tests

9.1 Unless otherwise agreed upon by the purchaser and the seller, routine lot inspection tests shall consist of evaluation of all of the properties specified in 7.4 – 7.7. For these properties,

**TABLE 9 Thicknesses and Tolerances for Type II Class A, B and C Films**

Grade	Nominal Thickness, $\mu\text{m}$ (mils)				Tolerances on Total Thickness, $\pm\mu\text{m}$ (mils)
	Total	First FEP <sup>A</sup> Layer	Polyimide Layer	Second FEP <sup>A</sup> Layer	
1	25 (1)	None	13 (0.5)	13 (0.5)	6 (0.25)
1	38 (1.5)	None	25 (1)	13 (0.5)	6 (0.25)
1	50 (2)	None	25 (1)	25 (1)	8 (0.3)
1	62 (2.5)	None	50 (2)	13 (0.5)	3.3 (0.13)
1	75 (3)	None	50 (2)	25 (1.0)	10 (0.4)
1	100 (4)	None	50 (2)	50 (2)	10 (0.4)
1	100 (4)	None	75 (3)	25 (1)	10 (0.4)
1	150 (6)	None	130 (5)	25 (1)	15 (0.6)
2	30 (1.18)	2.5 (0.1)	25 (1)	25 (0.1)	2 (0.08)
2	38 (1.5)	13 (0.5)	13 (0.5)	13 (0.5)	7 (0.3)
2	50 (2)	13 (0.5)	25 (1)	13 (0.5)	8 (0.3)
2	75 (3)	13 (0.5)	50 (2)	13 (0.5)	10 (0.4)
2	75 (3)	25 (1)	25 (1)	25 (1)	10 (0.4)
2	130 (5)	25 (1)	75 (3)	25 (1)	12 (0.5)

<sup>A</sup> The FEP-Fluorocarbon film shall conform to Specification D5213, Class D.

**TABLE 10 Splice Tolerances for Standard Rolls of Type I Film**

Roll Diameter, mm (in.)		Nominal Thickness, $\mu\text{m}$ (mils)								
ID	OD	7.5 (0.3)	13 (0.5)	20 (0.8)	25 (1.0)	40 (1.6)	50 (2.0)	75 (3.0)	100 (4.0)	130 (5.0)
<b>Number of Splices per Roll, max</b>										
76 (3)	124 (4.88)	9	...	...	...	...	...	...	...	...
76 (3)	152 (6)	...	5	2	2	2	1	1	1	1
76 (3)	241 (9.5)	...	...	7	7	5	5	4	4	4
152 (6)	241 (9.5)	40	10	5	5	5	3	3	2	2
<b>Length Between Splices or From End of Roll, m (ft), min</b>										
76 (3)	152 (6)	...	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	23 (75)	23 (75)
76 (3)	241 (9.5)	...	...	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	23 (75)	23 (75)
152 (6)	241 (9.5)	23 (75)	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	23 (75)	23 (75)
<b>Average Splice-Free Length per Roll, m (ft)<sup>A</sup>, min</b>										
76 (3)	152 (6)	...	150 (500)	150 (500)	115 (380)	115 (380)	75 (250)	45 (150)	45 (150)	45 (150)
76 (3)	241 (9.5)	...	...	195 (640)	195 (640)	130 (425)	130 (425)	105 (340)	60 (200)	60 (200)
152 (6)	241 (9.5)	90 (300)	170 (550)	150 (500)	150 (500)	115 (380)	115 (380)	75 (250)	60 (200)	60 (200)

<sup>A</sup> Divide the length of the roll by the total number of splice-free segments.

**TABLE 11 Splice Tolerances for Standard Rolls of Type II, Grade 1 Film**

Roll Diameter, mm (in.)		Nominal Thickness, $\mu\text{m}$ (mils)						
ID	OD	25 (1)	38 (1.5)	50 (2)	63 (2.5)	75 (3)	100 (4)	150 (6)
<b>Number of Splices per Roll, max</b>								
76 (3)	152 (6)	5	3	2	2	2	1	...
76 (3)	241 (9.5)	...	8	7	5	5	5	4
152 (6)	241 (9.5)	9	5	5	4	4	4	3
<b>Length Between Splices or From End of Roll, m (ft), min</b>								
76 (3)	152 (6)	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	...
76 (3)	241 (9.5)	...	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	23 (75)
152 (6)	241 (9.5)	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	30 (100)	23 (75)
<b>Average Splice-Free Length per Roll, m (ft)<sup>A</sup>, min</b>								
76 (3)	152 (6)	75 (250)	75 (250)	75 (250)	60 (200)	50 (165)	55 (185)	...
76 (3)	241 (9.5)	...	115 (375)	95 (310)	100 (335)	85 (280)	60 (205)	50 (170)
152 (6)	241 (9.5)	90 (300)	115 (375)	75 (250)	60 (200)	65 (210)	45 (150)	38 (125)

<sup>A</sup> Divide the nominal length of the roll by the total number of splice-free segments.

