



Designation: B 778 – 9702

## Standard Specification for Shaped Wire Compact Concentric-Lay-Stranded Aluminum Conductors (AAC/TW)<sup>1</sup>

This standard is issued under the fixed designation B 778; 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 ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee B1 B01 on Electrical Conductors and is the direct responsibility of Subcommittee B 01.07 on Conductors of Light Metals.

Current edition approved Oct. 10, ~~1997~~, 2002. Published December ~~1997~~, 2002. Originally published as B 778 – 87, approved in 1987. Last previous edition approved in 1997 as B 778 – 927.

### 1. Scope

1.1 This specification covers shaped wire compact concentric-lay-stranded aluminum conductor (AAC/TW) and its component wires for use as overhead electrical conductors (Explanatory Note 1 and Note 2).

1.2 The values stated in inch-pound units are to be regarded as the standard with the exception of temperature and resistivity. The SI equivalents of inch-pound units may be approximate.

NOTE 1—AAC/TW is designed to increase the aluminum area for a given diameter of conductor by the use of trapezoidally shaped wires (TW). The conductors consist of a central core of one round aluminum wire or a seven-strand compact round core surrounded by two or more layers of trapezoidal aluminum 1350-H19 wires. For the purposes of this specification, the sizes listed are tabulated on the basis of the finished conductor having an area equal to that of specific sizes of standard AAC (Table 1) or in fixed diameter increments (Table 2) so as to facilitate conductor selection.

NOTE 2—The aluminum and temper designations conform to ANSI Standard H 35.1. Aluminum 1350 corresponds to Unified Numbering System (UNS) A91350 in accordance with Practice E 527.

### 2. Referenced Documents

2.1 The following documents of the issue in effect on date of material purchase form a part of this specification to the extent referenced herein.

#### 2.2 ASTM Standards:

B 230 Specification for Aluminum 1350-H19 Wire for Electrical Purposes<sup>2</sup>

B 263 Test Method for Determination of Cross-Sectional Area of Stranded Conductors<sup>2</sup>

B 354 Terminology Relating to Uninsulated Metallic Electrical Conductors<sup>2</sup>

E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications<sup>3</sup>

E 527 Practice for Numbering Metals and Alloys (UNS)<sup>4</sup>

#### 2.3 Other Documents:

ANSI H35.1 American National Standard Alloy and Temper Designation Systems for Aluminum<sup>5</sup>

NBS *Handbook 100*—Copper Wire Tables<sup>6</sup>

Aluminum Association Publication 50 Code Words for Overhead Aluminum Electrical Conductors<sup>7</sup>

### 3. Ordering Information

3.1 Orders for material under this specification shall include the following information:

3.1.1 Quantity of each size,

3.1.2 Conductor size: kcmil area and diameter (Table 1 and Table 2),

3.1.3 Special tension test, if required (see 8.2),

3.1.4 Place of inspection (Section 15),

<sup>2</sup> *Annual Book of ASTM Standards*, Vol 02.03.

<sup>3</sup> *Annual Book of ASTM Standards*, Vol 14.02.

<sup>4</sup> *Annual Book of ASTM Standards*, Vol 01.01.

<sup>5</sup> Available from American National Standards Institute, 11 West 42nd St, 4th Floor, New York, NY 10036.

<sup>6</sup> Available from National Institute of Standards and Technology (NIST), 100 Bureau Dr., Stop 3460, Gaithersburg, MD 20899-3460.

<sup>7</sup> Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS; the Aluminum Association, Inc., 900 19th Street, NW, Suite 300, Washington, D.C. 20006.

**TABLE 1 Construction Requirements for Shaped Wire Compact Concentric-Lay-Stranded Aluminum Conductors Sized to Have Areas Equal to AAC Size**

