

**AMENDMENT NO. 1 DECEMBER 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  $(390 \pm 5)$  °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