



Standard Test Methods for Solventless Electrical Insulating Varnishes¹

This standard is issued under the fixed designation D 4733; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 These test methods cover solventless varnishes used primarily as electrical, mechanical, and environmental protection for electrical equipment.

1.2 These test methods are used on solventless varnishes that are applied by dipping (at atmospheric pressure conditions or under vacuum or other certain pressure), spraying, or brushing for the purpose of impregnating or sealing electrical equipment. The following test methods are included:

Property Tests (Uncured):	Section
Density	7
Flash Point	8
Gel Time	9
Monomer Content	10
Rheological Properties (Non-Newtonian)	11
Brookfield Viscosity	12
Performance Property Tests (cured):	
Bond Strength	13
Coating Thickness	14
Dielectric Strength	15
Dielectric Strength-Using Metal Panels	16
Permittivity and Dissipation Factor	17
Build	18

1.3 The values stated in inch-pound units are to be regarded as the standard. The values in parentheses are for information only.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.* Specific hazard statements are given in 8.3, 15.5.1, and 15.5.2.

NOTE 1—This test method is related to IEC 60455. Since both methods contain multiple test procedures, many procedures are technically equivalent while others differ significantly.

¹ These test methods are under the jurisdiction of ASTM Committee ~~D-9~~ D09 on Electrical and Electronic Insulating Materials and is the direct responsibility of Subcommittee D09.01 on Electrical Insulating Varnishes, Powders, and Encapsulating Compounds.

Current edition approved ~~Nov. 10, 1998~~; Oct. 1, 2003. Published ~~March 1999~~; November 2003. Originally published as ~~D 4733 – 87~~; approved in 1987. Last previous edition approved in 1998 as D 4733 – 94~~8~~.

2. Referenced Documents

2.1 *ASTM Standards:*²

- D 93 Test Methods for Flash-Point by Pensky-Martens Closed Cup Tester
- D 115 Test Methods for Testing Solvent Containing Varnishes Used for Electrical Insulation
- D 149 Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies
- D 150 Test Methods for A-C Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulating Materials
- D 168 Test Method for Coke Residue of Creosote
- D 374 Test Methods for Thickness of Solid Electrical Insulation³
- D 923 Test Method for Sampling Electrical Insulating Liquids
- D 1475 Test Method for Density of Paint, Varnish, Lacquer, and Related Products
- ~~D 1674 Methods of Testing Polymerizable Embedding Compounds Used for~~ 1711 Terminology Relating to Electrical Insulation
- ~~D 1711 Terminology Relating to Electrical Insulation~~³ 2196 Test Methods for Rheological Properties of Non-Newtonian Materials by Rotational (Brookfield) Viscometer
- ~~D 2196 Test Methods for Rheological Properties of Non-Newtonian Materials by Rotational (Brookfield) Viscometer~~⁶
- ~~D 2519 Test 2519~~ Test Method for Bond Strength of Electrical Insulating Varnishes by the Helical Coil Test
- D 3056 Test Method for Gel Time of Solventless Varnishes
- D 3278 Test Method for Flash Point of Liquids by Small Scale Closed-Cup Apparatus
- D 3312 Test Method for Percent Reactive Monomer in Solventless Varnishes
- D 3487 Specification for Mineral Insulating Oil Used in Electrical Apparatus⁶
- D 3636 Practice for Sampling and Judging Quality of Solid Electrical Insulating Materials
- D 6054 Practice for Conditioning Electrical Insulating Materials for Testing

2.2 *IEC Standards*

- IEC 60455 Resin Based Reactive Compounds Used for Electrical Insulation

3. Terminology

3.1 *Definitions:* For definitions of terms used in these test methods, refer to Terminology D 1711.

3.1.1 *gel time, n*—of solventless varnish, the time required at a specified temperature for a solventless varnish to be transformed from a liquid state to a gel as measured with a suitable gel time apparatus.

3.1.2 *thixotropy, n*—the property of a material to thin upon isothermal agitation and to thicken upon subsequent rest.

3.1.3 *varnish, electrical insulating, n*— a liquid resin system that is applied to and cured on electrical components providing electrical, mechanical, and environmental protection.

3.1.3.1 *Discussion*—There are two types of electrical insulating varnish—solvent-containing and solventless. The solvent-containing varnish is solution, dispersion, or emulsion of a polymer or a mixture of polymers in a volatile, nonreactable liquid. The solventless type is a liquid resin system free of volatile, nonreactable solvents.

