



Standard Specification for Biaxially Oriented Polymeric Resin Film for Capacitors in Electrical Equipment¹

This standard is issued under the fixed designation D 3664; 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 This specification covers thin biaxially oriented polymeric resin film for use in capacitors for electrical equipment. The material is biaxially oriented to improve the tensile properties in the machine (MD) and transverse (TD) directions.

1.2 The following safety hazards caveat pertains only to the test methods section of this specification. *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.* For specific warning statements see 9.3 and Table 1 footnote B.

1.3 The values stated in SI units are the standard. The values in parentheses are for information only.

NOTE 1—This standard resembles IEC 60674-3-2, Specification for plastic films for electrical use, in title only. The content is significantly different.

2. Referenced Documents

2.1 ASTM Standards:²

- 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 AC Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulation
- D 202 Test Methods for Sampling and Testing Untreated Paper Used for Electrical Insulation
- D 257 Test Methods for DC Resistance or Conductance of Insulating Materials
- D 374 Test Methods for Thickness of Solid Electrical Insulation

D 543 Practices for Evaluating the Resistance of Plastics to Chemical Reagents

D 570 Test Method for Water Absorption of Plastics

D 756 Practice for Determination of Weight and Shape Changes of Plastics Under Accelerated Service Conditions³

D 774/D 774M Test Method for Bursting Strength of Paper

D 882 Test Method for Tensile Properties of Thin Plastic Sheet

D 1004 Test Method for Initial Tear Resistance of Plastic Film and Sheet

D 1204 Test Method for Linear Dimensional Changes of Nonrigid Thermoplastic Sheet or Film at Elevated Temperature

D 1434 Test Method for Determining Gas Permeability Characteristics of Plastic Film and Sheet

D 1435 Practice for Outdoor Weathering of Plastics

D 1505 Test Method for Density of Plastics by the Density-Gradient Technique

D 2176 Test Method for Folding Endurance of Paper by the M.I.T. Tester

D 2305 Test Methods for Polymeric Films Used for Electrical Insulation

D 2863 Test Method for Measuring the Minimum Oxygen Concentration to Support Candle-Like Combustion of Plastics (Oxygen Index)

D 3417 Test Method for Enthalpies of Fusion and Crystallization of Polymers by Differential Scanning Calorimetry

D 3420 Test Method for Pendulum Impact Resistance of Plastic Film

D 3636 Practice for Sampling and Judging Quality of Solid Electrical Insulating Materials

D 3755 Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials Under Direct-Voltage Stress

D 3985 Test Method for Oxygen Gas Transmission Rate Through Plastic Film and Sheet Using a Coulometric Sensor

D 6054 Practice for Conditioning Electrical Insulating Materials for Testing

¹ This specification is under the jurisdiction of ASTM Committee D09 on Electrical and Electronic Insulating Materials and is the direct responsibility of Subcommittee D09.07 on Flexible and Rigid Insulating Materials.

Current edition approved March 1, 2004. Published April 2004. Originally approved in 1978. Last previous edition approved in 2000 as D 3664 - 00.

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* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Withdrawn.

E 96 Test Methods for Water Vapor Transmission of Materials

E 252 Test Method for Thickness of Thin Foil and Film by Weighing

2.2 IEC Standards:⁴

IEC 60674–3–2 Specification for plastic films for electrical purposes—Part 3: Specifications for individual materials—Sheet 2: Requirements for balanced biaxially oriented polyethylene phthalate (PET) films used for electrical insulation

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036.

3. Terminology

3.1 Definitions of Terms Specific to This Standard:

3.1.1 *shiner, n*—as related to dielectric films, a protrusion of material beyond the plane of either edge of the roll.

3.1.2 *space factor, n*—as related to dielectric films, a measure of surface roughness of film expressed by the following equation:

$$\text{Space factor} = 100 [T_b - T_g] [T_g]^{-1} \quad (1)$$

where:

T_b = bulking thickness determined using Test Methods D 374, and

T_g = gravimetric thickness determined using Test Method E 252.

Space factor is expressed as %.