AAC/TW Conductor Size, kcmil	Nominal Outside Diameter, in. <sup>d</sup> <sup>A</sup>	Number of Aluminum TW Conductors		Nominal Outside of L Diagonals		Nominal Mass, lb/1000-ft	Nominal Mass, kg/km	Number of Aluminum Wires	Rated Strength, lb	Rated Strength, kN	
		Size		mm							
		mm	in.	mm	lb/1000ft						
<del>336.4</del>	336.4	170	0.612			17	2	315.3	469.4	6.02	-6.02
Tulip/TW	336.4	170	0.612	15.5		17	2	315.3	469.4	6.02	26.8
<del>397.5</del>	397.5	201	0.661			17	2	372.6	554.7	6.96	-6.96
Canna/TW	397.5	201	0.661	16.8		17	2	372.6	554.7	6.96	31
<del>477.0</del>	477.0	242	0.720			17	2	447.1	665.6	8.36	-8.36
Cosmos/TW	477.0	242	0.720	18.3		17	2	447.1	665.6	8.36	37.2
<del>500.0</del>	500.0	253	0.736			17	2	468.7	697.7	8.76	-8.76
Zinnia/TW	500.0	253	0.736	18.7		17	2	468.7	697.7	8.76	39
<del>556.5</del>	556.5	282	0.775			17	2	521.6	776.5	9.75	-9.75
Mistletoe/TW	556.5	282	0.775	19.7		17	2	521.6	776.5	9.75	43.4
<del>600.0</del>	600.0	304	0.803			17	2	562.4	837.2	10.52	
Meadowsweet/TW	600.0	304	0.803	20.4		17	2	562.4	837.2	10.52	46.8
<del>636.0</del>	636.0	322	0.825			17	2	596.1	887.4	11.1	
Orchid/TW	636.0	322	0.825	21.0		17	2	596.1	887.4	11.1	49.4
<del>700.0</del>	700.0	355	0.864			17	2	656.1	976.7	12.3	
Verbena/TW	700.0	355	0.864	21.9		17	2	656.1	976.7	12.3	54.7
<del>750.0</del>	750.0	380	0.893			17	2	702.4	1045	13.1	
Nasturtium/TW	750.0	380	0.893	22.7		17	2	702.4	1045	13.1	58.3
<del>795.0</del>	795.0	403	0.919			17	2	745.1	1109	13.6	
Arbutus/TW	795.0	403	0.919	23.3		17	2	745.1	1109	13.6	60.5
<del>900.0</del>	900.0	456	0.990			31	3	843.6	1256	15.4	
Cockscomb/TW	900.0	456	0.990	25.1		31	3	843.6	1256	15.4	68.5
<del>954.0</del>	954.0	483	1.018			31	3	894.2	1331	16.4	
Magnolia/TW	954.0	483	1.018	25.9		31	3	894.2	1331	16.4	72.9
<del>1000.0</del>	1000.0	507	1.041			31	3	937.3	1395	17.1	
Hawkweed/TW	1000.0	507	1.041	26.4		31	3	937.3	1395	17.1	76.1
<del>1033.5</del>	1033.5	524	1.057			31	3	968.7	1442	17.7	
Bluebell/TW	1033.5	524	1.057	26.8		31	3	968.7	1442	17.7	78.7
<del>1113.0</del>	1113.0	564	1.095			31	3	1043.2	1553	19.1	
Marigold/TW	1113.0	564	1.095	27.8		31	3	1043.2	1553	19.1	85.0
<del>1192.5</del>	1192.5	604	1.132			31	3	1117.7	1664	20.4	
Hawthorn/TW	1192.5	604	1.132	28.8		31	3	1117.7	1664	20.4	90.7
<del>1272.0</del>	1272.0	644	1.168			31	3	1192.2	1775	21.8	
Narcissus/TW	1272.0	644	1.168	29.7		31	3	1192.2	1775	21.8	97.0
<del>1351.5</del>	1351.5	685	1.202			31	3	1266.3	1885	23.2	
Columbine/TW	1351.5	685	1.202	30.5		31	3	1266.3	1885	23.2	103
<del>1431.0</del>	1431.0	725	1.236			31	3	1341.3	1997	24.0	
Carnation/TW	1431.0	725	1.236	31.4		31	3	1341.3	1997	24.0	107
<del>1590.0</del>	1590.0	805	1.315			49	4	1490.3	2219	27.0	
Coreopsis/TW	1590.0	805	1.315	33.4		49	4	1490.3	2219	27.0	120
<del>1750.0</del>	1750.0	887	1.377			49	4	1640.3	2442	29.7	
Jessamine/TW	1750.0	887	1.377	35.0		49	4	1640.3	2442	29.7	132
<del>2000.0</del>	2000.0	1013	1.468			49	4	1893.0	2818	33.9	
Cowslip/TW	2000.0	1013	1.468	37.3		49	4	1893.0	2818	33.9	151
<del>2500.0</del>	2500.0	1266	1.648			71	5	2366.2	3522	41.9	
Lupine/TW	2500.0	1266	1.648	41.9		71	5	2366.2	3522	41.9	186
<del>3000.0</del>	3000.0	1520	1.799			71	5	2839.5	4227	50.3	
Trillium/TW	3000.0	1520	1.799	45.7		71	5	2839.5	4227	50.3	224

