

INCH-POUND

J-W-1177/25B

June 10, 1988

SUPERSEDING

J-W-1177/25A

September 27, 1976

FEDERAL SPECIFICATION SHEET

WIRE, MAGNET, ELECTRICAL, CLASS 155, TYPE DgV,
POLYESTER-GLASS-FIBER-COVERED, RECTANGULAR

This specification is approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

The requirements for acquiring the wire described herein shall consist of this specification and the latest issue of J-W-1177.

- Classification:** Class 155;
type Dg2 (bare with double polyester-glass fiber, unvarnished),
type Dg2V (bare with double polyester-glass fiber, varnished),
type B2Dg and type B2Dg2 (heavy film, single or double polyester-glass fiber, unvarnished),
type B2DgV and type B2Dg2V (heavy film, single or double polyester-glass fiber, varnished);
rectangular.
- Insulating materials:** The fiber covering and application of the covering shall be as specified in J-W-1177. If an underlying film coating is used, it shall have a class 130 rating. The varnish used in treating fibrous covered wire shall conform to the requirements of class 155 of MIL-I-24092, or an alternate selected on the basis of equivalent test data. The varnish used shall be identified in the qualification test report.
- NEMA/ANSI equivalent:** All test requirements are equivalent to MW-46 of NEMA MW 1000.
- General requirements:** See J-W-1177 for general requirements, quality assurance provisions, and packaging.

AMSC N/A

FSC 6145

DISTRIBUTION STATEMENT A Approved for public release; distribution unlimited

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Requirements:

Characteristics	Test procedure, see J-W-1177	Wire sizes, AWG	Requirements
Dimensions	4.7.1.2	All	<p>Rectangular wire:</p> <p>(a) Conductor dimensions and radii - see table I.</p> <p>(b) Conductor tolerances - see table II.</p> <p>(c) Increase in thickness - see table III (type B2Dg), table IV (type Dg2) and table V (type B2Dg2).</p> <p>(d) Increase in width due to the polyester-glass fiber covering shall be equal to or less than the increase in thickness.</p> <p>Square wire:</p> <p>(a) Conductor dimensions, radii and tolerances - see table VI.</p> <p>(b) Increase in thickness and width - see table VI.</p>
Adherence and flexibility	4.7.2.3.1	All	For bare wire, not less than 75 volts/mil of the minimum thickness of the polyester-glass fiber covering on one side of the bare conductor.
	4.7.2.3.2	All	For film coated wire, no cracks visible in the film coating after 20 percent elongation. Examine with normal vision without removal of the polyester-glass fiber covering.
Elongation	4.7.5	All	Not less than 32 percent for thickness of 0.049 inch and greater, or 30 percent for thicknesses less than 0.049 inch.
Dielectric strength	4.7.9	All	Not less than 90 volts/mil of minimum thickness of the polyester-glass fiber covering on one side (one-half the minimum specified under "Dimensions") plus the minimum breakdown for film coated wire.
Thermal endurance	----	All	Class 155. Insulating materials shall meet the thermal class ratings as described above.

TABLE I. Dimensions and radii for rectangular wire.

Nominal thickness	Nominal width																																					
	Inch	.079	1/.083	.088	1/.093	.098	1/.104	.110	1/.118	.124	1/.132	.140	1/.148	.157	1/.167	.177	1/.187	.197	1/.209	.220	1/.236	.248	1/.264	.280	1/.295	.315	1/.335	.354	1/.374	.394	1/.417	.441	1/.465	.492				
0.025																																						
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.124																																						
.140																																						
.157																																						
.177																																						
.197																																						
.220																																					0.039	

1/ R-40 series numbers.

EXAMPLE - Preferred sizes 55 x 110 (R20 x R20)

Radii tolerances are plus
or minus 25 percent.

Intermediate sizes 55 x 118 (R20 x R40)

TABLE II. Conductor tolerances.

Thickness, inch	Permissible variations in thickness
0.220 to 0.098	+ 1 percent
Under 0.098 to 0.025	- 0.001 percent
Width, inch	
0.492 to 0.315	+ 0.003 inch
Under 0.315 to 0.098	+ 1 percent
Under 0.098 to 0.079	- 0.001 inch

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TABLE III. Maximum increase in thickness, inch, due to single-polyester-glass-fiber covering and heavy-film coating over rectangular wire.

