

Distribution:		Date of Rev. 00: 10/12/1986	Name	Signature
LEM / IMM	1/1	Prepared by	Gautam Kumar	
GTG (EM)	2			
LEM (QC) / IMM (QC)	1/1	Checked by	Nidhi Gupta	
AME	1	Approved by	A. Tijare	
CIM	2			
CIM (QC)	1	Issued by	B.N. Oraon	
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE STATED				

3.0 Procedure for consolidation

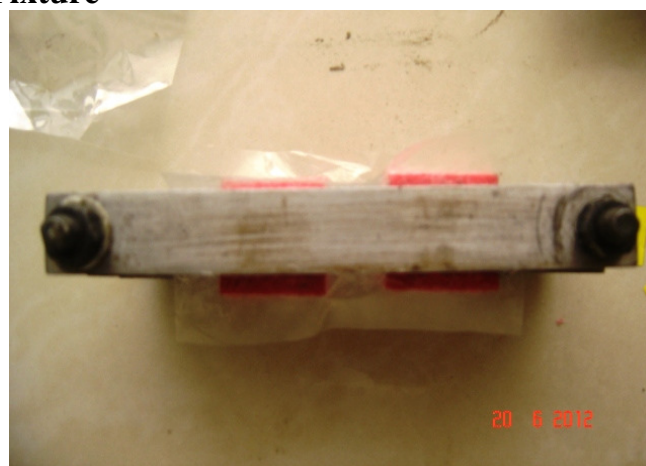
Take the required amount of Hm 693 pieces cut to 30 mm X 30 mm size and build up approximately to 36 mm-42 mm (i.e. 12 to 14 pieces of 3 mm thick Hm 693). Compress it with a pressure of 25 N/mm² using suitable spacer of 25mm thick between press plates. Take out from press and clamp the test pieces as shown in Cl.2. keeping the spacer height of 25 mm and projection of 5 mm from the clamps . (Use a small amount of silicon releaser on the clamp and place thin polyester release film AA 22801 between the test piece and the clamp)

Heat the clamped sample and the resin separately in oven to acquire 70 °C. Then dip the clamped Hm 693 packer in the resin completely. Heat it for 3 hours in oven in dipped condition for impregnation maintaining 70°C temperature. After impregnation take out the sample from resin. Cure the sample at 140°C for next 3 hours.

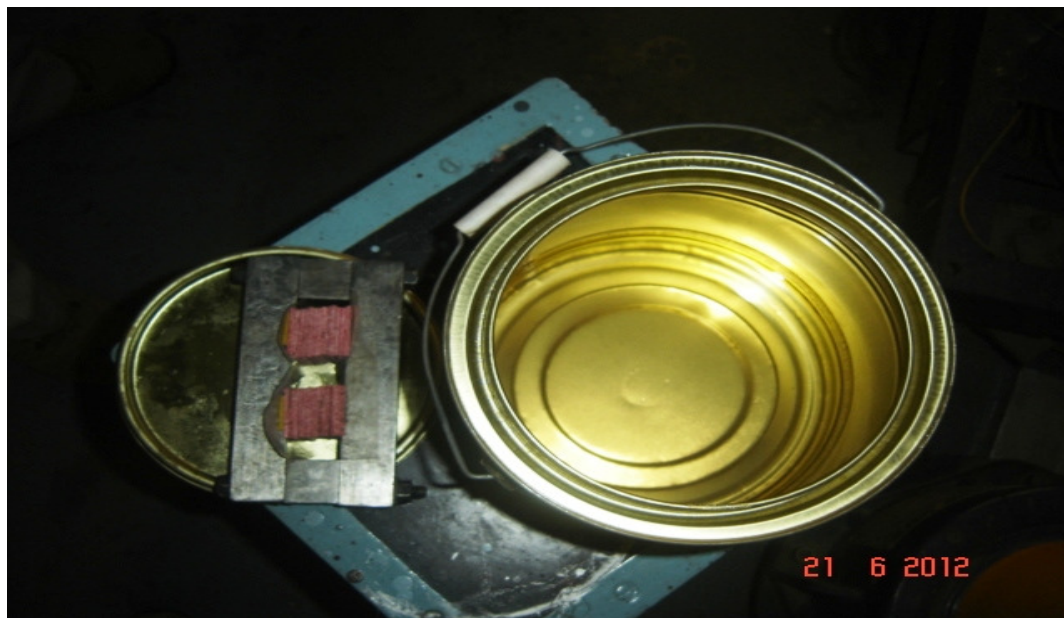
Process is elaborated in the following photos :



