



IEC 60317-27-4

Edition 1.1 2024-06
CONSOLIDATED VERSION

INTERNATIONAL STANDARD



Specifications for particular types of winding wires –
Part 27-4: Paper tape covered rectangular aluminium wire

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IEC Secretariat
3, rue de Varembe
CH-1211 Geneva 20
Switzerland

Tel.: +41 22 919 02 11
info@iec.ch
www.iec.ch

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CONTENTS

FOREWORD.....	3
INTRODUCTION.....	5
1 Scope.....	6
2 Normative references	6
3 Terms, definitions, general notes and appearance.....	6
3.1 Terms and definitions.....	6
3.2 General notes	7
3.2.1 Methods of test.....	7
3.2.2 Winding wire.....	7
3.3 Appearance	7
4 Dimensions.....	7
4.1 Conductor dimensions	7
4.2 Tolerance on conductor dimensions	7
4.3 Rounding of corners.....	7
4.4 Increase in dimensions due to paper tape covering.....	7
4.5 Maximum overall dimensions	8
5 Electrical resistance	8
6 Elongation	8
7 Springiness	8
8 Flexibility and adherence.....	8
9 Heat shock	8
10 Cut-through	8
11 Resistance to abrasion	9
12 Resistance to solvents.....	9
13 Breakdown voltage	9
14 Continuity of insulation	9
15 Temperature index	9
16 Resistance to refrigerants.....	9
17 Solderability	9
18 Heat or solvent bonding.....	9
19 Dielectric dissipation factor.....	9
20 Resistance to hydrolysis and to transformer oil.....	9
21 Loss of mass	9
23 Pin hole test	9
30 Packaging	10
Bibliography.....	11
Table 1 – Increase in dimensions.....	8

INTERNATIONAL ELECTROTECHNICAL COMMISSION

SPECIFICATIONS FOR PARTICULAR TYPES OF WINDING WIRES –

Part 27-4: Paper tape covered rectangular aluminium wire

FOREWORD

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This consolidated version of the official IEC Standard and its amendment has been prepared for user convenience.

IEC 60317-27-4 edition 1.1 contains the first edition (2020-05) [documents 55/1837/FDIS and 55/1859/RVD] and its amendment 1 (2024-06) [documents 55/1987/CDV and 55/2025/RVC].

In this Redline version, a vertical line in the margin shows where the technical content is modified by amendment 1. Additions are in green text, deletions are in strikethrough red text. A separate Final version with all changes accepted is available in this publication.

International Standard IEC 60317-27-4 has been prepared by IEC technical committee 55: Winding wires.

This document has been drafted in accordance with the ISO/IEC Directives, Part 2.

This International Standard is to be used in conjunction with IEC 60317-0-9:2015 and its Amendment 1:2024.

A list of all parts in the IEC 60317 series, published under the general title *Specifications for particular types of winding wires*, can be found on the IEC website.

The numbering of clauses in this standard is not continuous from Clauses 21 through 30 in order to reserve space for possible future wire requirements prior to those for wire packaging.

The committee has decided that the contents of this document and its amendment will remain unchanged until the stability date indicated on the IEC website under webstore.iec.ch in the data related to the specific document. At this date, the document will be

- reconfirmed,
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INTRODUCTION

This part of IEC 60317 forms an element of a series of standards which deals with insulated wires used for windings in electrical equipment. It is composed of the following series:

- 1) *Winding wires – Test methods* (IEC 60851 series);
- 2) *Specifications for particular types of winding wires* (IEC 60317 series);
- 3) *Packaging of winding wires* (IEC 60264 series).

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SPECIFICATIONS FOR PARTICULAR TYPES OF WINDING WIRES –

Part 27-4: Paper tape covered rectangular aluminium wire

1 Scope

This part of IEC 60317 specifies the requirements of paper tape covered rectangular aluminium winding wires. This covering consists of two or more layers of paper tape and is primarily intended for winding coils for oil immersed transformers.

The range of nominal conductor dimensions covered by this document is:

- width: min. 2,00 mm max. 16,0 mm;
- thickness: min. 0,80 mm max. 5,60 mm.

The paper tapes included in this document are restricted to those specified in IEC 60554-1 and IEC 60554-3-5.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 60317-0-9:2015, *Specifications for particular types of winding wires – Part 0-9: General requirements – Enamelled rectangular aluminium wire*
IEC 60317-0-9:2015/AMD1:2024

IEC 60554-1, *Specification for cellulosic papers for electrical purposes – Part 1: Definitions and general requirements*

IEC 60554-3-5, *Specification for cellulosic papers for electrical purposes – Part 3: Specifications for individual materials – Sheet 5: Special papers*

3 Terms, definitions, general notes and appearance

3.1 Terms and definitions

For the purposes of this document, the terms and definitions given in IEC 60317-0-9 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
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3.1.1 covering

material which is wound, wrapped or braided around a bare or insulated conductor

[SOURCE: IEC 60317-0-6:2020, 3.1.3]

3.2 General notes

3.2.1 Methods of test

Subclause 3.2.1 of IEC 60317-0-9:2015/AMD1:2024 applies. In case of inconsistency between IEC 60317-0-9:2015 and this document, IEC 60317-27-4 shall prevail.

