



**Raychem Wire and Cable**  
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**SPECIFICATION: WCD 3113**  
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PAGE: 1 of 14

**POWER CABLE, ELECTRIC, RADIATION-CROSSLINKED,  
MODIFIED FLUOROELASTOMER-INSULATED, NICKEL-COATED COPPER**

**1. SCOPE**

**1.1 SCOPE**

This specification covers nickel-coated copper wire insulated with radiation-crosslinked modified fluoroelastomer and is intended for use in high temperature, high power military ground support applications.

**1.2 CLASSIFICATION**

Products in accordance with this specification shall be of the following types, as specified in the applicable specification sheet.

Finished Cable: A single conductor, insulated as specified in the applicable specification sheet.

**1.3 TEMPERATURE INDEX**

Products in accordance with this specification have a temperature index rating of at least 3,000 hours at 200°C (*TI 3 kh/200°C*) when tested in accordance with ASTM D 3032, Section 14.

**2. APPLICABLE DOCUMENTS**

**2.1 GOVERNMENT-FURNISHED DOCUMENTS**

The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

**2.1.1 Department of Defense**

**SPECIFICATIONS**

**Federal**

TT-I-735 Isopropyl Alcohol

UU-T-450 Tissue, Facial

Military

MIL-PRF-5606 Hydraulic Fluid, Petroleum Base, Aircraft, Missile, and Ordnance

MIL-PRF-46170 Hydraulic Fluid, Rust Inhibited, Fire Resistant, Synthetic Hydrocarbon Base, NATO Code No. H-544

## STANDARDS

Federal

FED-STD-228 Cable and Wire, Insulated; Methods of Testing

Military

MIL-STD-681 Identification Coding and Application of Hook Up and Lead Wire

MIL-STD-2223 Test Methods for Insulated Electric Wire

(Copies of Department of Defense documents may be obtained from the Naval Publications and Forms Center, Standardization Documents Order Desk, Bldg. 4D, 700 Robbins Ave., Philadelphia, PA 19111-5094; or at <http://assist.daps.dla.mil/quicksearch/>.)

## 2.2 OTHER PUBLICATIONS

The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

2.2.1 American Society for Testing and Materials (ASTM)

D 3032 Standard Test Methods for Hookup Wire Insulation

D 4814 Standard Specification for Automotive Spark-Ignition Engine Fuel

(Copies of ASTM documents may be obtained from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959; or at [www.astm.org](http://www.astm.org).)

2.2.2 Society of Automotive Engineers (SAE)

AS4373 Test Methods for Insulated Electric Wire

AS22759 Wire, Electrical, Fluoropolymer-Insulated, Copper or Copper Alloy

AS29606 Wire, Electrical, Stranded, Uninsulated Copper, Copper Alloy, or Aluminum, or Thermocouple Extension, General Specification For

(Copies of SAE documents may be obtained from the Society of Automotive Engineers, 400 Commonwealth Drive, Warrendale, PA 15096-0001; or at [www.sae.org](http://www.sae.org).)

### 3. REQUIREMENTS

#### 3.1 SPECIFICATION SHEETS

The requirements for the individual cables furnished under this specification shall be as specified herein and in accordance with the applicable specification sheet. In the event of a conflict, the requirements of the specification sheet shall govern.

#### 3.2 QUALIFICATION

The finished cable furnished under this specification shall be a product which has been tested and has passed the qualification tests specified herein (see 4.3).

#### 3.3 MATERIALS

Materials not specifically designated herein shall be of the quality and form best suited for the purpose intended. Unless otherwise specified, the materials shall meet the following requirements:

##### 3.3.1 Conductor Material

Conductor material shall be nickel-coated soft or annealed copper in accordance with AS29606.

##### 3.3.2 Insulation Material

The insulation shall be extruded radiation-crosslinked modified fluoroelastomer.

#### 3.4 CONSTRUCTION

Construction of the finished cable shall be as specified herein and in the applicable specification sheet.