TABLE 1 Physical, Mechanical, and Electrical Requirements for Biaxially Oriented Polyethylene Terephthalate Capacitor Film (25.4 μm or less in thickness)⁴

Tensile Properties				
Tensile strength modulus, and elongation, MD and TD:				
Nominal Thickness, μm	Tensile Strength, min, MPA MD and TD	Break Elongation, % min		Tensile Modulus min, MPa MD and TD
		MD	TD	
1.5	110	40	20	2410
1.8	110	40	20	2410
2.0	110	...	30	2410
2.5	117	...	35	2410
3.0	131	...	35	2410
3.5	131	...	35	2716
4.0	131	45		2716
5.0	138	...	40	3103
6.0	138	...	40	3103
8.0	145	...	45	3103
10.0	145	...	50	3103
12.0	145	...	60	3103
19.0	145	...	60	2759
23.0	145	...	65	2759
Insulation resistance and conducting paths:				
Nominal Thickness, μm	Insulation Resistance, min $\text{M}\Omega$ at 125°C		Conducting Paths, max No. per m^2	
1.5	1000		...	
1.8	1000		...	
2.0	1000		...	
2.5	850		...	
3.0	850		...	
3.5	850		128	
4.0	825		107	
5.0	825		86	
6.0	800		64	
8.0	600		53	
10.0	600		43	
12.0	600		22	
19.0	500		11	
23.0	400		11	
Permittivity, 23°C, 50 % RH:				
60 Hz			3.2 $\pm$ 0.1	
1 kHz			3.2 $\pm$ 0.1	
Dissipation factor, max 23°C:			60 Hz	1 kHz
2.0 to 4.0 μm thick			0.006	0.008
5.0 to 25.0 μm thick			0.004	0.006
Thickness, μm :				
Nominal Thickness, μm	Average Thickness per Single-Slit Roll			
	Based on Roll Weight		Ten-Sheet Stack	
	min	max	min	max

TABLE 1 *Continued*

1.5	1.48	1.62	...	...
1.8	1.61	1.89	...	...
2.0	1.79	2.11	1.50	3.00
2.5	2.30	2.70	2.03	3.56
3.0	2.71	3.19	2.54	4.06
3.5	3.10	3.69	3.05	4.57
4.0	3.72	4.28	3.81	5.33
5.0	4.65	5.25	4.57	6.10
6.0	5.64	6.36	5.59	7.11
8.0	7.52	8.48	7.62	9.14

Nominal Thickness, μm	Average Thickness per Single-Slit Roll, μm			
	Based on Roll Weight		Ten-Sheet Stack	
	min	max	min	max
10.0	9.40	10.60	9.40	11.43
12.0	11.28	12.72	11.43	13.46
19.0	18.05	19.95	17.78	20.32
23.0	21.85	24.15	21.84	24.89

Width tolerance, variation from nominal, mm:	
less than 76 mm	± 0.2
76 to 152 mm	± 0.4
over 152 to 456 mm	± 0.8
over 456 mm	± 1.6
Density, 23/23°C, g/cm^3 ^B	1.385 to 1.410
Melting point, min, °C	252
Shrinkage, max, MD and TD at $150 \pm 1^\circ\text{C}$, %	3.0 MD, 2.0 TD

Dielectric breakdown voltage, dc:														
Critical test voltage, V	Number of capacitors that must survive the critical test voltage per 20 capacitors ^C													
	Thickness, μm													
	1.5	1.8	2.0	2.5	3.0	3.5	4.0	5.0	6.0	8.0	10.0	12.0	19.0	23.0
100			18											
200				17		18	18							
300					17			18						
400						17								
500							17		19					
600								17		19	19			
800												19		
1000									18				19	
1200										18				
1600											18			
1800												18		
2200													18	19
Min avg dc voltage of 20 capacitors	100	175	200	300	500	600	700	900	1500	2000	2400	2800	3700	4000

^A See Section 9 for Test Methods.

^B Use 1,3-dibromopropane and n-heptane for preparing density gradient tube. **Warning**—n-heptane is flammable and volatile.

^C This number has been statistically determined. Normally it will be met by any group of 20 capacitors. However, to definitely prove statistically that the specified number has been met for any mill roll lot of materials, it will be necessary to wind 60 capacitors from 3 slit rolls (20 from rolls A and B, 20 from rolls B and C, and 20 from A and C). If the average of the 3 groups is lower than the allowable number, the material is rejectable.