4. Significance and Use

4.1 The test methods referenced in these test methods are useful for control purposes during the manufacture and use of solventless varnishes.

5. Sampling

5.1 Accurate sampling, whether of the complete contents or only parts thereof, is extremely important from the standpoint of evaluating the quality of the product sampled. In most cases, the detection of contaminants that are not ordinarily dispersed uniformly through the liquid being sampled such as water or solid particles, necessitates taking samples at specific locations where the contaminants are likely to be found. For a liquid having a specific gravity less than one, water and other impurities are most likely to be found on the bottom; whereas in the case of liquids having a specific gravity greater than one, these impurities are most likely to be found on the surface.

5.2 *Sampling Fluids Exhibiting Newtonian Viscosity:*

5.2.1 Sample solventless varnishes having an approximate viscosity of 25 cP (0.025 Pa·s) or less at 100°F (37.8°C) using the sampling device shown in Fig. 1 of Test Method D 923. However, if the temperature of the material is below room temperature or if the humidity is above 75 % relative humidity, sample using an aspirator-type sampling device as shown in Fig. 2 of Test Method D 923.

5.2.2 Sample solventless varnishes having a viscosity from 25 to 650 cP (0.025 to 0.65 Pa·s) at 100°F (37.8°C) and where contact with the atmosphere must be avoided, use a pressure-type sampling device as shown in Fig. 3 of Test Method D 923.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards, Vol 05.01, volume information, refer to the standard's Document Summary page on the ASTM website.

5.2.3 Sample solventless varnishes having a viscosity above 650 cP at 100°F at 73 ± 10°F (23 ± 5°C). Open the container and mix slowly so as not to entrap air. When the material is homogeneous, take samples from two or three places on the surface and mix together.

5.3 *Sampling Fluids Exhibiting Non-Newtonian Viscosity:*

5.3.1 Sample solventless varnishes exhibiting non-Newtonian viscosity in accordance with 5.2.3.

5.4 Use sample containers and sampling procedures in accordance with Test Method D 923.

5.5 When a sampling method is needed to determine whether a lot meets the requirements of a material specification, use Practice D 3636 as a guide.

6. Conditioning

6.1 Condition test specimens at standard laboratory condition as specified in Practice D 6054.

6.2 Deaerate specimens to be used for property evaluation before curing using the vacuum technique recommended by the varnish manufacturer.

TEST METHODS

7. Density

7.1 *Scope*—This test method covers the measurement of the density using a pycnometer. It is particularly applicable where the fluid has too high a viscosity for other methods of testing density. In this test method the density will be expressed as pounds per gallon (grams per millilitere) at 70 to 77°F (20 to 25°C).

7.2 *Procedure*—Test for density in accordance with Test Method D 1475.

7.3 *Report*—Report the following information:

7.3.1 Identification of the test sample,

7.3.2 The test temperature to the nearest 0.2°F (0.1°C),

7.3.3 Density to the nearest 0.01 lb/gal (0.001 g/mL), and

7.3.4 The mean, the range, and the number of replicate determinations.

8. Flash Point

8.1 *Scope*—This test method covers the determination of the flash point of solventless varnishes. There are two types of materials involved:

8.1.1 Those varnishes having a flash point above 230°F (110°C), and

8.1.2 Those varnishes having a flash point below 230°F (110°C).

8.2 *Summary of Test Method*—A specified amount of sample is added to the instrument. The temperature of the material is increased at a constant rate until a small flame ignites the vapor of the specimen in the tester and propagates a flame across its surface. The temperature at ignition is taken as the flash point.

8.3 *This test method should be used to measure and describe the response of materials, products, or assemblies to heat and flame under controlled conditions and should not be used to describe or appraise the fire hazard or fire risk of materials, products, or assemblies under actual fire conditions. However, results of this test may be used as elements of a fire hazard assessment or a fire risk assessment which takes into account all of the factors which are pertinent to an assessment of the fire hazard of a particular end use.*

8.4 *Procedure:*

8.4.1 Test the materials of 8.1.1 in accordance with Test Methods D 93.

8.4.2 Test the materials of 8.1.2 in accordance with Test Method D 3278.

8.5 *Report*—Report information in accordance with the report section of the test method used.

9. Gel Time

9.1 *Scope*—This test method covers the determination of gel time of a solventless varnish mixed with a reactor or catalyst and exposed to elevated temperatures.

9.2 *Significance and Use*—Knowledge of gel time is important for determining shelf life, batch uniformity, and processing characteristics.