##### 3.4.1 Conductor

###### 3.4.1.1 Conductor Stranding

Conductor stranding shall be in accordance with the applicable specification sheet. For high-strand-count conductor, conductor having strand counts higher than AS29606 of the same wire size, the minimum allowable number of strands may be 98 percent of the number specified in the applicable specification sheet, as long as the dimensional and resistance requirements are met.

### 3.5 FINISHED CABLE

Finished cable shall conform to the requirements of Table 1 and to those of the applicable specification sheet.

**TABLE 1. PROPERTIES OF FINISHED CABLE**

Examination or Test	Requirement	Test Method	*Inspection Class
Abrasion	Specification Sheet	4.5.1	Q
Color	Specification Sheet and 3.5.1	4.5.5	P
Concentricity	Specification Sheet	AS4373, Method 101	P
Conductor Diameter	Specification Sheet	AS4373, Method 401	P
Conductor Elongation	3.5.2	4.5.3	P
Conductor Material	Specification Sheet and 3.3.1	4.5.2	V
Conductor Resistance	Specification Sheet	AS22759	P
Conductor Splices	MIL-DTL-29606	4.5.5	V
Conductor Stranding	Specification Sheet and 3.4.1.1	4.5.5	V
Crosslinking Proof Test	Specification Sheet and 3.5.3	4.5.4	P
Finished Cable Diameter	Specification Sheet	AS4373, Method 901	P
Flammability	Specification Sheet	4.5.6	Q
Humidity Resistance	Specification Sheet	4.5.7	Q
Identification and Color Striping Durability	Specification Sheet	AS22759	P
Identification of Product	Specification Sheet and 3.5.4	4.5.5	P
Immersion	Specification Sheet	4.5.8	Q
Insulation Construction	Specification Sheet	4.5.5	P
Insulation Elongation and Tensile Strength	Specification Sheet	4.5.9	P
Insulation Flaws	Specification Sheet and 3.5.5	4.5.10	100%
Insulation Material	Specification Sheet and 3.3.2	4.5.2	V
Insulation Resistance	Specification Sheet	4.5.11	Q
Insulation Thickness	Specification Sheet	AS4373, Method 101	P
Life Cycle	Specification Sheet and 3.5.6	4.5.12	Q
Low Temperature-Cold Bend	Specification Sheet and 3.5.7	4.5.13	P
Minimum Bend Radius	Specification Sheet and 3.5.8	4.5.14	Q
Shrinkage	Specification Sheet	4.5.15	P
Smoke Test	Specification Sheet	4.5.16	Q
Surface Resistance	Specification Sheet	4.5.17	Q
Thermal Shock Resistance	Specification Sheet and 3.5.9	4.5.18	P
Weight	Specification Sheet	AS22759	P
Workmanship	AS22759	AS22759	P
Wrap Test	Specification Sheet and 3.5.10	4.5.20	P

\*Inspection Class (see 4.2):

P = In-Process or Lot Test

100% = 100% Finished Product Test

Q = Qualification Test

V = Vendor Test

### 3.5.1 Color

Black or red is the preferred color. Color code designators and colored stripes, if used, shall be in accordance with MIL-STD-681.

### 3.5.2 Conductor Elongation

#### 3.5.2.1 AS29606 Conductor Stranding

For conductor composed of AS29606 stranding, the individual strands removed from finished cable, sizes 20 and larger, or the whole conductor removed from finished cable, sizes 22 and smaller, shall have the following minimum elongation when tested in accordance with 4.5.3.1:

Sizes 24 and smaller - 6 percent, minimum

Sizes 22 and larger - 10 percent, minimum

#### 3.5.2.2 High-Strand-Count Conductor Stranding

For high-strand-count conductor stranding, conductor having strand counts higher than AS29606 of the same wire size, the elongation shall be 5 percent, minimum average, for the whole stranded conductor of regular bunch constructions, or for one whole member from rope bunch constructions, as applicable, when removed from finished cable and tested in accordance with 4.5.3.2.

### 3.5.3 Crosslinking Proof Test

When finished cable is tested in accordance with 4.5.6, there shall be no cracking of the insulation and no dielectric breakdown.

