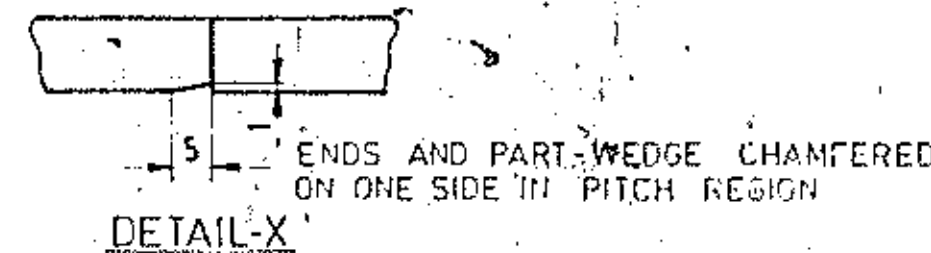
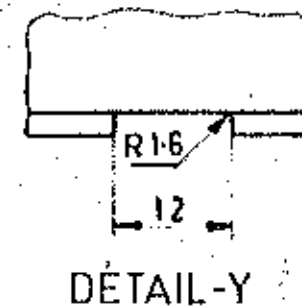
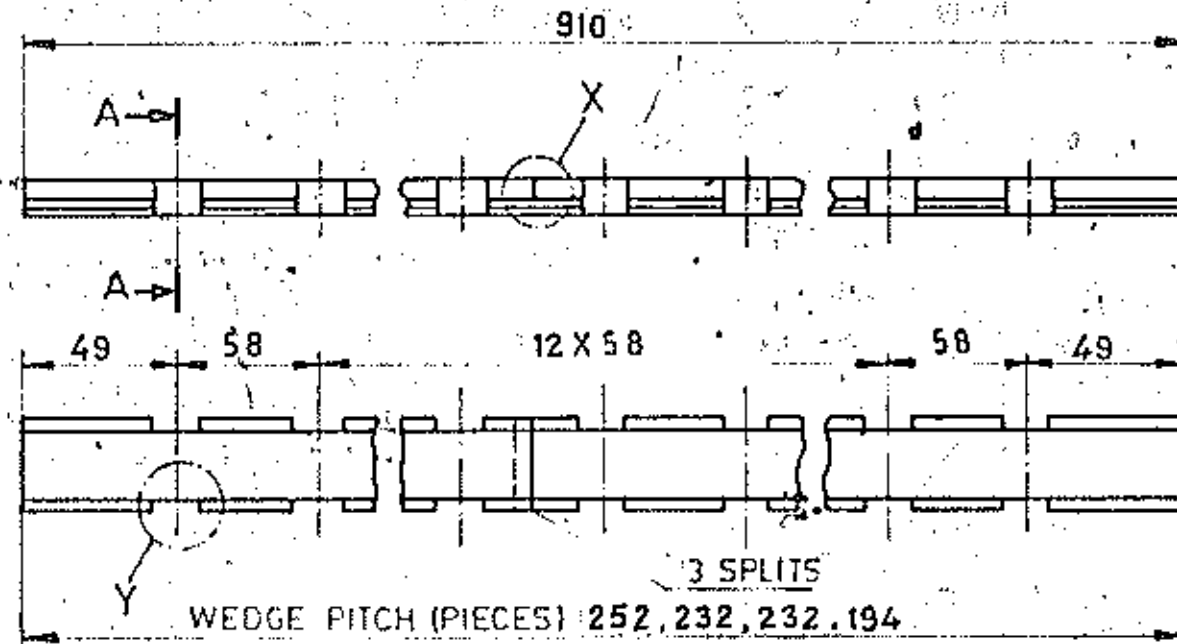


