



# Southwire® Machine Flex® Power PVC THHN

90°C Wet or Dry. 600 Volts. Flexible Stranded Copper Conductor. PVC Insulation and Nylon Jacket (THHN/THWN-2). Oil & Gasoline Resistant. Sunlight Resistant. Rated UL VW-1 and CSA FT1 & FT4 Flame Resistant.



Image not to scale. See Table 1 for dimensions.

## CONSTRUCTION:

1. **Conductor:** 8 - 4/0 AWG: Class K, Flexible stranded bare copper. 250 - 750 kcmil: Class I, Flexible stranded bare copper
2. **Insulation:** Polyvinyl Chloride (PVC) with Nylon sheath

## APPLICATIONS AND FEATURES:

Southwire's Machine Flex® power cables are suited for use in wet and dry areas, conduits, ducts, troughs, trays, aerial supported by a messenger, and where superior electrical properties are desired. These cables are capable of operating continuously at the conductor temperature not in excess of 90°C for normal operation in wet and dry locations, 130°C for emergency overload, and 150°C for short circuit conditions. 1/0 AWG & Larger rated for CT use.

## SPECIFICATIONS:

- ASTM B3 Soft or Annealed Copper Wire
- ASTM B172 Standard Specification for Rope-Lay-Stranded Copper Conductors Having Bunch-Stranded Copper Conductors
- ASTM B174 Standard Specification for Bunch-Stranded Copper
- UL 83 Thermoplastic Insulated Wires and Cables
- UL 758 Standard for Appliance Wiring Material Style 2463 (80C, 600V)
- UL 1063 Machine Tool Wiring (MTW)
- UL 1685 FT4 Vertical-Tray Fire Propagation and Smoke Release Test (1/0 and Larger)
- ICEA S-95-658 (NEMA WC70) Power Cables Rated 2000 Volts or Less for the Distribution of Electrical Energy
- **CE/RoHS-2 – The CE Marking has been applied solely to express the conformance to the material restrictions identified in the RoHS-2 (2011/65/EU) Directive**
- Made in America: Compliant with both Buy American and Buy America Act (BAA) requirements per 49 U.S.C. § 5323(j) and the Federal Transit Administration Buy America requirements per 49 C.F.R. part 661





**SAMPLE PRINT LEGEND:**

8AWG-1AWG

SOUTHWIRE #P# (UL) 1 AWG (42.406 mm<sup>2</sup>) CU TYPE THHN/THWN-2 600V 90(D)C DRY/90(D)C WET PRI/GRI VW-1 OR AWM [Applicable Styles] OR MTW SUN RES --- (CSA) T90 NYLON OR TWN75 FT1 FT4 --- CE RoHS-2 Made in USA. [SEQUENTIAL FOOTAGE MARKS]

1/0 AWG - 500 KCMIL

SOUTHWIRE #P# (UL) 500 KCMIL (253.35mm<sup>2</sup>) CU TYPE THHN/THWN-2 600V 90(D)C DRY/90(D)C WET PRI/GRI VW-1 FOR CT USE OR AWM [Applicable Styles] OR MTW SUN RES --- (CSA) T90 NYLON OR TWN75 FT1 FT4 --- CE RoHS-2 Made in USA. [SEQUENTIAL FOOTAGE MARKS]

**Table 1 – Weights and Measurements**

Stock Number	Cond. Size	Conductor Number	Color	Diameter Over Conductor	Conductor Stranding	Insulation Thickness	Approx. OD	Copper Weight	Overall Weight
	AWG/ Kcmil			inch		mils	inch	lbs/1000ft	lbs/1000ft
678431	600	1	BN	0.963	1480	70	1.127	1859	2033

All dimensions are nominal and subject to normal manufacturing tolerances  
 ◇ Cable marked with this symbol is a standard stock item

**Table 2 – Electrical and Engineering Data**

Cond. Size	Conductor Number	Min. Bend Radius	Max Pull Tension	DC Resistance at 25°C	AC Resistance at 75°C	Inductive Reactance @ 60Hz	Allowable Ampacity Raceway 75°C	Allowable Ampacity Raceway 90°C
AWG/ Kcmil		Inches	Lbs	Ω/1000ft	Ω/1000ft	Ω/1000ft	Amp	Amp
600	1	5.6	4800	0.019	0.027	0.039	420	475

† Ampacities based upon 2023 NEC Table 310.16 and do not take into account the overcurrent protection limitations in NEC 240.4(D) of 15 Amps for 14 AWG CU, 20 Amps for 12 AWG CU, and 30 Amps for 10 AWG CU (independent of the conductor temperature rating and stranding if size is present in table). Also, see NEC sections 310.15 and 110.14(C) for additional requirements.

† Ampacities have been adjusted for more than Three Current-Carrying Conductors.

\* Inductive impedance is based on non-ferrous conduit with one diameter spacing center-to-center.





**Stock Codes and Colors**

Size (Strand)	Black	Red	Brown	Orange	Yellow	Gray	Green	Pink	Purple	Tan	Gray/Purple	Green/Yellow
4 (413)	672867						674667					
3 (525)							664229					
2 (665)												
1 (836)							456258					
1/0 (1044)							674668					677368
2/0 (1330)							456257					
3/0 (1672)			664217	664220	664223	664226						
4/0 (2109)	679607		456253	456254	456255		456256					679606
250 (627)	649414		672218	672217	672219	673792	673791					677370
300 (741)	672866		674116	674117	674118	674120	674121					
350 (893)	649415	138181	674662	674664	674665	674666	652964					672017
500 (1221)	648948		646978	646979	646980	646981	677701	456461	456462	456463	456464	646982
600 (1480)	649416		678431	678432	678434	678435	673748					678436
750 (1850)	649549		677721	677722	677723	677725	671518					677726
1000 (2516)	674459											

