



UL 1063

STANDARD FOR SAFETY

Machine-Tool Wires and Cables

UL Standard for Safety for Machine-Tool Wires and Cables, UL 1063

Ninth Edition, Dated August 2, 2023

SUMMARY OF TOPICS:

This new Ninth Edition of ANSI/UL 1063 dated August 2, 2023 includes the addition of odd AWG sizes and other clarifications.

The new and revised requirements are substantially in accordance with Proposal(s) on this subject dated March 31, 2023.

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AUGUST 2, 2023



ANSI/UL 1063-2023

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UL 1063

Standard for Machine-Tool Wires and Cables

First Edition – July, 1972
Second Edition – March, 1976
Third Edition – June, 1981
Fourth Edition – December, 1986
Fifth Edition – September, 1993
Sixth Edition – July, 1998
Seventh Edition – December, 2006
Eighth Edition – July, 2017

Ninth Edition

August 2, 2023

This ANSI/UL Standard for Safety consists of the Ninth Edition.

The most recent designation of ANSI/UL 1063 as an American National Standard (ANSI) occurred on August 2, 2023. ANSI approval for a standard does not include the Cover Page, Transmittal Pages, and Title Page.

Comments or proposals for revisions on any part of the Standard may be submitted to ULSE at any time. Proposals should be submitted via a Proposal Request in the Collaborative Standards Development System (CSDS) at <https://csds.ul.com>.

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INTRODUCTION

1 Scope

1.1 These requirements cover all-thermoplastic Type MTW, 600-V, machine-tool wires and cables for use as specified in the National Electrical Code (NFPA 70), and in the National Fire Protection Association Electrical Standard for Industrial Machinery (NFPA 79). These wires and cables comply with a flame test and are for use at 90 °C (194 °F) and lower temperatures in dry locations and at 60 °C (140 °F) and lower temperatures where exposed to moisture, oil, or coolants such as cutting oils and the like.

1.2 The two single-conductor constructions covered are described in [Table 1.1](#). Both are PVC-insulated and one includes a nylon jacket over the insulation. These single-conductor constructions may be optionally shielded and jacketed. The multiple-conductor constructions covered consist of assemblies of these single-conductor constructions (sizes and styles may be mixed) enclosed by a PVC jacket.

Table 1.1
Single-Conductor Constructions

Conductor ^a size AWG or kcmil	NEC Construction A (Nylon jacket not used)				NEC Construction B					
	Minimum average thickness of the insulation		Minimum thickness of any point of the insulation		Minimum average thickness of the insulation		Minimum thickness of any point of the insulation		Minimum thickness of any point of nylon jacket	
	Mils	(mm)	Mils	(mm)	Mils	(mm)	Mils	(mm)	Mils	(mm)
22, 7-strand only; 21 – 12	30	(0.76)	27	(0.69)	15	(0.38)	13	(0.33)	4	(0.10)
11 – 10	30	(0.76)	27	(0.69)	20	(0.51)	18	(0.46)	4	(0.10)
9, 8	45	(1.14)	40	(1.02)	30	(0.76)	27	(0.69)	5	(0.13)
7, 6	60	(1.52)	54	(1.37)	30	(0.76)	27	(0.69)	5	(0.13)
5 – 2	60	(1.52)	54	(1.37)	40	(1.02)	36	(0.91)	6	(0.15)
1 – 4/0	80	(2.03)	72	(1.83)	50	(1.27)	45	(1.14)	7	(0.18)
250 – 500	95	(2.41)	86	(2.18)	60	(1.52)	54	(1.37)	8	(0.20)
550 – 1000	110	(2.79)	99	(2.51)	70	(1.78)	63	(1.60)	9	(0.23)
^a A conductor is appropriate for use with a cross-sectional area that does not correspond to one of the AWG or kcmil sizes in Table 6.2 when the finished wire or cable complies with the marking requirement in 30.2 and with each of the following: a) The conductor shall have a DC resistance that is not larger than the resistance determined by interpolation (by cross-sectional area) between the resistances of the next larger and smaller sizes shown in the applicable Table 6.7 or Table 6.8. b) The number of strands, the thicknesses of insulation, the thickness of any nylon jacket, and other particulars shall comply with the requirements applicable to the next smaller size shown in Table 6.2.										