3.2.2 Winding wire

The number of paper tapes, type of paper, paper tape thickness, and the degree of overlap shall be agreed upon between the purchaser and supplier.

When a reference is made to winding wire according to this document, the following information shall be given in the description:

- reference to IEC 60317-27-4;
- nominal conductor dimensions in millimetres (width × thickness);
- nominal increase in dimensions due to paper.

EXAMPLE: IEC 60317-27-4 4,00 × 1,00 + 0,20

- (Eventually) Proof stress minimum (and maximum) value

EXAMPLE: IEC 60317-0-9 4,00 × 1,00 + 0,20

IEC 60317-0-9 7,00 × 2,50 + 1,00 R p0,2 = 150 MPa

3.3 Appearance

The conductor shall be essentially free from aluminium dust and other extraneous matter when examined with normal vision, as wound on the original spool or reel. The paper covering shall be of one or more tapes wrapped firmly, closely, evenly, and continuously around the conductor.

No bonding or adhesive material shall be used except to anchor the ends of paper tapes.

4 Dimensions

4.1 Conductor dimensions

Subclause 4.1 of IEC 60317-0-9:2015 applies.

4.2 Tolerance on conductor dimensions

Subclause 4.2 of IEC 60317-0-9:2015 applies.

4.3 Rounding of corners

Subclause 4.3 of IEC 60317-0-9:2015 applies.

4.4 Increase in dimensions due to paper tape covering

The increase in width or thickness due to the paper tape covering shall be agreed between purchaser and supplier and the minus tolerance shall not exceed the values given in Table 1.

The increase in width due to the paper covering shall be equal to or less than the increase in thickness.

The maximum increase may be exceeded, provided that the maximum overall dimension does not exceed the sum of the maximum dimensions of the conductor plus the maximum increase given in Table 1.

Table 1 – Increase in dimensions

Increase in diameters due to the paper covering mm		Tolerance %
Over	Up to and including	
-	0,50	-10 0
0,50	1,25	-7,5 0
1,25	-	-5 0

4.5 Maximum overall dimensions

The overall dimensions shall not exceed the sum of the maximum bare dimensions given in 4.2 and the maximum increase in dimensions permitted in 4.4.

5 Electrical resistance

Clause 5 of IEC 60317-0-9:2015 and IEC 60317-0-9:2015/AMD1:2024 applies.

6 Elongation

Clause 6 of IEC 60317-0-9:2015 applies.

NOTE When the value of the proof strength of the aluminium is specified between minimum and maximum limits, the requirements are agreed upon between the purchaser and supplier. The description of the term “proof strength” and the method of determination are given in ISO 6892-1:2016.

7 Springiness

~~Test appropriate but no requirements specified.~~

Test inappropriate.

8 Flexibility and adherence

Because of the great variation in the number and the thickness of papers applied, the requirements for flexibility shall be agreed between purchaser and supplier at the time of placing the order.

9 Heat shock

Test inappropriate.

10 Cut-through

Test inappropriate.

11 Resistance to abrasion

Test inappropriate.

12 Resistance to solvents

Test inappropriate.

13 Breakdown voltage

Test inappropriate.

14 Continuity of insulation

Test inappropriate.

15 Temperature index

Test requirements under consideration.

16 Resistance to refrigerants

Test inappropriate.

17 Solderability

Test inappropriate.

18 Heat or solvent bonding

Test inappropriate.

19 Dielectric dissipation factor

Test inappropriate.

20 Resistance to hydrolysis and to transformer oil

Test appropriate but no requirements specified.

21 Loss of mass

Test inappropriate.

23 Pin hole test

Test inappropriate.

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30 Packaging

The kind of packaging can influence certain properties of the wire, for example flexibility and adherence. Therefore, the kind of packaging, for example the type of spool, shall be agreed between purchaser and supplier.

The wire shall be evenly and compactly wound on spools. Where wires are delivered in coils, the dimensions and the maximum masses of such coils shall be agreed between purchaser and supplier. Any additional protection for coils shall also be agreed between purchaser and supplier.

A clearance of at least 25 mm shall be arranged between the outermost layer and the periphery of the spool flange. Where there is a requirement for a protective paper between the layers and between the wire and the spool, this shall be agreed between the purchaser and the supplier. Marking of the label when there is more than one length, identification of the separate lengths and identification of joints shall also be by agreement between the purchaser and supplier.