9.3 *Procedure*—Test for gel time in accordance with Test Method D 3056.

9.4 *Report*—Report the following information:

9.4.1 Identification of the material,

9.4.2 The reactor or catalyst and quantity used should be stated if the reactor or catalyst is supplied in a separate package,

9.4.3 Gel time to the nearest 0.1 min,

9.4.4 Temperature of the bath, and

9.4.5 Liquid used in the bath.

10. Monomer Content

10.1 *Scope*—This test method covers the determination of the percent monomer having a vapor pressure exceeding 0.1 Torr (13 Pa) at 77°F (25°C).

10.2 *Significance and Use*—The percent of reactive monomer in a solventless varnish will affect the viscosity, handling, and processing properties of the uncured resin. The amount of reactive monomer may also affect the physical and electrical properties of the cured resin.

10.3 *Procedure*—Test for the monomer content in accordance with Test Method D 3312.

10.4 *Report*—Report the following information:

10.4.1 Identification of the solventless varnish, and

10.4.2 Percent reactive monomer.

11. Rheological Properties (Non-Newtonian)

11.1 *Scope*—This test method covers the determination of the rheological properties of solventless varnishes that are non-newtonian in character.

11.2 *Significance and Use*—This test method is used to test solventless varnishes that are thixotropic in nature and require specific treatment of the sample in order to determine this property.

11.3 *Procedure*—Test for thixotropy in accordance with Test Method D 2196, Method B or C.

11.4 *Report*—Report information as specified in Test Method D 2196.

12. Brookfield Viscosity

12.1 *Scope*—This test method covers the determination of viscosity for liquids having flow properties approaching those of the newtonian solutions.

12.2 *Apparatus*:

12.2.1 *Brookfield Viscometer*.

12.2.2 *Thermometer*.

12.2.3 *Water Bath*.

12.2.4 *Stirrer*.

12.3 *Procedure*:

12.3.1 Bring the specimen to a temperature of $77 \pm 2^\circ\text{F}$ ($25 \pm 1.0^\circ\text{C}$) using a water bath and stirrer if necessary. Allow the specimen to sit in the water bath at $77 \pm 2^\circ\text{F}$ until no bubbles are visible in the specimen.

12.3.2 Make all measurements with the Brookfield viscometer at $77 \pm 2^\circ\text{F}$ ($25 \pm 1.0^\circ\text{C}$).

12.4 *Report*—Report information as specified in Test Method D 2196.

12.5 *Precision and Bias*:

12.5.1 *Precision*—See Test Method D 2196 for a statement of precision.

12.5.2 *Bias*—See Test Method D 2196 for a statement of bias.

13. Bond Strength

13.1 *Scope*—This test method covers the determination of the bond strength of an electrical insulating varnish when applied to a helical coil.

13.2 *Significance and Use*—Values obtained by flexural test can provide information with regard to the bond strength of a particular varnish in combination with a particular wire when measured under the prescribed conditions.

13.3 *Procedure*—Perform the test in accordance with Test Method D 2519.

~~13.3.1 Apply the varnish in the “as received” condition;~~

~~13.3.2 Apply only one coat of varnish, and~~

~~13.3.3 Use film-insulated magnet wire.~~

13.4 *Report*—Report information in accordance with Test Method D 2519.

13.5 *Precision and Bias*:

13.5.1 *Precision*—See Test Method D 2519 for a statement of bias.

13.5.2 *Bias*—See Test Method D 2519 for a statement of bias.

14. Coating Thickness

14.1 *Scope*:

14.1.1 This test method is used to determine the thickness of a coating obtained with a solventless varnish.

14.1.2 The shear history of the varnish immediately preceding the test may have an appreciable effect on the coating thickness obtained. This test method specifies the degree of shear of the sample and the rate of withdrawal of the specimen in order to arrive at a reproducible buildup on a test specimen.

14.2 *Apparatus*:

14.2.1 *Device*, capable of withdrawing a specimen at approximately 4 in./min (100 mm/min).

14.2.2 *Water Bath*, or conditioned room controlled to a temperature of $75 \pm 2^\circ\text{F}$ ($24 \pm 1^\circ\text{C}$).

14.2.3 *Thermometer*, with a range of 32 to 212°F (0 to 100°C).

14.2.4 *Test Panel*, consisting of a steel or aluminum strip 3 in. (75 mm) in width, 5 in. (125 mm) in length, and ~~0.0405–0.032~~ in. (0.125–0.81 mm) in thickness.