2 Units of Measurement

2.1 When a value for measurement is followed by a value in other units in parentheses, the second value may be only approximate. The first stated value is the requirement.

3 References

3.1 Any undated reference to a code or standard appearing in the requirements of this standard shall be interpreted as referring to the latest edition of that code or standard.

4 Terms

4.1 Wherever the designation "UL 1581" is used in this wire standard, reference is to be made to the designated part(s) of the Reference Standard for Electrical Wires, Cables, and Flexible Cords (UL 1581). Wherever the designation "UL 2556" is used in this wire standard, reference is to be made to the designated part(s) of the Standard for Wire and Cable Test Methods, (UL 2556).

CONSTRUCTION

5 General

5.1 Materials

5.1.1 Each material used in a machine-tool wire or cable shall be compatible with all of the other materials used in the wire or cable.

5.2 PVC

5.2.1 Wherever "PVC" appears in these requirements the intention is to designate a synthesized compound whose characteristic constituent is polyvinyl chloride or a copolymer of vinyl chloride and vinyl acetate.

6 Conductors

6.1 Metal

6.1.1 Each conductor shall be only of stranded soft-annealed copper with or without continuous coating of tin applied before the conductor is stranded or insulated.

6.1.2 Each strand in a bare copper conductor shall comply with the requirements of ASTM B3.

6.1.3 Each strand in a tin-coated conductor shall comply with the requirements of ASTM B33.

6.2 Sizes

6.2.1 Conductors shall not be smaller than 22 AWG and shall not be larger than 1000 kcmil.

6.2.2 The size of each conductor shall be verified either by determination of the DC resistance or by determination of the cross-sectional area as described in [6.6.1](#). Determination of the conductor size by measurement of the direct-current resistance as described in [6.7.1](#) is the referee method in all cases.

6.3 Number and assembly of strands and conductor diameters

6.3.1 Conductors shall be stranded with at least the number of strands indicated in the applicable [Table 6.3](#), [Table 6.4](#), or [Table 6.5](#). A 19-wire combination round-wire unilay-stranded soft-annealed copper conductor shall be round and shall consist of a straight central wire, an inner layer of six wires of the same diameter as the central wire with the six wires having identical lengths of lay, and an outer layer consisting of six wires of the same diameter as the central wire alternated with six smaller wires having a diameter of 0.732 times the diameter of the central wire and with all twelve wires of the outer layer having the same length of lay and direction of lay as the six wires of the inner layer. Otherwise, no particular assembly of the individual strands is required; however, untwisted strands shall not be used for the entire conductor or any part thereof. Class B or C 16 AWG – 1000 kcmil conductors shall be with or without compressed strands. Compressed stranding shall not be used in the Size 22 AWG, 7 strand construction, or in the Class K and