Nominal thickness	Nominal width																																		
Inch	0.079	1/.083	.088	1/.093	.098	1/.104	.110	1/.118	.124	1/.132	.140	1/.148	.157	1/.167	.177	1/.187	.197	1/.209	.220	1/.236	.248	1/.264	.280	1/.295	.315	1/.335	.354	1/.374	.394	1/.417	.441	1/.465	.492	Inch	
0.025																																		0.025	
.028																																			.028
.031																																			.031
.035																																			.035
.039																																			.039
.044																																			.044
.049			0.010									0.011																							.049
.055																																			.055
.063																																			.063
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.079																																			.079
.088																																			.088
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1/ R-40 series numbers.
Radii tolerance is plus
or minus 25 percent.

EXAMPLE - Preferred sizes 55 x 110 (R20 x R20)
Intermediate sizes 55 x 118 (R20 x R40)

NOTES:

1. The maximum increase due to the heavy-film coating and single-polyester-glass-fiber covering may be exceeded provided the overall dimension of the covered wire does not exceed the sum of the maximum thickness of the bare wire plus the maximum increase due to the heavy-film coating and single-polyester-glass-fiber covering.
2. The increase due to the heavy-film coating and single-glass-fiber covering for wire having dimensions not shown in table III shall be the same as those for the next larger thickness or width.
3. The increase in thickness due to the heavy-film coating, if any, shall be for film-coated wire.
4. The increase in thickness due to the single-polyester-glass-fiber covering shall be determined by subtracting 0.005 inch (maximum thickness of film coating) from the maximum increase in thickness given in table III.

TABLE IV. Maximum increase in thickness, inch, due to double-polyester-glass-fiber covering over rectangular wire.

Nominal thickness	Nominal width																																			
Inch	0.079	1/.083	.088	1/.093	.098	1/.104	.110	1/.118	.124	1/.132	.140	1/.148	.157	1/.167	.177	1/.187	.197	1/.209	.220	1/.236	.248	1/.264	.280	1/.295	.315	1/.335	.354	1/.374	.394	1/.417	.441	1/.465	.492	Inch		
0.025																																			0.025	
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1/ R-40 series numbers.
Radii tolerance is plus
or minus 25 percent.

EXAMPLE - Preferred sizes 55 x 110 (R20 x R20)
Intermediate sizes 55 x 118 (R20 x R40)

NOTES:

1. The maximum increase due to the polyester-glass-fiber covering may be exceeded provided the overall dimension of the covered wire does not exceed the sum of the maximum thickness of the bare wire plus the maximum increase due to the polyester-glass-fiber covering.
2. The increase due to the polyester-glass-fiber covering for wires having dimensions not shown in table IV shall be the same as those for the next larger thickness or width.
3. The minimum increase shall be 70 percent of the maximum increase shown in table IV, rounded off to the nearest 0.001 inch.

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TABLE V. Maximum increase in thickness, inch, due to double-polyester-glass-fiber covering and heavy-film coating over rectangular wire.

Nominal thickness	Nominal width																																		
Inch	0.079	1/.083	.088	1/.093	.098	1/.104	.110	1/.118	.124	1/.132	.140	1/.148	.157	1/.167	.177	1/.187	.197	1/.209	.220	1/.236	.248	1/.264	.280	1/.295	.315	1/.335	.354	1/.374	.394	1/.417	.441	1/.465	.492	Inch	
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.028																																			.028
.031																																			.031
.035																																			.035
.039																																			.039
.044			0.016						0.017			0.018											0.020												.044
.049																																			.049
.055																																			.055
.063																																			.063
.071																																			.071
.079																																			.079
.088																																			.088
.098																																			.098
.110										0.018			0.019									0.020					0.021							.110	
.124																																			.124
.140																																			.140
.157																																			.157
.177																0.020																			.177
.197																																			.197
.220																																			.220

1/ R-40 series numbers.
Radii tolerance is plus
or minus 25 percent.

EXAMPLE - Preferred sizes 55 x 110 (R20 x R20)
Intermediate sizes 55 x 118 (R20 x R40)

NOTES:

1. The maximum increase due to the polyester-glass-fiber covering may be exceeded provided the overall dimension of the covered wire does not exceed the sum of the maximum thickness of the bare wire or film-coated wire plus the maximum increase due to the polyester-glass-fiber covering.
2. The increase due to the polyester-glass-fiber covering for wires having dimensions not shown in table IV shall be the same as those for the next larger thickness or width.
3. The increase in thickness due to the heavy film coating, if any, shall be for film-coated wire.
4. The minimum increase shall be not less than 70 percent of the maximum increase shown in table IV, rounded off to the nearest 0.001 inch.
5. Because it is impossible to separate accurately the polyester-glass-fiber covering from the film coating, the total minimum increase in the thickness of film-coated double-polyester-glass-fiber-covered rectangular wire shall be 70 percent of the maximum increase given in table V rounded off to the nearest 0.001 inch.