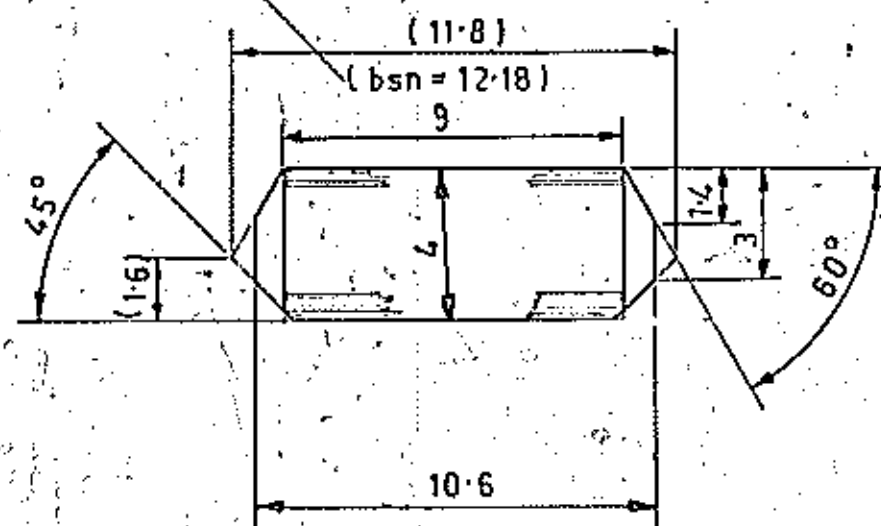
1009708 207 Z



TECHNICAL REQUIREMENTS -

1. WEDGE TO BE MANUFACTURED IN ONE PIECE AND THEN PARTED OFF TO SPECIFIED LENGTHS.
2. ALL PART WEDGE WHEN ASSEMBLED SHOULD FORM TO THE GIVEN LENGTH SPLITTING ALLOWANCE TO BE DECIDED SUITABLY BY SUPPLIER.
3. EACH ITEM TO BE GIVEN SUITABLE IDENTIFICATION TAG WHEN SUPPLIED.
4. TOLERANCE ON ALL MANUFACTURED DIMENSIONS TO BE ± 0.1 .
5. DIMENSION IN BRACKETS ARE FOR REFERENCE ONLY.

TIP DIMENSION OF PUNCHED STAMPING



ENLARGED SECTION A-A

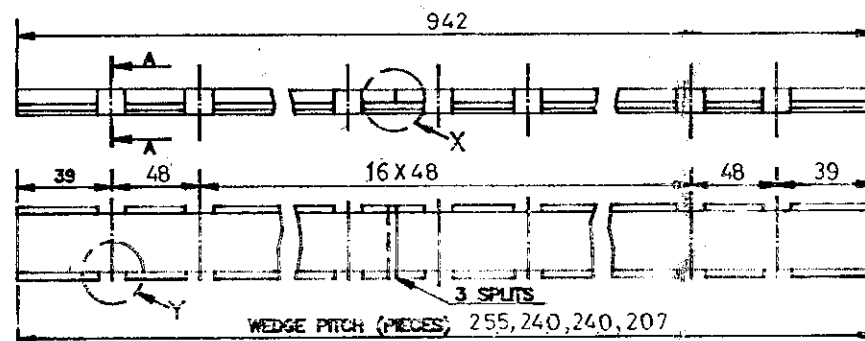
VAR. NO.	REMARKS	VAR. NO.	ITL. NO.	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.	QTY
01		03		SLOT WEDGE 4TKX10.6X194		AA22415	0.017	
02		02		SLOT WEDGE 4TKX10.6X232		AA22415	0.02	
01		01		SLOT WEDGE 4TKX10.6X252		AA22415	0.021	

ADDITIONAL INFORMATION WO 44061A22-11.81		TYPE OF PRODUCT: 1RR 7636 OR NAME OF CUSTOMER/PROJECT: M/S VISHNU CEMENTS	
STATUS OF DRAWING		DISTRIBUTION OF PRINTS	
D.C. - 1 P.L.M. - 4 T.CX(P.L.M.) - 1		D.C. - 1 P.L.M. - 4 T.CX(P.L.M.) - 1	
REV. DATE ALT. CHD.		REV. DATE ALT. CHD.	
04 22-7-96 CHECKED		04 22-7-96 CHECKED	
DRG. RETRACED		DRG. RETRACED	
DEPT. CODE 404		GRADE OF UN. TOL. DIM. 404	
SCALE: N.T.S.		WEIGHT (kg): 0.078	
TITLE: ROTOR WEDGE		REF. TO ASSY. DRG. 04028040001	
CARD CODE		DRAWING NO. 24028046001	
SHEET NO. 01		NO. OF SHEETS 01	

