

AMENDMENT NO. 1 SEPTEMBER 2024
TO
IS 13730 (PART 21) : 2017/IEC 60317-21 : 2013 SPECIFICATIONS FOR
PARTICULAR TYPES OF WINDING WIRES
PART 21 SOLDERABLE POLYURETHANE ENAMELLED ROUND COPPER
WIRE OVERCOATED WITH POLYAMIDE, CLASS 155

This amendment of IS 13730 (Part 21) : 2017 is identical to Amendment No. 1 (2019) of IEC 60317-21 : 2013 issued by International Electrotechnical Commission (IEC).

17 Solderability

Replace the content of this clause by the following:

17.1 General

The temperature of the solder bath shall be (390 ± 5) °C. The surface of the tinned wire shall be smooth and free from holes and enamel residues.

17.2 Nominal conductor diameters up to and including 0,100 mm

The maximum immersion time shall be 2 s.

17.3 Nominal conductor diameters over 0,100 mm

The maximum immersion time (in seconds) shall be the following multiple of the nominal conductor diameter (in millimetres) with a minimum of 2 s.

Grade 1	Grade 2
8 s/mm	12 s/mm