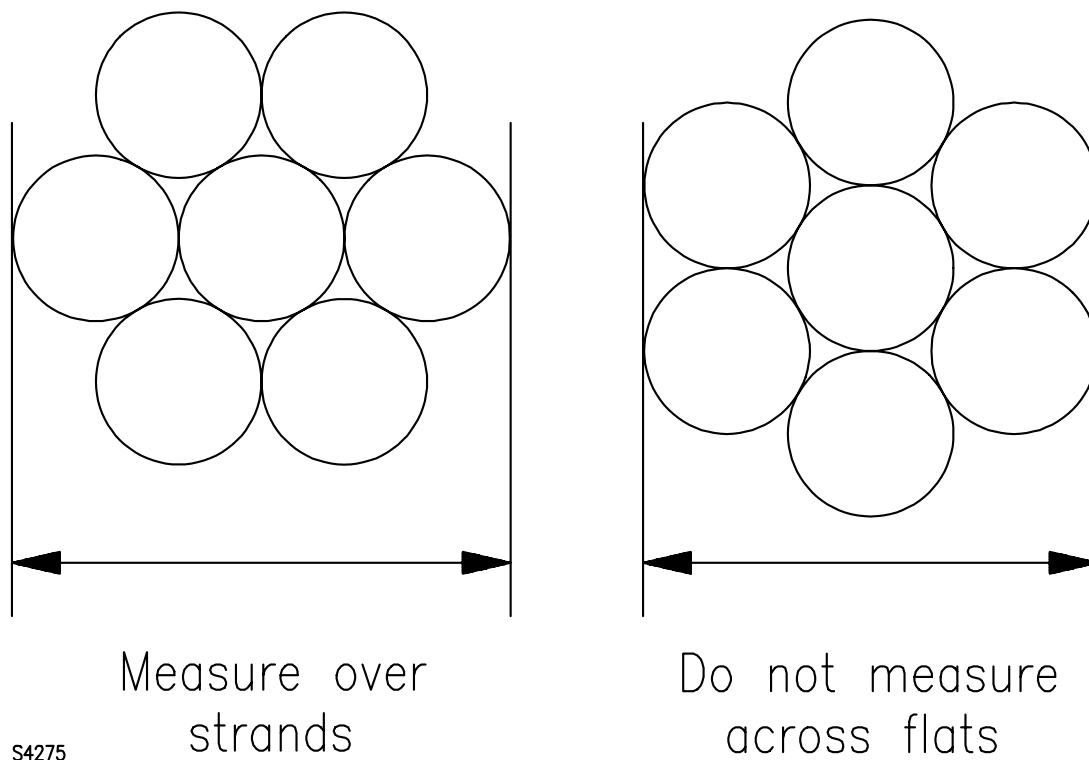
M constructions. Only single-bunch, bunch stranding and the concentric, rope-lay, and 19-wire combination unilay assemblies indicated in [Table 6.3](#), [Table 6.4](#), and [Table 6.5](#) shall be used. Compact stranding shall not be used.

6.3.2 A compressed round concentric-lay-stranded conductor shall be a round conductor consisting of a central core wire surrounded by one or more layers of helically laid wires with, for the 6 AWG – 1000 kcmil sizes, the direction of lay reversed in successive layers or unilay or unidirectional lay. The direction of lay of the outer layer shall be left-hand in all cases. The strands of one or more layers shall be slightly compressed by rolling, drawing, or other means to slightly change the originally round strands to various shapes that fill some of the spaces originally present between the strands.

6.3.3 A finished compressed-stranded Class B or C conductor shall not be larger in average diameter than the maximum diameter indicated for the size under Y in [Table 6.3](#) and shall not be smaller in average diameter than the minimum diameter indicated for the size under Z in [Table 6.3](#). Class B or C 16 AWG – 1000 kcmil conductors with uncompressed strands shall not be larger or smaller in average diameter than the maximum and minimum diameters indicated for the size in Tables 20.4 (Class B) and 20.4.1 (Class C) of UL 1581. The average diameter of the conductor is to be determined and compared with the table in the manner described in [6.3.4](#) and [6.3.5](#). Class B 1 AWG – 1000 kcmil conductors with round unilay or unidirectional lay compressed strands shall not be larger or smaller in average diameter than the maximum and minimum diameters indicated for the size in Table 20.3.1 of UL 1581. A finished 19-wire combination unilay conductor shall not be larger in average diameter than the maximum diameter indicated for the size in Table 20.6 of UL 1581. The average diameter of a conductor is to be determined and compared with the tables in the manner described in [6.3.4](#) and [6.3.5](#).