<sup>A</sup>Code words shown in ~~—~~ this column are obtained from "Publication 5-40, Code Words for Overhead Aluminum Electrical Conductors," by the Aluminum Association. They are provided for information only.

- 3.1.5 Package size and type (see 15.1),
- 3.1.6 Special package markings, if required (Section 15), and
- 3.1.7 Heavy wood lagging, if required (see 15.3).

#### 4. Requirement for Wires

4.1 Before stranding, the trapezoidal aluminum wires shall conform to the requirements of Specification B 230 except for shape and diameter tolerance. The tensile strength and elongation requirements of trapezoidal wires shall be the same as for round wires of equal area. The area tolerances shall be such that the finished conductor conforms to Section 11.

#### 5. Joints

5.1 Electric-butt welds, electric-butt cold-upset welds, or cold-pressure welds may be made in the individual aluminum wires during the stranding process. No weld shall occur within 50 ft (15 m) of any other weld in the completed conductor (Explanatory Note 3).

**TABLE 2 Construction Requirements for Shaped Wire Compact Concentric-Lay-Stranded Aluminum Conductors, in Fixed-Diameter Increments**

AAC/TW Conductor Wor-Size, kcmil	Nominal Outside Diameter, AAC/ TW iCon-			ductor Size		Number of Aluminu Wts/sides		Diameter 1000 lbf	Number of Lay Aluminum Wires	Neuminal Mass,ber of Layers	Nominal Mass Rated kN
	d <sup>4</sup> kcmil	mm	in.	mm	lb/1000 ft	Rated Strenkgth-/km					
-322.5	322.5	163	0.60	15.2	17	2	302.3	-50	5.88		
Logan/TW	322.5	163	0.60	15.2	17	2	302.3	450	5.88	26.2	
-384.5	384.5	195	0.65	16.5	17	2	360.4	-6.5	6.74		
	384.5	195	0.65	16.5	17	2	360.4	536.5	6.74	30	
-449.4	449.4	228	0.70	17.8	17	2	421.2	-7	.88		
Wheeler/TW	449.4	228	0.70	17.8	17	2	421.2	627	7.88	35.1	
-521.7	521.7	264	0.75	19.1	17	2	489.0	-	9.14		
	521.7	264	0.75	19.1	17	2	489.0	728	9.14	40.7	
-595.8	595.8	302	0.80	20.3	17	2	558.4	1.3	10.44	46.4	
Robson/TW	595.8	302	0.80	20.3	17	2	558.4	831.3	10.44	46.4	
-678.2	678.2	344	0.85	21.6	17	2	635.7	946.3	11.88	52.8	
	678.2	344	0.85	21.6	17	2	635.7	946.3	11.88	52.8	
-761.5	761.5	386	0.90	22.9	17	2	713.7	1062.5	13.07	58.1	
McKinley/TW	761.5	386	0.90	22.9	17	2	713.7	1062.5	13.07	58.1	
-854.2	854.2	433	0.95	24.1	17	2	800.6	1191.8	14.86	66.1	
	854.2	433	0.95	24.1	17	2	800.6	1191.8	14.86	66.1	
-918.8	918.8	465	1.00	25.4	31	3	861.2	1282	15.76	70.1	
Rainer/TW	918.8	465	1.00	25.4	31	3	861.2	1282	15.76	70.1	
	1020.0	517	1.05	26.7	31	3	956.0	1423.2	17.50	77.8	
	1020.0	517	1.05	26.7	31	3	956.0	1423.2	17.50	77.8	
	1123.1	569	1.10	27.9	31	3	1052.7	1567.1	19.26	85.7	
Helens/TW	1123.1	569	1.10	27.9	31	3	1052.7	1567.1	19.26	85.7	
	1234.2	625	1.15	29.2	31	3	1156.8	1722.1	21.17	94.2	
	1234.2	625	1.15	29.2	31	3	1156.8	1722.1	21.17	94.2	
	1346.8	682	1.20	30.5	31	3	1262.3	1879.1	23.10	102.7	
Mazama/TW	1346.8	682	1.20	30.5	31	3	1262.3	1879.1	23.10	102.7	
	1467.9	744	1.25	31.8	31	3	1375.9	2048.2	24.65	109.6	
	1467.9	744	1.25	31.8	31	3	1375.9	2048.2	24.65	109.6	
	1583.2	802	1.30	33	34	3	1483.9	2209	26.59	118.3	
Hood/TW	1583.2	802	1.30	33	34	3	1483.9	2209	26.59	118.3	