14.2.4.1 The thickness is determined by measuring the thickness at 2 in. (50 mm) below the top and at 4 in. (100 mm) below the top. An average of these two is the thickness of the bare panel. Thickness measurements shall be made in accordance with Test Methods D 374.

14.3 *Procedure:*

14.3.1 Bring the test specimen to a temperature of $75 \pm 2^\circ\text{F}$ ($24 \pm 1^\circ\text{C}$) and pour slowly into a suitable container. Do not trap air in the varnish.

14.3.2 Slowly lower the test panel into the varnish.

14.3.3 Place the container with the varnish and panel in a constant-temperature water bath or in a conditioned room held at $75 \pm 2^\circ\text{F}$ ($24 \pm 1^\circ\text{C}$). Allow it to stand in this condition without vibration for 60 to 65 min.

14.3.4 At the end of 60 min move the specimen under a dip coater that has been previously adjusted to withdraw the specimen at a rate of approximately 4 in./min (100 mm/min). Attach the specimen without disturbing the jar or panel.

14.3.5 After the panel has been raised out of the varnish, stop the dip coater and allow the panel to stand for 30 min. Move the container away from the specimen so that the specimen can hang free without detriment to the coating.

14.3.6 Place the specimen in an oven and bake in accordance with the manufacturer's instructions. Be careful not to vibrate the specimen in the early part of the baking.

14.4 . *Report*—Report the following information:

14.4.1 Average thickness of the coated panel,

14.4.2 Average thickness of the uncoated panel,

14.4.3 The thickness of the coating on both sides of the panel is the difference between the coated and uncoated panel.

14.4.4 The coating thickness (the thickness of the coating obtained in 14.4.3 divided by 2).

14.5 *Precision and Bias:*

14.5.1 *Precision*—It is not practicable to specify the precision of this procedure because it has not been determined.

14.5.2 *Bias*—Since there is no acceptable reference material suitable for determining the bias of this test method, no statement of bias is being made.

15. Dielectric Strength

15.1 *Significance and Use:*

15.1.1 Dielectric strength of an insulating varnish is an important indication of its ability to withstand electric stress without failure. The value determined by this test is not a measure of dielectric strength expected in service, but is a numerical value which may be used for purchase by specification as an indication of quality, for comparison of different varnishes, and, to limited degree, for design work when coupled with experience.

15.1.2 See the Significance and Use section of Test Methods D 149 for further information on this subject.

15.2 *Apparatus:*

15.2.1 Electrical apparatus is as described in Test Method D 149.

15.2.2 *Electrodes* are opposing cylinders 50 mm (2 in.) in diameter and 25 mm (1 in.) in length, with the edges rounded to a radius of 6.4 mm (¼ in.). Use clean insulating oil meeting the requirements of Specification D 3487, Type I or Type II as the surrounding medium for test.

15.3 *Test Specimens:*

15.3.1 Cut five specimens, 100 by 100 by 3 mm (4 by 4 by ⅛ in.) from cast slabs. Cast the slabs in the vertical position in any suitable mold which will result in castings of thickness which can be controlled within $\pm 5\%$. The mold may consist of two highly polished plates, 9.5 mm (⅜ in.) thick, coated with a suitable release agent and spaced to the desired specimen thickness with a U-shaped spacer of any suitable material to which the varnish will not adhere. Clamp the mold assembly with sufficient pressure to prevent leakage of the compound. Cure specimens in accordance with manufacturer's instructions.

15.4 *Conditioning:*

15.4.1 Condition the specimens in accordance with Procedure A of Practice ~~D 618~~ D 6054.

15.5 *Procedure:*

15.5.1 **Caution:** *Lethal voltages may be present during this test. It is essential that the test apparatus, and all associated equipment that may be electrically connected to it, be properly designed and installed for safe operation. Solidly ground all electrically conductive parts that any person might come in contact with during the test. Provide means for use at the completion of any test to ground any parts which: were at high voltage during the test; may have acquired an induced charge during the test; may retain a charge even after disconnection of the voltage source. Thoroughly instruct all operators in the proper way to conduct tests safely. When making high voltage tests, particularly in compressed gas or in oil, the energy released at breakdown may be sufficient to result in fire, explosion, or rupture of the test chamber. Design test equipment, test chambers, and test specimens so as to minimize the possibility of such occurrences and to eliminate the possibility of personal injury.*

15.5.2 **Caution:** *Ozone is a physiologically hazardous gas at elevated concentrations. The exposure limits are set by governmental agencies and are usually based upon recommendations made by the American Conference of Governmental Industrial Hygienists.³⁴ Ozone is likely to be present whenever voltages exist which are sufficient to cause partial, or complete, discharges in air or other atmospheres that contain oxygen. Ozone has a distinctive odor which is initially discernible at low concentrations but sustained inhalation of ozone can cause temporary loss of sensitivity to the scent of ozone. Because of this it*

is important to measure the concentration of ozone in the atmosphere, using commercially available monitoring devices, whenever the odor of ozone is persistently present or when ozone generating conditions continue. Use appropriate means, such as exhaust vents, to reduce ozone concentrations to acceptable levels in working areas.