Aqueous extract conductivity, max, $\mu\text{S/cm}$

2

Acidity, max, milliequivalents/g

0.002

4. Classification

4.1 This specification covers the following:

4.1.1 *Type I*—having smooth surfaces (space factor $<5\%$, see 3.1.2);

4.1.1.1 *Grade 1*—not pre-treated,

4.1.1.2 *Grade 2*—one side pre-treated to facilitate the vacuum deposition of metal, and

4.1.1.3 *Grade 3*—both sides pre-treated.

4.1.2 *Type II*—having at least one rough surface (space factor $\geq 5\%$, see 3.1.2);

4.1.2.1 *Grade 1*—not pre-treated,

4.1.2.2 *Grade 2*—one side pre-treated to facilitate the vacuum deposition of metal, and

4.1.2.3 *Grade 3*—both sides pre-treated.

4.2 *Materials:*

4.2.1 *Class A*—polyethylene terephthalate (PET).

4.2.2 *Class B*—polypropylene (PP).

5. General Requirements

5.1 The material shall be of uniform composition, and as free from metal particles, contamination, blisters, holes, and other imperfections as commercially feasible.

5.2 Information of general engineering interest is given in the Appendix.

6. Detail Requirements

6.1 The material shall conform to requirements prescribed in Table 1 or Table 2.

7. Sampling

7.1 For purposes of sampling, and inspection lot for examination shall consist of all film of the same type, grade, class, and nominal thickness submitted for inspection at one time. If

TABLE 2 Physical, Mechanical, and Electrical Requirements for Biaxially Oriented Polypropylene Capacitor Film (25.4 μm or less in thickness)^A

Property	Value	
Tensile strength, min, MPA (MD or TD)	Type I	120
	Type II	90
Elongation, min, % (MD or TD)	Type I	40
	Type II	30
Conducting Paths Nominal Thickness, μm	Conducting Paths, max per m ²	
4.0	2.6	
5.0	2.3	
6.0	1.8	
7.0	1.7	
7.4	1.7	
8.0	1.5	
9.0	1.3	
10.0	1.2	
10.1	1.2	
11.0	1.1	
12.0 or greater	1.0	
Permittivity, 23°C, 50% RH		
60 Hz	2.2 ± 0.1	
1 kHz	2.2 ± 0.1	
Dissipation Factor, 23°C, 50 % RH		
60 Hz	0.003	
1 kHz	0.0002	
Thickness Tolerance, μm	±10 %	
Width Tolerance, mm		
up to 50 mm	±0.5 mm	
over 50 mm to 300 mm	±1.0 mm	
over 300 mm to 450 mm	±2.0 mm	
over 450 mm to 750 mm	±4.0 mm	
Density, 23°C, g/cm ^{3B}	0.91 ± 0.01	
Melting Point, min, °C	165	
Shrinkage, max	To be agreed upon by purchaser and manufacturer	
Dielectric Breakdown Voltage, dc:		
Nominal Film Thickness	Average Breakdown Voltage, V	Not more than 1 of 21 results shall be below, V
4.0	480	160
5.0	750	300
6.0	1140	480
7.0	1610	700
7.4	1700	740
8.0	2000	960
9.0	2430	1305
10.0	2900	1650
10.1	2930	1665
11.0	3300	1925
12.0	3720	2220
12.7	4000	2475
25.0	8000	5000

^A See Section 9 for Test Methods.

^B Use methanol and ethylene-glycol for preparing density gradient tube.

a single shipment contains film having different lot numbers assigned by the film manufacturer, sample each lot number separately.

7.2 Unless otherwise agreed upon between the purchaser and seller, sample material for test according to Practice D 3636. Set inspection levels and acceptable quality levels (AQL) as agreed upon between the purchaser and seller.

8. Conditioning

8.1 If required, condition the test specimens in accordance with Procedure A of Practice D 6054 and Test Methods D 2305.

8.2 Use test conditions in accordance with Practice D 6054, unless otherwise specified.

9. Test Methods

9.1 *Tensile Strength, Modulus, and Elongation*—Test Method D 882, Method A. Test at 50 mm/min (2 in./min) with an initial jaw separation of 50 mm (2 in.). Test a 25-mm (1-in.) width or the width as received, if less.

9.2 *Density*—Test Method D 1505.