	1682.7	852	1.35	34.3	49	4	1577.5	2348.4	28.55	127	
	1682.7	852	1.35	34.3	49	4	1577.5	2348.4	28.55	127	
	1812.7	918	1.40	35.6	49	4	1699.0	2529.2	30.74	136.7	
Whitney/TW	1812.7	918	1.40	35.6	49	4	1699.0	2529.2	30.74	136.7	
	1954.3	990	1.45	36.8	49	4	1832.1	2727.4	33.16	147.5	
	1954.3	990	1.45	36.8	49	4	1832.1	2727.4	33.16	147.5	
	2093.6	1061	1.50	38.1	49	4	1981.6	2949.9	35.51	157.9	
Powell/TW	2093.6	1061	1.50	38.1	49	4	1981.6	2949.9	35.51	157.9	
	2245.4	1137	1.55	39.4	49	4	2125.7	3164.4	37.30	165.9	
	2245.4	1137	1.55	39.4	49	4	2125.7	3164.4	37.30	165.9	
	2388.1	1210	1.60	40.6	52	4	2260.3	3364.8	39.67	176.5	
Jefferson/TW	2388.1	1210	1.60	40.6	52	4	2260.3	3364.8	39.67	176.5	
	2514.8	1274	1.65	41.9	71	5	2379.5	3542.3	42.17	187.6	
	2514.8	1274	1.65	41.9	71	5	2379.5	3542.3	42.17	187.6	
	2667.2	1351	1.70	43.2	71	5	2524.5	3758.1	44.74	199	
Shasta/TW	2667.2	1351	1.70	43.2	71	5	2524.5	3758.1	44.74	199	
	2844.5	1441	1.75	44.5	71	5	2692.2	4007.8	47.70	212.2	
	2844.5	1441	1.75	44.5	71	5	2692.2	4007.8	47.70	212.2	
	3006.2	1523	1.80	45.7	71	5	2873.0	4276.9	50.43	224.3	
Adams/TW	3006.2	1523	1.80	45.7	71	5	2873.0	4276.9	50.43	224.3	

<sup>4</sup>Code words shown in this column are obtained from "Publication 50, Code Words for Overhead Aluminum Electrical Conductors," by the Aluminum Association. They are provided for information only.

## 6. Lay

6.1 The preferred lay of the outside layer of aluminum wires of shaped wire aluminum conductors, having multiple layers of aluminum wires is 11 times the outside diameter of the conductor but the lay shall not be less than 10 nor more than 14 times that diameter (Explanatory Note 1).

6.2 The preferred lay of the layer immediately beneath the outside layer of aluminum wires is 13 times the outside diameter of such layer but the lay shall be not less than 10 nor more than 16 times that diameter.

6.3 The lay of the inner layers of aluminum wires shall be not less than 10 nor more than 17 times the outside diameter of such layer.

6.4 The direction of lay of the outside layer of aluminum wires shall be right-hand.

6.5 The direction of lay of the aluminum wires shall be reversed in successive layers.

6.6 For the purpose of this specification the lay factor is the length of lay of a given layer divided by its outside diameter.

## 7. Construction

7.1 The nominal aluminum cross-sectional area, the outside diameter, the nominal number of aluminum wires, the number of layers, the linear density, and the rated strength, of the shaped wire compact concentric-lay-stranded aluminum conductors, shall be as shown in Table 1 and Table 2.

NOTE 3—Exception to 7.1. Because the final design of a shaped wire compact conductor is contingent on several factors such as layer diameter, wire width and thickness, and the like, the actual configuration of a given size may vary between manufacturers. This might result in a slight variation in the number of wires and number of layers, from that shown in Table 1 and Table 2, and also in the dimensions of the individual wires.