### 3.5.4 Identification of Product

When specified by the procuring activity, finished cable shall be identified by a marking applied to the outer surface. The identification shall consist of the appropriate mark as specified by the contract or the applicable specification sheet. The mark color shall be contrasting to that of the marking surface. Identification shall be applied with the vertical axis of the printed characters parallel to the longitudinal axis of the cable when the nominal diameter of the marking surface is 0.050 inch (*1.3 mm*) or smaller. The vertical axis of the printed characters may be either perpendicular or parallel to the longitudinal axis of the cable when the nominal diameter of the marking surface exceeds 0.050 inch (*1.3 mm*).

### 3.5.5 Insulation Flaws

One hundred percent of finished cable shall pass the impulse dielectric test or the spark test specified in 4.5.10 using the voltage specified in the applicable specification sheet. Testing shall be performed during the final winding of the cable on shipment spools or reels.

### 3.5.6 Life Cycle

When finished cable is tested in accordance with 4.5.12, there shall be no cracking of the insulation and no dielectric breakdown.

### 3.5.7 Low Temperature-Cold Bend

When finished cable is tested in accordance with 4.5.13, there shall be no cracking of the insulation and no dielectric breakdown.

### 3.5.8 Minimum Bend Radius

The minimum bend radius of the finished cable shall be one half the diameter of the mandrel specified in the applicable specification sheet provided there is no cracking of the insulation and no dielectric breakdown when the finished cable is tested in accordance with 4.5.14.

### 3.5.9 Thermal Shock Resistance

When finished cable is tested in accordance with 4.5.18, the insulation shall not shrink or elongate more than that specified in the applicable specification sheet. There shall be no flaring of the insulation.

### 3.5.10 Wrap Test

When finished cable is tested in accordance with 4.5.20, there shall be no cracking of the insulation.

## 4. **QUALITY ASSURANCE PROVISIONS**

### 4.1 RESPONSIBILITY FOR INSPECTION

The supplier is responsible for the performance of all the inspection tests specified herein. The supplier may utilize his own or any other inspection facility and services acceptable to the buyer. Inspection records of the examinations and tests shall be kept complete and available to the buyer as required.

### 4.2 INSPECTION CLASSIFICATION

- a. Vendor Control (V): Requirements for raw materials such as conductor and insulation materials over which the vendor has control and responsibility.
- b. Process Control (P): Inspections performed on samples taken from the lots of cable. Inspections may be performed on finished cable or after the process which establishes the specified characteristic. The Quality Control Plan establishes the frequency of inspection based on process control data.
- c. One Hundred Percent (100%): Tests performed on the total length of each cable. Tests may be performed on the finished product or "in process", as applicable.
- d. Qualification (Q): Tests performed only at the time of initial qualification or requalification.

#### 4.3 QUALIFICATION INSPECTION

Qualification inspection shall consist of all tests listed in Table 1. Requalification testing shall be performed any time changes in materials or processes occur that are deemed to have the potential for significantly altering the form, fit, function, or appearance of the product.

##### 4.3.1 Sampling for Qualification Inspection

Qualification inspection shall be performed on samples of PWR0113-8-0 that have been taken from production lots manufactured under the most current Quality Control Plan.

#### 4.4 QUALITY CONFORMANCE INSPECTION

Quality conformance inspection consists of a series of tests and inspections that assure that raw materials and manufacturing processes are consistent and result in products that conform to specification requirements. Quality conformance tests and inspections are listed in Table 1, designated as "P", "V", or "100%", and shall be performed on every lot of cable procured under this specification.

#### 4.5 TEST METHODS

##### 4.5.1 Abrasion

Finished cable shall be tested in accordance with AS4373, Method 301, except that only four measurements (90 degree rotation between tests) shall be required.

##### 4.5.2 Certification of Materials

Prior to incorporation in a cable construction, incoming (raw) materials must meet internal procurement requirements that are not covered in this specification or the applicable specification sheet. Certificates of compliance shall be kept on file stating that the specified materials have been used and that they met all applicable requirements.

##### 4.5.3 Conductor Elongation

###### 4.5.3.1 AS29606 Conductor Stranding

Elongation tests of the conductor shall be tested in accordance with MIL-STD-2223, Method 5002, using a 10-inch (254-mm) initial jaw separation and a jaw separation speed of  $10 \pm 2$  inches ( $254 \pm 51$  mm) per minute. Elongation shall be determined by the distance the jaw has traveled. Breaks occurring at the jaws shall be discounted and a new specimen shall be tested.