TABLE VI. Minimum increase and maximum overall dimensions of polyester-glass-fiber-covered square wire.

AWG size	Bare wire dimension, inch			Radii inchi/ inchi	Type Dg2V		Type B2DgV		Type B2Dg2V	
	Min	Nom	Max		Minimum increase, inch	Maximum overall dimension, inch	Minimum increase, inch	Maximum overall dimension, inch	Minimum increase, inch	Maximum overall dimension, inch
0	0.3219	0.3249	0.3279	0.040	0.012	0.344	0.009	0.341	0.015	0.349
1	.2864	.2893	.2922	.040	.012	.308	.009	.305	.015	.313
2	.2550	.2576	.2602	.040	.012	.276	.008	.272	.015	.281
3	.2271	.2294	.2317	.040	.012	.248	.008	.244	.015	.253
4	.2023	.2043	.2063	.040	.012	.222	.008	.219	.015	.227
5	.1801	.1819	.1837	.040	.011	.199	.008	.196	.014	.204
6	.1604	.1620	.1636	.032	.011	.179	.008	.175	.014	.184
7	.1429	.1443	.1457	.032	.010	.160	.008	.157	.013	.165
8	.1272	.1285	.1298	.032	.009	.143	.008	.141	.012	.148
9	.1133	.1144	.1155	.026	.009	.129	.008	.127	.012	.134
10	.1009	.1019	.1029	.026	.008	.115	.007	.113	.011	.120
11	.0897	.0907	.0917	.020	.008	.103	.007	.102	.011	.108
12	.0798	.0808	.0818	.020	.008	.093	.007	.092	.011	.098
13	.0710	.0720	.0730	.016	.008	.084	.007	.084	.011	.089
14	.0631	.0641	.0651	.016	.008	.076	.007	.076	.011	.081

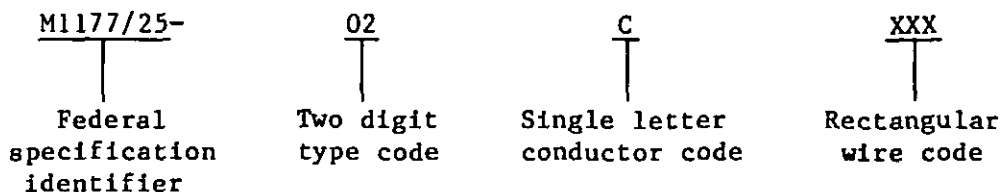
1/ Tolerance is plus or minus 25 percent.

NOTES:

1. The increase due to the heavy film coating or glass-fiber covering for wires having dimensions not shown in table VI shall be the same as those for the next larger size.
2. The increase in thickness due to the heavy film coating, if any, shall be for film-coated wire.

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Part number: Magnet wire covered by this specification shall be defined by the following part numbering system. Example: M1177/25-02CXXX.



The following codes shall apply:

Type	Type code	Conductor	Conductor code
Dg2	01	Copper	C
Dg2V	02	Aluminum	A
B2Dg	03	Nickel-coated copper	N
B2Dg2	04	Silver-coated copper	S
B2DgV	05		
B2Dg2V	06		

Intended use: Type DgV rectangular magnet wire is intended for use in 155°C applications similar to those for which type GV magnet wire is used where increased toughness and nonfraying properties are required.

Revision letters are not used to denote changes due to the extensiveness of the changes.

MILITARY INTERESTS:

Custodians:

Army - CR
Navy - SH
Air Force - 85

Review activities:

Army - AR, ER, MI
DLA - IS

User activities:

Army - ME
Navy - AS, CG, MC, OS

CIVIL AGENCY COORDINATING ACTIVITIES:

GSA - FSS, PBO, PCD
INTERIOR - BLM
HHS - FDA
DCGOVT - DCG
NASA - JFK
COMMERCE - NBS
TRANSPORTATION - APM, FAA

Preparing activity:

Navy - SH
(Project 6145-1111-21)