6.3.4 For diameter measurements, the insulation is to be removed at a single place at the center of a straight length of the finished conductor. Measurements of the conductor diameter are to be made over the metal-coated or uncoated conductor strands by means of a machinist's micrometer caliper having flat surfaces both on the anvil and on the end of the spindle. The measurements for all constructions for which the diameter requirements apply are to be made over the strands rather than across flats; this is illustrated in [Figure 6.1](#) only for a 7-strand construction. The measurements are to be made on a line extending through the center of the conductor and through the center of two wires (strands) in the outer layer that are 180° apart. The micrometer is to be calibrated to read directly to at least 0.001 inch or 0.01 mm, with each division of a width that facilitates estimation of each measurement to at least 0.0001 inch or 0.001 mm. The maximum and minimum diameters at that point are each to be recorded to the nearest 0.0001 inch or 0.001 mm, added together, and divided by 2 without any rounding of the sum or resulting average.

Figure 6.1
Conductor Diameter Measurement



6.3.5 Each minimum and maximum diameter indicated in [Table 6.3](#) and in Tables 20.3.1, 20.4, 20.4.1, and 20.6 of UL 1581 is absolute. The unrounded average of the two diameter readings is therefore to be compared directly with both the minimum and the maximum in the table.

6.4 Lay

6.4.1 Concentric conductors

6.4.1.1 The length of lay of the strands in both layers of a 19-wire combination round-wire unilay-stranded copper conductor shall be 8 – 16 times the outside diameter of the completed conductor. Otherwise, the length of lay of the strands in every layer of a concentric-lay-stranded conductor consisting of fewer than 37 strands shall be 8 – 16 times the outside diameter of that layer. The length of lay of the strands in the outer two layers of a concentric-lay-stranded conductor consisting of 37 or more strands shall be 8 – 16 times the outside diameter of that layer. The direction of lay of the outer layer shall be left-hand.

6.4.2 Single-bunch bunch-stranded conductors

6.4.2.1 The length of lay of the strands in a single-bunch bunch-stranded conductor shall not be greater than indicated in [Table 6.1](#). The direction of lay shall be left-hand.

Table 6.1
Length of Lay of Strands in a Single-Bunch Bunch-Stranded Conductor

Size of conductor AWG or kcmil	Maximum length of lay	
	inches	(mm)
22 – 17	1	(25)
16, 15	1-1/4	(32)
14, 13	1-5/8	(41)
12, 11	2	(51)
10, 9	2-1/2	(64)
8, 7	2-3/4	(70)
6	3-3/8	(86)
5 – 1000	16 times the diameter of the conductor	

6.4.3 Rope-lay bunch-stranded conductors

6.4.3.1 The length of lay of the individual strands in a bunch-stranded member of a rope-lay-stranded conductor shall not be more than 30 times the overall diameter of the member, and the length of the lay of the members in the outer layer shall neither be less than 8 nor more than 16 times the overall conductor diameter. The direction of lay of the outer layer shall be left-hand.

6.5 Joints

6.5.1 A joint in one strand of a stranded conductor shall be made in a workmanlike manner, shall not change the diameter of the strand or of the overall conductor, and shall not lessen the mechanical strength of the overall conductor. A joint shall be made by separately joining each strand. A joint shall not impair the flexibility of the conductor. A joint in a compressed-stranded conductor shall be made before compressing.

6.6 Area

6.6.1 Where measured as the means of size verification (see [6.2.2](#)) the cross-sectional area of a conductor shall not be smaller than the minimum indicated for the size in [Table 6.2](#).

Table 6.2
Cross-Sectional Areas of Conductors

Conductor size, AWG or kcmil	Nominal		Minimum acceptable	
	cmil	(mm ²)	cmil	(mm ²)
22	640	(0.324)	627	(0.318)
21	812	(0.412)	796	(0.404)
20	1020	(0.519)	1000	(0.507)
19	1290	(0.653)	1264	(0.641)
18	1620	(0.823)	1571	(0.798)
17	2050	(1.04)	2009	(1.02)
16	2580	(1.31)	2528	(1.28)
15	3260	(1.65)	3195	(1.62)
14	4110	(2.08)	4028	(2.04)

Table 6.2 Continued on Next Page