###### 4.5.3.2 High-Strand-Count Conductor Stranding

For high-strand-count conductor, conductor having strand counts higher than AS29606 of the same wire size, elongation tests of the conductor shall be the same as specified in 4.5.3.1, except that the test shall be performed upon the whole conductor for regular bunch-stranded constructions, or upon one whole member removed from rope bunch-stranded constructions, as applicable, taken from the finished cable. In either case, elongation shall be measured upon breakage of the first strand of the whole conductor or member, as applicable.

#### 4.5.4 Crosslinking Proof Test

Crosslinking proof test shall be conducted in accordance with the life cycle test method of 4.5.12. The time and temperature specified for the crosslinking proof test on the applicable specification sheet shall be used.

#### 4.5.5 Examination of Product

All samples shall be examined carefully to determine conformance to this specification and to the applicable specification sheet with regard to requirements not covered by specific test methods.

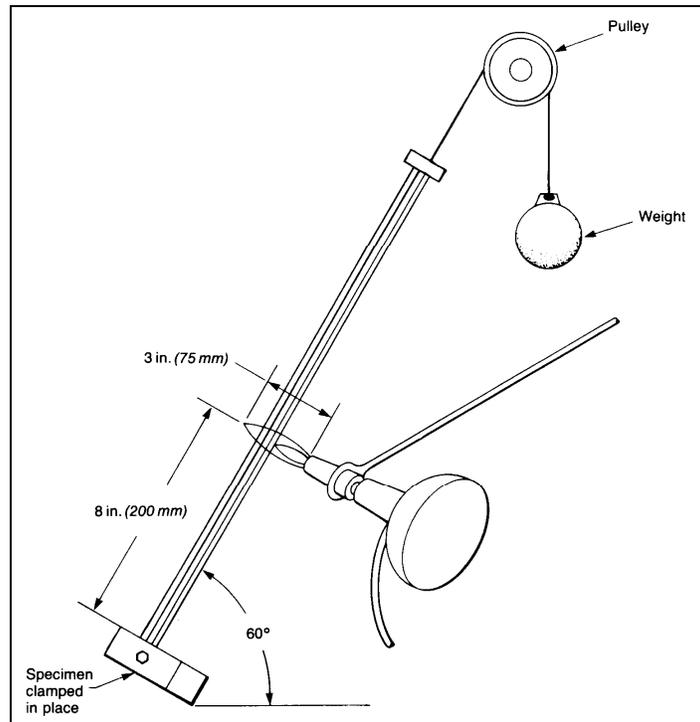
#### 4.5.6 Flammability

##### 4.5.6.1 Test Apparatus

The test shall be performed within a test chamber approximately 1 foot (*0.30 m*) square by 2 feet (*0.61 m*) in height, open at the top and front to provide adequate ventilation for combustion but to prevent drafts. The specimen holder shall be so designed that the lower end of a 24-inch (*610-mm*) specimen is held by a clamp, while the upper end of the specimen passes over a pulley and can be suitably weighted to hold the specimen taut at an angle of 60 degrees with the horizontal, in a plane parallel to and approximately 6 inches (*152 mm*) from the back of the chamber. The test flame shall originate from a Bunsen type gas burner with a 0.250-inch (*6.4-mm*) inlet, a needle valve in the base for gas adjustment, a nominal bore of 0.375 inch (*9.5 mm*), and a barrel length of approximately 4 inches (*102 mm*) above the air inlets. The burner shall be adjusted to furnish a 3-inch (*76-mm*) high conical flame with an inner cone approximately 1 inch (*25 mm*) in length and a flame temperature not less than 954°C at its hottest point, as measured with an accurate thermocouple pyrometer. A sheet of facial tissue conforming to UU-T-450 shall be suspended taut and horizontal 9.5 inches (*241 mm*) below the point of application of the flame to the specimen and at least 0.50 inch (*13 mm*) from the chamber floor, so that any material dripping from the specimen shall fall upon the tissue.

