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REV. 03	DATE 9.8.85	ALTERED <i>sd.</i> CHECKED <i>sd.</i>	REV. 04	DATE 2.3.93	ALTERED <i>sd.</i> CHECKED <i>sd.</i>	ADDITIONAL INFORMATION
DIMN 35 WAS 40 AND SPEC NO 7610 B WAS 2704/FP.			SPEC NO. 7604 B ADDED.			STATUS OF DRAWING
REV. 05	DATE 4.3.93	DRG RETRACED.				
REV. 06	DATE 15.12.93	ALT. <i>Chand</i> CHD. <i>sd.</i>				
AGAINST SL. NO. 2 SPECIFICATION NO. WAS 7604 B.						

SPECIAL INSTRUCTIONS—

1 FOR SWEATING/TINNING (FLEXIBLES):

- 1.1 CLEAN INDIVIDUAL SHEET ELECTROTINNED 4 TO 5 MICRON TK AS PER PR. SPEC NO. 7610 B TO A SURFACE AS PER FIG.1
- 1.2 CLAMP TOGETHER REQUIRED NO. OF PARALLEL STRIPS, APPLY FLUX, DIP IN TO SOLDERING BATH CONTAINING 60% TIN AND 40% LEAD. REMOVE THE BUNCH FROM BATH, SHAKE IT WELL TO REMOVE EXCESS MATERIAL, PRESS IT WELL TO GET REQUIRED TK'S, GROUND THE EDGES AFTER SOLDERING, REFIL IF CAVITIES ARE LEFT ON EDGES, GROUND/BUFF THE EDGES SMOOTHLY.

FOR SILVER PLATING:

- 1.3 REMOVE SWEATING MATERIAL FROM OUTER SURFACES ONLY FOR SILVER PLATING PURPOSES. AFTER PROPER CLEANING, SILVER PLATING TO BE DONE TO 13 TO 15 MICRON TK.

2. FOR CONDUCTOR PALM AND OTHER ITEM TO SPEC NO. AA0673613.

- 2.1 HANDLE CAREFULLY TO AVOID DENTS ETC, SKIM CUT IF DENTS ARE VISIBLE. SILVER PLATE 13 TO 15 MICRON TK TO THE REQUIRED LENGTH AS PER FIG.1

3. HANDLING:

- 3.1 SILVER PLATED SURFACE TO BE COVERED BY COTTON/ ASBESTOS TAPE AFTER SILVER PLATING.
- 3.2 TAKE PROPER CARE THAT "SILVER PLATED" SURFACES SHOULD NOT BE DAMAGED WHILE WELDING THE CONDUCTOR.
- 3.3 COTTON/ ASBESTOS TAPE SHOULD NOT BE REMOVED AT ANY STAGE TILL THE CONDUCTORS ARE REQUIRED FOR MAKING THE BOLTED JOINTS AT SITE.

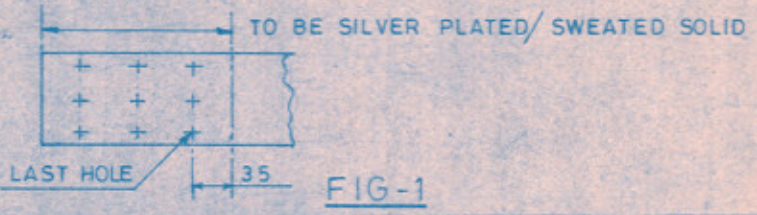


FIG-1

66	64	63	62	61	53	52	51	22	18	20	22	23	34	35	36	39	50	58	59	64	65	73	79	80
QTY				UNIT OF QTY.				DESCRIPTION	ITEM No.	STD.	DRAWING No.	ITEM No.	MATL. CODE	MATL. SPECN.	COMP GROUP	UNIT WEIGHT (Kg.)	QTY.	BMT/GRSP	D1					
VARI-ANT		BASIC VARI-ANT		R.M UNIT		QTY.																		
ANT		ANT		61		54		21		21		CARDTYPE-1												

BHARAT HEAVY ELECTRICALS LIMITED

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DEPT SWE	CODE 409		SCALE	WEIGHT (Kg.)	REF. TO ASSY. DRG.	ITEM No.	
TITLE GENERAL INSTRUCTIONS FOR SWEATING & SILVER PLATING ON COPPER CONDUCTOR & FLEXIBLE					DRAWN H. LAL	SIGN. <i>sd.</i>	DATE 5.6.81
					CHECKED ILB	SIGN. <i>sd.</i>	DATE 5.6.81
					APPROVED <i>sd.</i>	SIGN. <i>sd.</i>	DATE

DIMENSIONS TO BE CONTROLLED WITHIN AS LIMITS SHOWN.				DRAWING No.	15	16	17
MACHINING TOLERANCE ± 0.25 mm UNLESS OTHERWISE SHOWN.					4	5	6
NON - MACHINING TOLERANCE ±				CARD CODE 4 5 4 1 0 0 0 0 0 0 0 5	REV. 0 6		
				SHEET No. 1	No. OF SHEETS		