

REV	DATE	ALTERED	REV	DATE	ALTERED	ADDITIONAL INFORMATION
06	29.07.08	CHECKED			CHECKED	STATUS OF DRAWING
DRAWING RETRACED.						DISTRIBUTION OF PRINTS

SPECIAL INSTRUCTIONS:-

1. FOR SWEATING/TINNING (FLEXIBLES)

- 1.1 CLEAN INDIVIDUAL SHEET ELECTRO-TINNED 4 TO 5 MICRON AS PER SPEC. NO. 7610B 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 THICKNESS, GROUND THE EDGE AFTER SOLDERING, REFIL IF CAVITIES ARE LEFT ON EDGE, GROUND/BUFF THE EDGE SMOOTHLY.

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 THICKNESS 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.

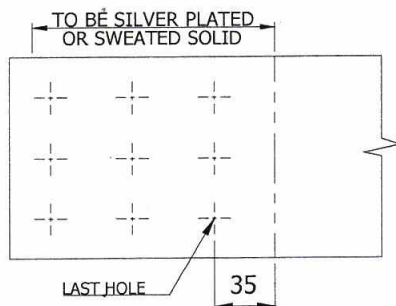


FIG - 1

	BHARAT HEAVY ELECTRICALS LTD. RUDRAPUR		NAME	SIGN	DATE
			DRN	VISHAL	29.07.08
			CHD	P.SINGH	29.07.08
			APPD	RK LAL	29.07.08
DEPT.	ECC		SCALE	N.T.S.	Wt. [Kg]
REF. TO ASSY. DRG.			ITEM No		
TITLE			DRAWING NO.		
GEN. INSTRUCTION FOR SWEATING & SILVER PLATING ON COPPER CONDUCTOR & FLEXIBLE			4 541 00 00 005		
			REV.		
			06		
SHEET NO. -03			NO. OF SHEETS -03		