**TABLE 12 Splice Tolerances for Standard Rolls of Type II, Grade 2 Film**

Roll Diameter, mm (in.)		Nominal Thickness, $\mu\text{m}$ (mils)			
ID	OD	38 (1.5)	50 (2)	75 (3)	130 (5)
<b>Number of Splices, Per Roll, max</b>					
76 (3)	241 (9.5)	...	7	6	5
152 (6)	241 (9.5)	9	5	4	4
<b>Length Between Splices or From End of Roll, m (ft), min</b>					
76 (3)	152 (6)	30 (100)	30 (100)	30 (100)	23 (75)
76 (3)	241 (9.5)	...	30 (100)	30 (100)	23 (75)
152 (6)	241 (9.5)	30 (100)	30 (100)	30 (100)	23 (75)
<b>Average Splice-Free Length per Roll, m (ft)<sup>A</sup>, min</b>					
76 (3)	152 (6)	50 (165)	75 (250)	50 (165)	45 (150)
76 (3)	241 (9.5)	...	95 (310)	75 (245)	50 (160)
152 (6)	241 (9.5)	45 (140)	75 (250)	65 (210)	37 (12)

<sup>A</sup> Divide the nominal length of the roll by the total number of splice-free segments.

each master roll shall be considered a lot for sampling. All samples must pass inspection.

9.2 Routine lot inspection tests for properties specified in 7.1, including definition of the number of master rolls per lot, shall be agreed upon between the purchaser and the seller. All samples must pass inspection.

9.3 The number of specimens tested from each sample for properties specified in 7.1 and 7.5 shall be in accordance with the requirements of the individual test method. The test result on a sample shall be the average of the results on individual specimens prepared from that sample, unless otherwise stated in the test method.

9.4 For slit rolls and full-width rolls other than master rolls, the number of samples taken for properties specified in 7.2 – 7.4 shall be subject to agreement between the purchaser and the seller.

**10. Certification**

10.1 The purchase order or contract shall state any requirements for certification by the producer. If required, a certification shall state that the film was sampled in accordance with Section 8, tested in accordance with Test Methods D2305, and found to be in conformance with the requirements shown in

**TABLE 13 Thickness Tolerances for Type I Film**

Nominal Thickness, $\mu\text{m}$ (mils)	Thickness Tolerance, $\pm \mu\text{m}$ (mils)
7.5 (0.3)	1.5 (0.06)
13 (0.5)	4 (0.15)
20 (0.8)	4 (0.15)
25 (1)	5 (0.2)
40 (1.6)	5 (0.2)
50 (2)	8 (0.3)
75 (3)	8 (0.3)
100 (4)	10 (0.4)
130 (5)	13 (0.5)

Section 7. If required by the purchase order, or contract, the producer shall furnish a report of the testing used as the basis for the certification.

## 11. Identification and Marking

11.1 *Identification*—Marking of the material shall show the name of the material, type and grade, dimensions, and quantity.

11.2 *Shipping Containers*—Boxes or crates shall be marked with the name of the material, type and grade, and dimensions and lot number; and the name and address of the supplier.

11.3 All packing, packaging, and marking provisions of Practice **D4088** shall apply to this specification.

## 12. Keywords

12.1 conditioning; dielectric strength; dissipation factor; elongation; FEP fluorocarbon; film; fluorinated poly(ethylene-propylene); heat-seal strength; heatsealable; permittivity; polyetherimide; polyethylene naphthalate; polyethylene terephthalate; polyimide; poly(N; N'-p; p'-oxydiphenylene biphenyltetracarboxylimide); poly(N; N'-p; p'-oxydiphenylene pyromellitimide); poly(N; N'-p-phenylene biphenyltetracarboxylimide); shrinkage; tensile strength; thickness; volume resistivity

## SUMMARY OF CHANGES

Committee D09 has identified the location of selected changes to this specification since the last issue, D5213 – 07, that may impact the use of this specification. (Approved November 1, 2012.)

(1) Non-mandatory terms have been eliminated from Footnote C in Tables 1 through 7.

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