## 8. Rated Strength of Conductor

8.1 The rated strength of a conductor, as shown in Table 1 and Table 2, shall be taken as the percentage, indicated in Table 3, in accordance with the number of aluminum layers, of the sum of the wire strengths calculated from the specified diameter of the round wires having the same area as the trapezoidal wires used in the manufacture of the conductor, and the appropriate minimum average tensile strength given in Specification B 230.

8.1.1 The rated strengths of conductors calculated in accordance with 8.1 and 8.3 are listed in Table 1 and Table 2.

8.2 Tests to confirm that the rated strength of the conductor is met are not required by this specification, but shall be made if agreed upon between the manufacturer and the purchaser at the time of placing an order. When tested, the breaking strength of the conductor shall be not less than the rated strength if failure occurs in the free length at least 1 in. (25 mm) beyond the end of either gripping device, or shall be not less than 95 % of the rated strength if failure occurs inside or within 1 in. of the end of either gripping device (Explanatory Note 2).

8.3 Rated strength and breaking strength values shall be rounded to three significant figures in the final value only, in accordance with Practice E 29.

## 9. Density

9.1 For the purpose of calculating mass per unit length, cross-sections, and the like, the density of aluminum 1350 shall be taken as 0.0975 lb/in.<sup>3</sup> (2705 kg/m<sup>3</sup>) at 20°C.

## 10. Mass and Electrical Resistance

10.1 The mass per unit length and electrical resistance of a unit length of stranded conductor are a function of the length of lay. The approximate linear density and electrical resistance of a stranded conductor may be determined using the standard increments shown in Table 4. When greater accuracy is desired, the increment based on the actual lay of the conductor may be calculated (Explanatory Note 3).

## 11. Variations in Area

11.1 The area of cross-section of the aluminum wires of the conductor shall be not less than 98 % nor more than 102 % of the area specified in column 1 of Table 1 and Table 2. The area of each wire shall be determined by Test Method B 263. In applying this method, the increment in linear density resulting from stranding may be the applicable value specified in Table 4, or it may be calculated from the measured dimensions of the sample under test. In case of questions regarding area compliance, the actual linear density increment due to stranding shall be calculated.

11.2 The diameter of the finished conductor shall be not less than 99 % nor more than 101 % of that shown in Table 1 and Table 2 when measured with a diameter tape between the closing dies and the capstan of the strander.

## 12. Workmanship, Finish, and Appearance

12.1 The conductor shall be clean and free from imperfections not consistent with good commercial practice.

## 13. Mechanical and Electrical Tests

13.1 Tests for mechanical and electrical properties of aluminum wires shall be made before stranding (Explanatory Note 4).

## 14. Inspection

14.1 Unless otherwise specified in the contract or purchase order, the manufacturer shall be responsible for the performance of all inspection and test requirements specified.

**TABLE 3 Rating Factors**

Number of Layers	Rating Factor, %
2	0.93
3	0.91
4	0.90
5 and above	0.89

**TABLE 4 Standard Increments Due to Stranding**

Size of Conductor, kcmil	Increment (Increase) of Mass per Unit Length and Electrical Resistance, %
Over 3 000 to 4 000	4
Over 2 000 to 3 000	3
2 000 and under	2

14.2 All inspections and tests shall be made at the place of manufacture unless otherwise especially agreed upon between the manufacturer and the purchaser at the time of the purchase.

14.3 The manufacturer shall afford the inspector representing the purchaser all reasonable manufacturer's facilities to satisfy him that the material is being furnished in accordance with this specification.

## 15. Packaging and Package Marking

15.1 Package sizes and kind of package, reels, etc. shall be agreed upon between the manufacturer and the purchaser.

15.2 There shall be only one length of conductor on a reel.

15.3 The conductors shall be protected against damage in ordinary handling and shipping. If heavy wood lagging is required, it shall be specified by the purchaser at the time of placing the order.

15.4 The net mass, length, size, kind of conductor, stranding, and any other necessary identification shall be marked on a tag attached to the conductor inside the package. This same information, together with the purchase order number, the manufacturer's serial number (if any), and all shipping marks and other information required by the purchaser shall appear on the outside of the package.