9.3 *Permittivity and Dissipation Factor*—Test Methods D 150. Use a maximum applied voltage of 30 V ac. Use the fluid-displacement method. Recommended fluids are air, *n*-heptane, or $1 \text{ or } 5 \times 10^{-6} \text{ m}^2/\text{s}$ (cSt) silicone fluid having a dissipation factor less than 0.00001. Conducting paint, sprayed or evaporated metal electrodes, are acceptable if care is taken to avoid errors as outlined in Test Methods D 150. In case of disagreement, use the fluid-displacement method as the referee method. (**Warning**—Heptane is readily flammable. Use proper precautions.

9.4 *Surface Resistivity and Volume Resistivity*—Test Methods D 257 with electrification for 60 s at 100 V dc.

9.5 *Melting Point*—Test Method D 3417.

9.6 *Shrinkage*—Test Method D 1204.

9.7 *Thickness*—Test Methods D 374, Procedures 6.2. See the Thickness Section of Test Methods D 202 for directions for handling ten-sheet stack specimens.

9.8 *Bursting Strength*—Test Method D 774/D 774M.

9.9 *Tear Strength*—Test Method D 1004.

9.10 *Impact Strength*—Test Method D 3420.

9.11 *Fold Endurance*—Test Method D 2176.

9.12 *Color or Clarity*—Visual observation.

9.13 *Moisture Absorption*—Test Method D 570, 24 h at 23°C.

9.14 *Moisture Permeability*—Test Methods E 96.

9.15 *Oxygen Index*—Test Method D 2863.

9.16 *Oxygen Permeability*—Test Method D 1434 or Test Method D 3985.

9.17 *Resistance to Corrosive Agents*—Practices D 543 for acids, alkalies, and organic solvents; Test Methods E 96 for water; Practice D 1435 for sunlight.

9.18 Special requirements such as heat or solvent resistance and hygroscopic coefficient of expansion are subjects for individual negotiation.

9.19 *Aqueous Extract Conductivity*—Test Methods D 202, except use a 5-g specimen and 200 mL of boiling distilled water. Omit stirring. After filtering, wash specimen with 50 mL of hot distilled water and add to filtrate. Adjust final volume to

250 mL with hot distilled water. Divide the calculated result by two. Save the solution to perform acidity test as in 8.21.

9.20 *Acidity*—Test Methods D 202, except titrate extract as in 9.19.

9.21 *Conducting Paths*—Method A of Test Methods D 202 using 100 V dc.

9.22 *Insulation Resistance*—Test Methods D 257. Measure on 0.5- μ F unimpregnated single-layer capacitors with 3-mm margins, 3-min total electrification at 100 V dc. Preheat capacitors in oven at $125 \pm 1^\circ\text{C}$ for $\frac{1}{2}$ h prior to test. Maintain temperature at $125 \pm 1^\circ\text{C}$ during measurement.

9.23 *Dielectric Breakdown Voltage (dc)*—See 9.3 for Warning. Test Method D 3755. Measure on 0.5- μ F unimpregnated single-layer capacitors subjected to dc voltage at 100-V/s rate of rise at room temperature and 50 % relative humidity. Conduct tests on “as-wound” units, using a 20-mm minimum or preferably 50-mm wide film with a 16-mm margin and a 3-mm arbor. Discard units failing a 6-V shorting test.

9.24 *Thickness of Capacitor Film*:

9.24.1 *Roll Weight Method*—Calculate the average thickness from the average density, and from the width, length, and net weight of the role.

9.24.2 *Ten-Sheet Stack Method*—Use Method A or C of Test Methods D 374. Make measurements on a ten-sheet stack of film from a single-slit roll. Keep the micrometer foot more than 20 mm from any folded edge of a stack, as specified in Test Methods D 202, or 6 mm from the edge of the sheet.

9.24.3 *Gravimetric Method*—Use Test Method E 252.

10. Roll Requirements

10.1 The following requirements apply:

10.1.1 *Core*—Cores must not distort or collapse from the winding tension, nor flake or degrade the sheet.

NOTE 2—Current industry practice is to wrap the material on either 76 or 152-mm (3 or 6-in.) diameter cores. Film for film/foil capacitor use is also supplied on 29-mm diameter cores. Details of whether the core may extend to the edge of the material or protrude beyond are subject to agreement between purchaser and manufacturer.