15.5.3 Measure the thickness of each specimen at the center by the dead-weight dial micrometer, Method C of Test Methods D 374.

15.5.4 Place specimen between the electrodes and add surrounding medium, if necessary. Raise the voltage at the rate of 500 v/s until failure.

15.5.5 Calculate the dielectric strength in v/mil (kV/mm) for each specimen by dividing the breakdown voltage by the specimen thickness.

15.6 *Report:*

15.6.1 Report the following information:

15.6.1.1 Average thickness of five specimens,

15.6.1.2 Individual breakdown voltages, and

15.6.1.3 Average dielectric strength

15.7 *Precision and Bias:*

15.7.1 *Precision*—This test method has been in use for many years, but no statement of precision has been made and no activity is planned to develop such a statement.

15.7.2 *Bias*—A statement of bias is not possible due to the lack of a standard reference material.

16. Dielectric Strength (Using Metal Panels)

16.1 Follow the procedure for determining dielectric strength of dried varnish film in accordance with Test Methods D 115, with the following exceptions:

16.1.1 Aluminum or steel panels, 3 in. by 6 in. by 0.005 to 0.032 in., (7.6 cm by 15.2 cm by 0.013 to 0.08 cm) may be used in place of copper.

16.1.2 Do not adjust the varnish.

16.1.3 Dip in varnish only once.

16.2 Report information for dielectric breakdown of dried varnish film in accordance with Test Methods D 115.

17. Permittivity and Dissipation Factor

17.1 *Procedure*—Test for permittivity and dissipation factor in accordance with Test Methods D 150. Cast a slab of the material $\frac{1}{8}$ in. (3 mm) in thickness and test a specimen 2 in. (50 mm) in diameter. Use a two-terminal micrometer electrode system capable of heating the electrodes. Select test temperature, voltage, and frequency based upon the application of the varnish.

17.2 *Report*—Report information in accordance with Test Methods D 150.

17.3 *Precision and Bias:*

17.3.1 *Precision*—This test method has been in use for many years, but no statement of precision has been made and no activity is planned to develop such a statement.

17.3.2 *Bias*—A statement of bias is not possible due to the lack of a standard reference material.

18. Build

18.1 Follow the copper strip procedure in accordance with the section entitled “Build” of Test Methods D 115, except that aluminum or steel panels, 3 in. by 6 in. by 0.005 to 0.032 in. (7.6 cm by 15.2 cm by 0.013 to 0.08 cm) may be used in place of copper strips.

18.2 Report information in accordance with the section entitled “Build” of Test Methods D 115.

19. Keywords

19.1 bond strength; coating thickness; density; dielectric strength; dissipation factor; flash point; gel time; monomer content; permittivity; solventless varnishes; varnishes; viscosity

Annual Book of ASTM Standards, Vol 10.01

⁴ 1330 Kemper Meadow Drive, Cincinnati, Ohio 45240.

ASTM International takes no position respecting the validity of any patent rights asserted in connection with any item mentioned in this standard. Users of this standard are expressly advised that determination of the validity of any such patent rights, and the risk of infringement of such rights, are entirely their own responsibility.

This standard is subject to revision at any time by the responsible technical committee and must be reviewed every five years and if not revised, either reapproved or withdrawn. Your comments are invited either for revision of this standard or for additional standards and should be addressed to ASTM International Headquarters. Your comments will receive careful consideration at a meeting of the responsible technical committee, which you may attend. If you feel that your comments have not received a fair hearing you should make your views known to the ASTM Committee on Standards, at the address shown below.



This standard is copyrighted by ASTM International, 100 Barr Harbor Drive, PO Box C700, West Conshohocken, PA 19428-2959, United States. Individual reprints (single or multiple copies) of this standard may be obtained by contacting ASTM at the above address or at 610-832-9585 (phone), 610-832-9555 (fax), or service@astm.org (e-mail); or through the ASTM website (www.astm.org).