34028046019

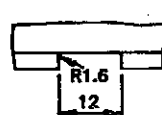
DIN 9134

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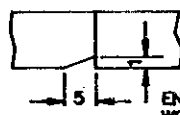


TECHNICAL REQUIREMENTS :-

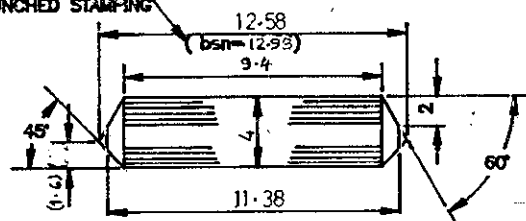
1. WEDGE TO BE MANUFACTURED IN ONE PIECE AND THEN PARTED OFF TO SPECIFIED LENGTHS.
2. ALL PART WEDGES WHEN ASSEMBLED SHOULD FORM TO THE GIVEN LENGTH SPLITTING ALLOWANCE TO BE DECIDED SUITABLY BY SUPPLIER.
3. EACH ITEMS TO BE GIVEN SUITABLE IDENTIFICATION TAG WHEN SUPPLIED.
4. TOLERANCE ON ALL MANUFACTURED DIMENSIONS TO BE ± 0.1 .
5. DIMENSION IN BRACKETS ARE FOR REFERENCE ONLY.



DETAIL-Y



DETAIL-X

ENDS AND PART
WEDGE CHAMFERED
ON ONE SIDE IN
PITCH REGIONTIP DIMENSION OF
PUNCHED STAMPING

ENLARGED SECTION A-A

01		04	SLOT WEDGE 4 TK-X12-58 X 207		AA 22415	0-019
01		03	SLOT WEDGE 4 TK-X12-58 X 240		AA 22415	0-022
01		02	SLOT WEDGE 4 TK-X12-58 X 240		AA 22415	0-022
01		01	SLOT WEDGE 4 TK-X12-58 X 255		AA 22415	0-023

APPROVED BY
W.O. 44189 A422-11821

SIGNATURE OF DRAWER

 DISTRIBUTION OF PARTS
 O.C.-1 IMM-3
 PLM-4
 TCX(PLM)-1 TEX(imm)-1

TYPE OF PRODUCT

1LS 7804-6

NAME OF CUSTOMER/PROJECT

M/S. J.P. BELA



BHARAT HEAVY ELECTRICALS LTD.

BRIHAL

DATE	NAME	SIGN.	DATE
19-12-94	U.N.W.	U.N.W.	19-12-94
19-12-94	D.K.D.	D.K.D.	19-12-94
22-12-94	N.G.N.	N.G.N.	22-12-94

 REV. 1
 DATE 20-12-94
 ALTERED BY
 IN DISTRIBUTION IMM
 & TEX(imm) ADDED.

 DEPT. AME
 CODE 404
 GRADE OF UN. TOL. E/NVE
SCALE
NTSWEIGHT(KG)
0-086
 REF. TO ASSY. DRG.
 TERN NO.
 78 77

TITLE

ROTOR WEDGE

CARD
CODEDRAWING NO.
34028046019

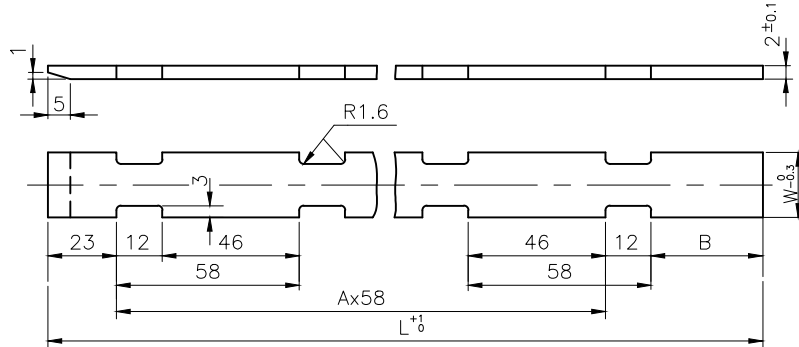
SHEET NO. NO. OF SHEETS

REV
01

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

REV	DATE	ALTERED	RV	ADDITION INFORMATION
29	18.3.11	CHECKED	ALC	—
		APPROVED	ALC	STATUS OF DRAWING
IT. 50 ADDED.			DISTRIBUTION OF PRINT	
IT. 51 ADDED.			AME-1, HGM-3, TEX(HGM)-1	



