

Mould for Core Impregnation and Silicone Shed Manufacturing

	Sl. No.	Description	BHEL Specification
A	Mould for Impregnation of Wounded Core		
	01	Application (Core Impregnation)	The mould is required for the impregnation of wounded core for electrical bushings as per Drawing No. RD-DG-4-26-1133-8000.
	02	Material	P-20 Steel/EN-353 or equivalent grade material capable of withstanding continuous temperature up to 200 deg. C
	03	Inner surface finish	Mirror finish (Shining type) interior surfaces
	04	Dimensional Tolerance	As per Drawing No. RD-DG-4-26-1133-8000.
	05	Supply of "Mould Drawings" by the Vendor	The Vendor should submit the "Mould Drawings" along with detailed specifications, while submitting the Technical Bid. Offers received without detailed mould drawing will not be considered for further evaluation.
	06	Mould Usage Criteria	The mould should be suitable for casting/moulding commercial-grade 'Polymeric Epoxy Resin Hardener System'.
B	Mould for Manufacturing of Silicone Shed		
	01	Application (Manufacturing of Silicone Shed)	The mould is required for the manufacture of silicone shed profile for electrical bushings as per Drawing No. RD-DG-4-26-1133-0000 and RD-DG-4-26-1133-5000 along with the provision for the inserts as per Drawing No. RD-DG-4-26-1133-1000 and RD-DG-4-26-1133-4000 respectively.
	02	Material	P-20 Steel/EN-353 or equivalent grade material capable of withstanding continuous temperature up to 200 deg. C
	03	Inner surface finish	Mirror finish (Shining type) interior surfaces
	04	Dimensional Tolerance	As per Drawing No. RD-DG-4-26-1133-0000 and RD-DG-4-26-1133-5000.
	05	Supply of "Mould Drawings" by the Vendor	The Vendor should submit the "Mould Drawings" along with detailed specifications, while submitting the Technical Bid. Offers received without detailed mould drawing will not be considered for further evaluation.
	06	Mould Usage Criteria	The mould should be suitable for casting/moulding commercial-grade 'Polymeric Epoxy Resin Hardener System'.
C	General Specification (Mould for Core Impregnation and Silicone Shed Manufacturing)		
	01	General	The mould for both Core Impregnation and Silicone Shed Manufacturing should be of TWO - PART mould with filling port/provision at the bottom of mould. Both the moulds should have leak proof arrangement by using O-Ring and should also have provision for trouble free opening of moulded components.



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02	O rings	06 nos. of O-ring for each mould to be supplied at the time of delivery.
03	Removal of cured job	Suitable arrangement for easy removal of cured job from the mould to be provided.
04	Lifting arrangement	Suitable arrangements to be provided for easy lifting and handling of the moulds.
05	Port arrangement for material filling.	Suitable clearance to be provided at the bottom of the mould to accommodate the filling port and other accessories.
06	Guiding arrangement	Suitable guiding system / arrangement to be provided in the mould for easy and appropriate interlocking of each half of the mould.

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