## 16. Keywords

16.1 AAC/TW; aluminum conductors; compact conductors; compact conductors, aluminum; concentric-lay-stranded aluminum conductors; electrical conductors; electrical conductors, aluminum; shaped wire compact conductors; shaped wire compact conductors, aluminum; shaped wire conductors; shaped wire conductors, aluminum; trapezoidal conductor; trapezoidal conductor, aluminum

## EXPLANATORY NOTES

NOTE 1—In this specification only shaped wire compact concentric-lay-stranded aluminum conductors are specifically designated. Conductor constructions not included in this specification should be agreed upon between the manufacturer and the purchaser when placing the order.

NOTE 2—For definitions of terms relating to conductors, refer to Terminology B 354.

NOTE 3—The behavior of properly spaced joints in aluminum wires in stranded conductors is related to both their tensile strength and elongation. Because of its higher elongation properties, the lower-strength electric-butt weld gives equivalent overall performance to that of a cold-pressure weld or an electric-butt, cold-upset weld in stranded conductors.

NOTE 4—The lay factor with respect to the outside diameter of a layer of wires varies for different layers and for different diameters of conductor, being larger for the inside layers than for the outside layer.

NOTE 5—To obtain the actual breaking strength of AAC/TW tested as a unit requires special devices for gripping the ends of the aluminum wires without causing damage thereto and resultant failure below the actual strength of the conductor. Various special dead-end devices are available for this purpose, such as compression sleeves. Ordinary jaws or clamping devices usually are not suitable.

NOTE 6—The increment of mass or electrical resistance of a completed concentric-lay-stranded conductor,  $k$ , in percent is given by the following equation:

$$k = 100(m - 1)$$

where  $m$  is the stranding factor, and is also the ratio of the mass or electrical resistance of a unit length of stranded conductor to that of a solid conductor of the same cross-sectional area or of a stranded conductor with infinite length of stranding, that is, all wires parallel to the conductor axis. The stranding factor ( $m$ ) for the completed stranded conductor is the *numerical average* of the stranding factors for each of the individual wires in the conductor, including the straight core wire, if any (for which the stranding factor is unity). The stranding factor ( $m_{ind}$ ) for any given wire in a concentric-lay-stranded conductor is:

$$m_{ind} = \sqrt{1 + (9.8696/n^2)}$$

where  $n$  = length of lay/diameter of helical path of the wire. This is assumed to be  $ID + t$  for a given layer where  $t$  equals the thickness of the layer. To be more precise, for trapezoidal wire, this diameter should be that of the centroid (the center of mass of the wire) which is on a diameter slightly larger than the average layer diameter used in the above formula. Using the average layer diameter for the helical path of the wire introduces a small error which is considered to be negligible and may be ignored. The derivation of the above is given in the *NBS Handbook 100*.<sup>6</sup>

NOTE 7—Wires unalaid from conductors may have different physical properties from those of the wire before stranding because of the deformation brought about by laying and again straightening for test.

## SUPPLEMENTARY REQUIREMENTS

The following supplementary requirements shall apply only when specified by

### SUMMARY OF CHANGES

Committee B01.07 has indentified the purchaser in the inquiry, contract, or order, for agencies location of the U.S. Government.

#### **S1. Referenced Documents**

~~S1.1 The following documents form a part of this specification selected changes to this standard since the extent specified herein. Unless otherwise specified, the issues of these documents shall be those listed in the last issue of (B 778 – 97) that may impact the Department use of Defense Index of Specifications and Standards (DODISS) and supplement thereto, cited this standard.~~

~~(1) Added Code Word names for various conductor constructions as found in the solicitation.~~

~~S1.2 *Military Specification:*<sup>2</sup>~~

~~MIL-C-12000 Cable, Cord Tables 1 and Wire, Electric Packaging of~~

#### **S2. Inspection**

~~S2.1 The government shall have the right 2.~~

~~(2) Added new Keywords.~~

~~(3) Eliminated references to perform any U.S. Government “Supplementary Requirements” at the end of the inspections and tests set forth in this specification when such tests are deemed necessary to ensure that the material conforms to the prescribed requirements.~~

#### **S3. specification.**

~~(4) Added Summary of Changes. Packaging~~

~~S3.1 Packaging shall be in accordance with MIL-C-12000.~~

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