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IEC 60264 (all parts), *Packaging of winding wires*

IEC 60317 (all parts), *Specifications for particular types of winding wires*

IEC 60317-0-6:2020, *Specifications for particular types of winding wires – Part 0-6: General requirements – Glass-fibre wound resin or vanish impregnated, bare or enamelled round copper wire*

IEC 60851 (all parts), *Winding wires – Test methods*

ISO 6892-1:2016, *Metallic materials – Tensile testing – Part 1: Method of test at room temperature*

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CONTENTS

FOREWORD.....	3
INTRODUCTION.....	5
1 Scope.....	6
2 Normative references	6
3 Terms, definitions, general notes and appearance.....	6
3.1 Terms and definitions.....	6
3.2 General notes	7
3.2.1 Methods of test.....	7
3.2.2 Winding wire.....	7
3.3 Appearance	7
4 Dimensions.....	7
4.1 Conductor dimensions	7
4.2 Tolerance on conductor dimensions.....	7
4.3 Rounding of corners.....	7
4.4 Increase in dimensions due to paper tape covering.....	7
4.5 Maximum overall dimensions	8
5 Electrical resistance	8
6 Elongation	8
7 Springiness	8
8 Flexibility and adherence.....	8
9 Heat shock	8
10 Cut-through	8
11 Resistance to abrasion	8
12 Resistance to solvents.....	9
13 Breakdown voltage	9
14 Continuity of insulation	9
15 Temperature index	9
16 Resistance to refrigerants.....	9
17 Solderability	9
18 Heat or solvent bonding.....	9
19 Dielectric dissipation factor.....	9
20 Resistance to hydrolysis and to transformer oil.....	9
21 Loss of mass	9
23 Pin hole test	9
30 Packaging	9
Bibliography.....	11
Table 1 – Increase in dimensions.....	8

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IEC 60554-3-5, *Specification for cellulosic papers for electrical purposes – Part 3: Specifications for individual materials – Sheet 5: Special papers*

3 Terms, definitions, general notes and appearance

3.1 Terms and definitions

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3.1.1 covering

material which is wound, wrapped or braided around a bare or insulated conductor

[SOURCE: IEC 60317-0-6:2020, 3.1.3]

3.2 General notes

3.2.1 Methods of test

Subclause 3.2.1 of IEC 60317-0-9:2015/AMD1:2024 applies. In case of inconsistency between IEC 60317-0-9 and this document, IEC 60317-27-4 shall prevail.

3.2.2 Winding wire

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When a reference is made to winding wire according to this document, the following information shall be given in the description:

- reference to IEC 60317-27-4;
- nominal conductor dimensions in millimetres (width × thickness);
- nominal increase in dimensions due to paper.

EXAMPLE: IEC 60317-27-4 4,00 × 1,00 + 0,20

- (Eventually) Proof stress minimum (and maximum) value

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IEC 60317-0-9 7,00 × 2,50 + 1,00 R p0,2 = 150 MPa

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No bonding or adhesive material shall be used except to anchor the ends of paper tapes.

4 Dimensions

4.1 Conductor dimensions

Subclause 4.1 of IEC 60317-0-9:2015 applies.

4.2 Tolerance on conductor dimensions

Subclause 4.2 of IEC 60317-0-9:2015 applies.

4.3 Rounding of corners

Subclause 4.3 of IEC 60317-0-9:2015 applies.

4.4 Increase in dimensions due to paper tape covering

The increase in width or thickness due to the paper tape covering shall be agreed between purchaser and supplier and the minus tolerance shall not exceed the values given in Table 1.

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Table 1 – Increase in dimensions

Increase in diameters due to the paper covering mm		Tolerance %
Over	Up to and including	
-	0,50	-10 0
0,50	1,25	-7,5 0
1,25	-	-5 0

4.5 Maximum overall dimensions

The overall dimensions shall not exceed the sum of the maximum bare dimensions given in 4.2 and the maximum increase in dimensions permitted in 4.4.

5 Electrical resistance

Clause 5 of IEC 60317-0-9:2015 and IEC 60317-0-9:2015/AMD1:2024 applies.

6 Elongation

Clause 6 of IEC 60317-0-9:2015 applies.

NOTE When the value of the proof strength of the aluminium is specified between minimum and maximum limits, the requirements are agreed upon between the purchaser and supplier. The description of the term "proof strength" and the method of determination are given in ISO 6892-1:2016.

7 Springiness

Test inappropriate.

8 Flexibility and adherence

Because of the great variation in the number and the thickness of papers applied, the requirements for flexibility shall be agreed between purchaser and supplier at the time of placing the order.

9 Heat shock

Test inappropriate.

10 Cut-through

Test inappropriate.

11 Resistance to abrasion

Test inappropriate.