##### 4.5.6.2 Test Procedure

A 24-inch (*610-mm*) specimen shall be marked at a distance of 8 inches (*203 mm*) from its lower end to indicate the point for flame application and shall be placed in the specified 60-degree position in the test chamber. The lower end of the specimen shall be clamped in position in the specimen holder and the upper end shall be passed over the pulley of the holder with a weight attached that is equal to one half the test load specified for the life cycle test of the same wire in the applicable specification sheet. With the burner held perpendicular to the specimen and at an angle of 30 degrees from the vertical plane of the specimen (see Figure 1), the hottest portion of the flame shall be applied to the lower side of the specimen at the test mark. The period of test flame application shall be 30 seconds and the test flame shall be withdrawn immediately at the end of that period. The distance of flame travel upward along the specimen from the test mark and the time of burning after removal of the test flame shall be recorded; also the presence or absence of flame in the facial tissue due to incendiary dripping from the specimen. Charred holes or charred spots in the tissue shall be ignored in the absence of actual flame. Breaking of the cable specimens in size 24 or smaller shall not be considered as failure, provided the requirements for flame travel limits, duration of flame, and absence of incendiary dripping are met.



**FIGURE 1. FLAMMABILITY TEST APPARATUS  
(shown without chamber)**

#### 4.5.7 Humidity Resistance

A specimen of finished cable at least 26 feet (7.9 m) in length shall be tested in accordance with AS22759.

#### 4.5.8 Immersion

Specimens of finished cable of sufficient length to perform the subsequent tests in Table 2 shall have one inch (25 mm) of their insulation removed from each end. Specimens shall be measured at their midpoints to determine their initial diameters and shall then be immersed to within 6 inches (152 mm) of their ends in each of the fluids (using a separate specimen for each fluid) for the time and temperature specified in Table 2. During immersion, the coil diameter of the cable shall be the same as the mandrel size specified for the minimum bend radius in the applicable specification sheet. Upon removal from the fluids, the specimens shall remain for 1 hour in free air at room temperature. The diameters shall then be remeasured at the original point of measurement and compared to the initial diameters. The percent change in diameter shall then be calculated. The specimens shall then be subjected to the bend test (4.5.12.1) followed by the voltage withstand test (4.5.19).

**TABLE 2. IMMERSION TEST FLUIDS**

	Test Fluid	Test Temperature (°C)	Immersion Time
(a)	ASTM D 4814, Fuel	20 to 25	168 hours
(b)	MIL-PRF-5606, Hydraulic Fluid	48 to 50	20 hours
(c)	MIL-PRF-46170, Hydraulic Fluid	88 to 92	20 hours
(d)	TT-I-735, Isopropyl Alcohol	20 to 25	168 hours
(e)	SAE Grade 15W-40	88 to 92	20 hours
(f)	SAE Grade 30W	88 to 92	20 hours

#### 4.5.9 Insulation Elongation and Tensile Strength

Specimens of the entire insulation shall be carefully removed from the conductor and tested for elongation and tensile strength in accordance with FED-STD-228, Methods 3031 and 3021, respectively, using 1-inch (25-mm) bench marks, a 1.2-inch (30-mm) initial jaw separation, and a jaw separation speed of 2 inches (51 mm) per minute.

#### 4.5.10 Insulation Flaws

##### 4.5.10.1 Impulse Dielectric Test

Finished cable shall be tested in accordance with ASTM D 3032, Section 13, at the voltage specified in the applicable specification sheet with the conductor grounded at one end or both ends. When specified in the contract or order, dielectric failure, untested portions, or portions which have been exposed to fewer or more than the specified pulses may be marked by stripping the insulation or by any other suitable method of marking as specified in the contract in lieu of being cut out of the cable.

##### 4.5.10.2 Spark Test

Finished cable shall be passed through a chain electrode spark test device using the voltage specified in the applicable specification sheet at a frequency of 60 or 3000 Hz. The conductor shall be grounded at one or both ends. The electrode shall be of a suitable bead chain or fine mesh construction that will give intimate metallic contact with practically all of the cable surface. Electrode length and speed of specimen movement shall be such that the cable is subjected to the test voltage for a minimum of 0.2 second. Any portion showing breakdown shall be cut out, including at least 2 inches (51 mm) of insulation on each side of the failure.