10.1.2 *Patching*—None is allowed.

10.1.3 *Shiners*—More than three per roll or those extending more than 1.6 mm (0.062 in.) are unacceptable.

10.1.4 *Splices*—The maximum number of splices permitted in a slit roll is given in Table 3. The minimum distance between

**TABLE 3 Slit Roll Splice Frequency
(Maximum Number Permitted)**

Roll Inside Diameter 76 mm				
Film Thickness	Roll Outside Diameter			
	240 mm	330 mm	410 mm	
1.5 – 23.0	2	3	4	

Roll Inside Diameter 152 mm				
Film Thickness	Roll Outside Diameter			
	230 mm	280 mm	360 mm	455 mm
1.5 – 23.0	2	3	4	5

splices, or from beginning or end of a slit roll is 162 m (500 ft), unless otherwise agreed upon between the purchaser and the supplier. Details of the splice, such as color, trailing tails at the top or bottom, sandwiched or overlapped, shall be agreed upon by the purchaser and supplier.

10.1.5 *Telescoping*—There shall be no more than 1.6-mm (0.062-in.) displacement from the plane of the edge of the roll.

10.1.6 *Wrinkles*—Permit no wrinkles that cause permanent deformation of the film.

10.1.7 *Marking*—Mark the following information on the core or on an accompanying label: mill roll number, footage, actual sheet thickness or gage, width, and the manufacturer’s designation.

11. Packaging

11.1 Package the material in standard commercial containers designed to protect the roll from damage, and constructed to ensure acceptance by common or other carriers for safe transportation at the lowest rate to the point of delivery, unless otherwise specified in the contract or order.

12. Marking

12.1 Identify shipping containers with the name and the specification number of the material, the thickness, the width, the footage, the roll and core diameters, the manufacturer’s name, and the number of the contract or order.

13. Keywords

13.1 capacitor; polyethylene terephthalate; polymeric resin film; polypropylene



APPENDIX

(Nonmandatory Information)

X1. INFORMATION OF GENERAL ENGINEERING INTEREST 25 μm (0.001 in.),
NOMINAL THICKNESS**TABLE X1.1 Information of General Engineering Interest
(Biaxially Oriented Polyethylene Terephthalate Film)**

Property ^{A,B}	Value
Bursting strength:	
kPa	>475
psi	>69
Tear strength:	
MPa	>12.4
psi	>1800
Impact strength:	
J/mm	96.4
J/mil	2.5
Fold endurance, cycles	>14 000
Color or clarity	clear to translucent
Moisture absorption, %	<0.6
Moisture permeability:	
g/m ² ·24 h	<23.2
g/100 in ² ·24 h	<1.5
Hygroscopic coefficient of expansion,% ($\Delta l/l$)/ Δ % RH:	
mm/mm·% RH = in/in·% RH	0.6×10^{-5}
Oxygen index	20–25
Oxygen permeability:	
cm ³ /m ² ·24 h·atm·m	<3.66
cm ³ /100 in. ² ·24 h·atm·mil	<6.
Corona	c
Resistance to corrosive agents:	
Weak acids	excellent
Strong acids	fair
Weak alkali	poor
Strong alkali	poor
Organic solvents	excellent
Water	excellent
Sunlight	poor unless specifically treated
Moisture and heat (hydrolytic stability)	poor
Surface resistivity, typical, Ω (per square):	
23°C, 30 % RH	1×10^{16}
23°C, 80 % RH	1×10^{12}
Volume resistivity, typical, Ω -cm:	
25°C, 50 % RH	1×10^{18}
150°C, 50 % RH	1×10^{13}

^A If these are to be specified, they are subject to agreement between the purchaser and the manufacturer.

^B See Section 9 for test methods.

^C Not recommended for use where continuous corona or electrical discharges are likely to occur.

**TABLE X1.2 Information of General Engineering Interest
(Biaxially Oriented Polypropylene Film)**

Property ^{A,B}	Value
Surface resistivity, typical, Ω (per square):	$\geq 10\text{E}14$
23°C, 50 % RH	
Volume resistivity, typical, Ω -cm:	$>10\text{E}15$
23°C, 50 %RH	

^A If these are to be specified, they are subject to agreement between the purchaser and the manufacturer.

^B See Section 9 for test methods.

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).