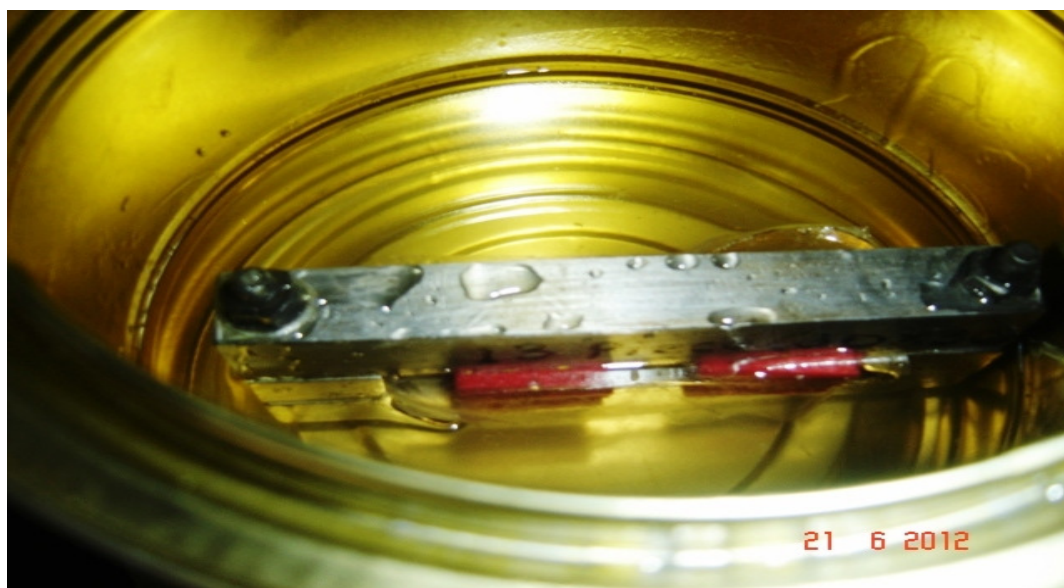
Front view of Hm 693 in Fixture



Top view of Hm 693 in Fixture

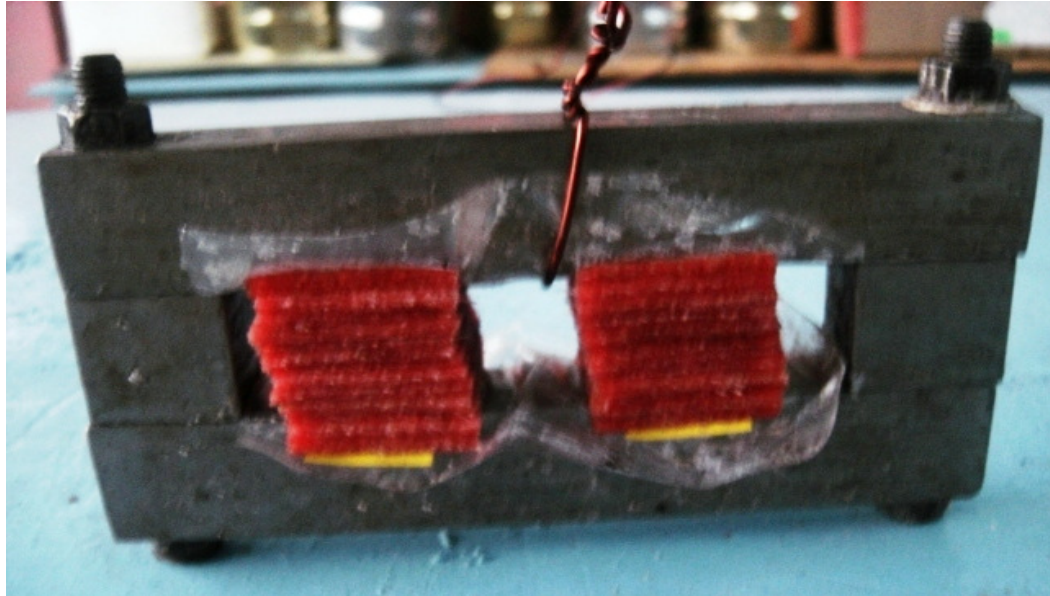


Resin & Hm 693 clamped in Fixture heated separately till they acquire 70°C



Sample completely dipped in resin and heated for 3hrs at 70°C in oven for impregnation

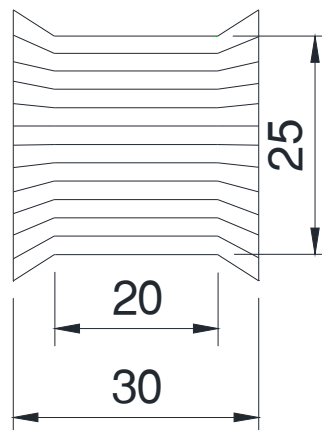
INSULATION SKETCH	IN. SK.46016
INSULATION SYSTEMS ENGINEERING	Rev. No.: 01
TEST FOR ABSORPTION AND CONSOLIDATION QUALITY OF Hm 693 PACKING MATERIAL	Rev. Dt.:22/03/2013
	Sht. 4 of 5 sheets.



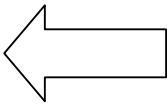
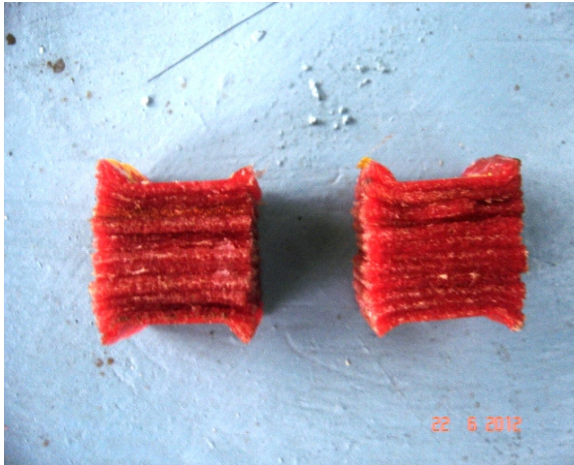