#### 4.5.11 Insulation Resistance

The uninsulated ends of a cable specimen at least 26 feet (7.9 m) in length shall be connected electrically to a DC terminal. The specimen shall be immersed to within 6 inches (152 mm) of its ends in a water bath at  $25 \pm 5^\circ\text{C}$  containing 0.5 to 1.0 percent of an anionic wetting agent. After 4 hours minimum of immersion, the specimen shall be subjected to a potential of 250 to 500 volts applied between the conductor and the water bath, which serves as the second electrode. The insulation resistance of the specimen shall be determined after one minute of electrification at this potential and shall be calculated as follows:

$$\text{Megohms for 1000 feet} = \frac{\text{Specimen resistance (megohms)} \times \text{Immersed length (feet) (or meters)}}{1000}$$

(or  $M\Omega\text{-}1\text{ km}$ )

#### 4.5.12 Life Cycle

Four inches (102 mm) of insulation shall be removed from each end of a finished cable specimen having a length no less than 30 inches (762 mm). The central portion of the specimen then shall be bent at least halfway around a horizontally positioned smooth stainless steel mandrel of the diameter specified in the applicable specification sheet. To prevent sticking of the specimen to the mandrel, the mandrel shall be covered with polytetrafluoroethylene in the form of either a dispersion coating or wrapped tape, provided that the diameter of the mandrel still conforms to the applicable specification sheet. Each end of the conductor shall be loaded with the weight specified in the applicable specification sheet so that the portion of the insulation between the conductor and mandrel is under compression while the conductor is under tension. This specimen, so prepared on the mandrel, shall be conditioned in an air-circulating oven for the time and at the temperature specified in the applicable specification sheet. The velocity of air past the specimen (measured at room temperature) shall be not less than 100 feet (30 m) per minute. After conditioning, the oven shall be shut off, the door opened, and the specimen allowed to cool in the oven for at least 1 hour. When cool, the specimen shall be freed from tension, removed from the mandrel, and straightened. The specimen shall then be subjected to the bend test (4.5.12.1) followed by the voltage withstand test (4.5.19).

##### 4.5.12.1 Bend Test

At a temperature maintained between 20 and 25°C, one end of the cable specimen shall be secured to the mandrel and the other end to the weight specified in the applicable specification sheet. The mandrel shall be rotated until the full length of the specimen is wrapped around the mandrel and is under the specified tension with adjoining turns in contact. The mandrel shall then be rotated in the reverse direction until the full length of the specimen which was outside during the first wrapping is now next to the mandrel. This procedure shall be repeated until two bends in each direction have been formed in the same section of the specimen. The specimen shall then be examined for cracking of the insulation.

#### 4.5.13 Low Temperature-Cold Bend

A specimen of finished cable shall be tested in accordance with the insulation low temperature resistance test specified in AS22759 at  $-65 \pm 2^\circ\text{C}$  for 4 hours, except the diameter of the mandrel and the test load shall be as specified in the applicable specification sheet.

#### 4.5.14 Minimum Bend Radius

One inch (25 mm) of insulation shall be removed from each end of a sufficient length of finished cable. The center portion of the specimen shall be wound 2 times around a mandrel having a diameter as specified in the applicable specification sheet. The ends of the specimen shall extend at least 6 inches (152 mm) beyond the wound portion and shall be secured to each other. The specimen shall then be removed from the mandrel without unwinding and shall be conditioned in an air-circulating oven for the time and at the temperature specified in the applicable specification sheet. After conditioning, the oven shall be shut off, the door opened, and the specimen allowed to cool in the oven for at least 1 hour. When cool, the specimen shall be removed from the oven and visually examined, without magnification, for cracks. The specimen shall then be subjected to the voltage withstand test (4.5.19).

#### 4.5.15 Shrinkage

A specimen of finished cable shall be tested in accordance with the insulation shrinkage test specified in AS22759 using the oven temperature specified in the applicable specification sheet.

