CABLE, LOW TENSION, VINYL INSULATED, 105 °C, THIN WALL, BARE — **WSK-M1L124-A**

CABLE, LOW TENSION, VINYL INSULATED, 90 °C, STANDARD WALL, BARE — **WSK-M1L124-B**

CABLE, LOW TENSION, VINYL INSULATED, 105 °C, THIN WALL, TINNED — **WSK-M1L125-A**

1. SCOPE

The materials defined by these specifications are low tension stranded cables, vinyl-insulated conductors. The cables are similar to ISO 6722 with a standard and thin wall insulation thickness.

2. APPLICATION

These specifications were released originally for materials used in automotive electrical harnesses.

Note: The assemblers of electrical wire harnesses shall use the bulk wire suppliers as shown in the Ford Motor Company Approved Source List.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 CABLE

3.2.1 Specimen Length 1.2 m

3.2.2 The maximum outside diameter shall be determined by taking measurements at three points along the conductor length separated by at least 100 mm and recording the greatest overall diameter at each point. No single value shall exceed the maximum overall diameter as specified in Tables 2a, 2b, and 2c.

3.3 CONDUCTOR

3.3.1 The conductor of all cable classes shall consist of bunched or stranded soft annealed copper wires.

3.3.2 Specimen Length 1.2 m

3.3.3 Three sections 10 mm long and separated by at least 400 mm shall be cut from the specimen. Carefully remove the conductor without deformation of the insulation.

Date	Action	Revisions
2003 08 18	Revised	Para 3.0 inserted; Para 3.1, 3.20, 3.21, 3.22, 4 deleted
1997 06 05	Revised	Rev. Title, 3.8-11,Table 2c , Del.3.5;Upd. P.Seuchy
1990 06 11	EE00I10063626003	Released MD/PL-10 U. /Schwarz

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3.3.4 The conductor diameter shall be determined by measuring the inside diameter of the insulation taken at three points separated by at least 300 mm and recording the maximum inside diameter at each point. The measurements shall be made with an optical device accurate to at least 0.01 mm. No value shall exceed the maximum diameter of the conductor specified in Tables 2a, 2b, and 2c.

3.3.5 The conductor area may be determined by measuring individual strand diameters and calculating the sums of the individual strand areas. As an alternate method, conductor area may also be determined in accordance with FLTM BB 105-01 or by measuring the resistance in accordance with Tables 1 and 2c.

3.3.6 The strands shall be bunched and the maximum lay length shall be a maximum of 50 times the conductor diameter. Minimum number of wires shall comply with Tables 1 and 2c. Maximum variation between individual strand diameters must not exceed 10% per the following:

$$\text{Variation} = \frac{\text{max strand diameter - min strand diameter}}{\text{min strand diameter}}$$

Missing strands are not allowed.

3.3.7 Elongation
(ASTM B 3, prior to bunching)

for d =/- 0.287 mm	e > 15%
for d > 0.287 mm	e > 20%

where: d = individual strand diameter
e = elongation of individual strand.

3.3.8 Resistivity, max
(ASTM B 193, at 20 °C)

Bare	1.7094 μΩ/cm
Tinned	1.7593 μΩ/cm

3.4 INSULATION

3.4.1 The insulating material shall be polyvinyl chloride (PVC) material, homogeneous in character. The surface shall be smooth and even without cracks, knots, blisters, or other faults.

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3.4.2 The color of the cables are per the Munsell Color Coding System and shall conform to Table 3. The following method shall be used to evaluate the color of the cables.

Comparison must be made by a person with normal or corrected vision, under cool white fluorescent lighting. The surface being inspected and the tolerance set must be in the same plane. Cable samples must be placed flat, overlapping the color standard. Color tolerance Reference Sets are available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

As an alternative, the color of the cables can be per the DIN 47002 or IEC 304 and shall conform to Table 4.

3.4.3 The minimum insulation thickness shall be determined by taking measurements at three points separated by at least 100 mm and recording the minimum insulation thickness at each point. The thickness shall be measured with an optical device accurate to at least 0.01 mm. No single value shall be lower than the minimum insulation thickness specified in Tables 2a, 2b, and 2c.

3.5 FAULT TESTING OF THE COMPLETE DELIVERY (in process testing)

3.5.1 When pulling the grounded dry cable through the test electrodes connected to the test voltage, there must be no punctures. The test electrodes may consist of a coil, a metal tube, metal ball chains or any other type of suitable electrode.

3.5.2 Test Voltage

For wires =/- 0.5 mm^2	3 kVeff
For wires > 0.5 mm^2	5 kVeff

The power supply shall be a transformer delivering a sinusoidal voltage. The electrode length and the frequency of the AC voltage shall be chosen, considering the speed of cable running through the field of the electrode, so that each point of the cable shall be loaded by at least nine voltage cycles. If in place of a sinusoidal voltage unidirectional pulses are applied, there must be 18 pulses on each point of the cable.

3.6 DURATION TEST VOLTAGE AND BREAKDOWN VOLTAGE

(FLTM BB 101-12, The cable must not be punctured.)

3.6.1	Specimen Length	1.2 m

3.7 INSULATION RESISTIVITY

(FLTM BB 101-13)

3.7.1	Specimen Length	5 m
3.7.2	Volume Resistivity, min	2 megaohm/m

3.8 INSULATION COMPRESSION TEST AT HIGH TEMPERATURE

(FLTM BB 101-14)

3.8.1	Specimen Length	100 mm

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