Curing in oven at 140°C for 3 hrs

4. Observation on the Test Piece

- 1) Test piece should be a single monolithic piece without delamination.
- 2) There should be expansion at the edges where the Hm 693 was projecting beyond the clamps. See the following figure

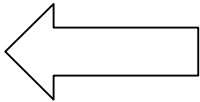
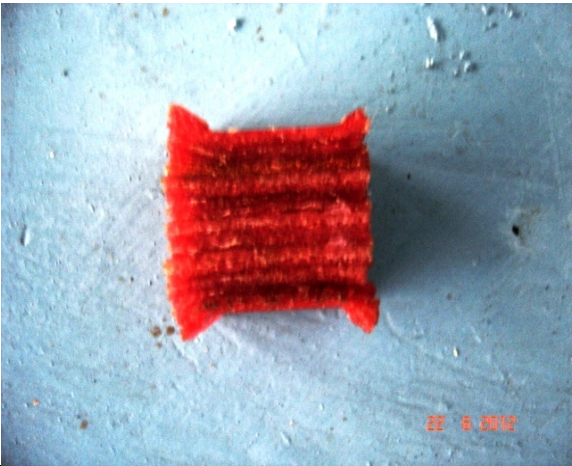
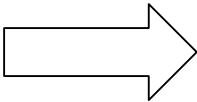


- 3) The test piece can be cut in the middle and checked for consolidation quality by visual inspection.



**Dismantling of the
fixture and checking
bonding and swelling at
edges**

**Test sample edges
have swelled by
6mm**



Final test piece