#### 4.5.16 Smoke Test

A specimen of finished cable shall be tested in accordance with the smoke resistance test specified in AS22759 with the conductor temperature stabilized at the temperature specified in the applicable specification sheet.

#### 4.5.17 Surface Resistance

A specimen of finished cable shall be tested in accordance with MIL-STD-2223, Method 3004, except that the required humidity shall be maintained by ASTM E 104, Method A, and without instrumentation of the chamber. All specimens, after having been provided with the required electrodes, but prior to testing, shall be cleaned by the procedure described in the test method. The specimens shall be positioned in the test chamber so that their ends are at least 1 inch (25 mm) from any wall of the chamber.

#### 4.5.18 Thermal Shock Resistance

A specimen of finished cable shall be tested in accordance with the insulation thermal shock test specified in AS22759 using the oven temperature specified in the applicable specification sheet.

#### 4.5.19 Voltage Withstand (Post Environmental)

The uninsulated ends of the specimen shall be attached to an electric lead. The specimen shall be immersed in a 5-percent, by weight, solution of sodium chloride in water at 20 to 25°C, except that the uninsulated ends and 1.5 inches (38 mm) of insulated cable at each end of the specimen shall protrude above the surface of the solution. After immersion for 5 hours, the voltage specified in the applicable specification sheet at 60 Hz shall be applied between the conductor and the water bath which shall be grounded. The voltage shall be gradually increased at a uniform rate from zero to the specified voltage in 0.5 minute, maintained at that voltage for a period of 5 minutes, and gradually reduced to zero in 0.5 minute.

#### 4.5.20 Wrap Test

A specimen of finished cable shall be tested in accordance with the insulation wrap test specified in AS22759 for extruded insulation using the oven temperature and diameter of the mandrel specified in the applicable specification sheet.

## 5. STANDARD PACKAGING

Unless otherwise specified (see 6.1), the following shall define the standard spooling and labeling requirements for cable furnished under this specification. Standard shipping tolerance on ordered quantity shall be  $\pm 10$  percent.

### 5.1 SPOOLING REQUIREMENTS

All layers of cable shall be wound on spools or reels (see 5.1.2) with sufficient tension to prevent shifting of layers and creation of crossovers within layers.

#### 5.1.1 Finished Cable

Finished cable lengths shall be wound on spools or reels with the ends spliced together to provide one mechanically and electrically continuous length. Unless otherwise specified, the minimum continuous length between splices shall be in accordance with Table 3.

**TABLE 3. FINISHED CABLE LENGTHS**

Cable Size Range (AWG)	Minimum Length
30 through 10	100 feet (30 m)
8 and larger	50 feet (15 m)

(NOTE: Metric lengths specified above apply only to those orders placed in metric.)

#### 5.1.2 Spools and Reels

Spools and reels shall be of a nonreturnable type. Each spool and reel shall have an appropriate diameter for the respective cable size. In no case shall the barrel of the spool or reel have a diameter less than 3.5 inches (89 mm). Spools and reels shall be suitably finished to prevent corrosion under typical storage and handling conditions. Loaded plastic spools shall not exceed 50 pounds (23 kg). Loaded wooden reels shall have no weight restriction.

#### 5.1.3 Containers

Unless otherwise specified (see 6.1), finished cable shall be delivered in standard commercial containers so constructed as to ensure acceptance by common or other carrier for safe transportation at the lowest rate to the point of delivery.

### 5.2 LABELING REQUIREMENTS

All spools and reels shall be identified with the following information:

Manufacturer's Part Number  
 Lot Number  
 Quantity in Feet (or Meters)  
 Name of Manufacturer

## 6. NOTES

### 6.1 ORDERING DATA

Procurement documents should specify the following:

- a. Title, number, and revision of this specification
- b. Applicable specification sheet part number
- c. Quantity
- d. Special preparation for delivery requirements, if applicable (see Section 0)

### 6.2 METRIC UNITS

Metric units (where shown in parentheses) are for information only.

### 6.3 TRADEMARKS

Raychem, TE Connectivity, TE connectivity (logo), and TE (logo) are trademarks.