MATERIAL— AA22415

ITEM NO.	A	B	W	L	WT. kg	W.O. NO.
01	6	58	13.4	441	0.024	41245A423-11
02	5	33	11.8	358	0.014	41272L423-11
03	6	33	11.8	416	0.017	41272L423-11
04	8	73	11.8	572	0.024	42185A421-11
05	9	73	11.8	630	0.026	42185A421-11
06	4	63	18.8	330	0.021	42188A423-11
07	3	63	18.8	272	0.018	42188A423-11
08	7	53	17.8	494	0.032	43408L421-11
09	7	33	20.8	474	0.035	43163A421-11
10	8	63	14.8	562	0.035	42180A423-61
11	7	63	14.8	504	0.031	42180A423-61
12	6	53	17.8	436	0.028	44051A421-11
13	6	63	19.8	446	0.031	44017A422-31
14	5	63	19.8	388	0.027	44017A422-31
15	2	68	17.5	219	0.013	44407L423-11
16	3	68	17.5	277	0.017	44407L423-11
17	6	53	15.8	436	0.024	43016A425-61
18	6	23	15.8	406	0.023	43016A425-61
19	5	53	15.4	378	0.021	44074A425-31
20	6	53	16.4	436	0.024	44069A425-31
21	5	53	16.2	378	0.022	43378A425-31
22	6	53	16.6	436	0.026	44144A425-11
23	7	53	16.6	494	0.03	-----DO-----
24	6	63	20.0	446	0.03	44424L422-11
25	7	63	20.0	504	0.036	-----DO-----
26	8	53	20.1	552	0.040	45008A275-21
27	9	53	20.1	610	0.044	45008A275-21
28	8	63	13.4	562	0.027	44478P423-71
29	9	63	13.4	620	0.030	44478P423-71

ITEM NO.	A	B	W	L	WT. kg	W.O. NO.
30	6	43	17.8	426	0.028	
31	5	43	17.8	368	0.023	
32	8	33	19.3	532	0.036	46262A423-11
33	9	33	19.3	590	0.040	46262A423-11
34	6	53	12.4	436	0.024	47085A421-21
35	7	53	12.4	494	0.026	47085A421-21
36	8	63	17.3	562	0.035	47197A423-31
37	7	63	17.3	504	0.031	47197A423-31
38	5	53	11.4	378	0.015	47160A421-11
39	4	53	11.4	320	0.013	47160A421-11
40	8	53	20.8	552	0.036	47045A422-92
41	9	53	20.8	610	0.040	47045A422-92
42	7	33	19.8	474	0.033	47090P426-21
43	6	33	19.8	416	0.029	47090P426-21
44	7	73	20	514	0.034	48019A422-12
45	8	73	20	572	0.041	48019A422-12
46	9	53	22.8	610	0.047	48141T421-11
47	9	53	18.8	610	0.039	49072P421-41
48	10	53	18.8	668	0.042	49072P421-41
49	8	53	20.8	552	0.042	47090P426-11
50	8	53	13.4	552	0.027	40134A275-11
51	7	53	13.4	494	0.024	44113A275-11



BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

DRN	NAME	SIGN	DATE	73 NO. OF VAR
CKD	LP	Sd/-	5.12.01	
APPD	RPG	Sd/-	5.12.01	
	SB	Sd/-	5.12.01	

DEPT.	GRADE OF UNTOL.	SCALE	WEIGHT (kg)	REF. TO ASSY. DRG.	ITEM NO.	75 NO. OF ITEMS
AME	DIM. C/M/F	NTS	—			
CODE						
404						
TITLE				DRAWING NO.		
STATOR SLOT WEDGE				4 402 05 46235		
(R' TYPE)				REV. 30		
				SHEET NO. 01		
				NO. OF SHEET 01		

SIZE A4

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AM 54235
REF. DRG. NO.

SIGN. & DATE

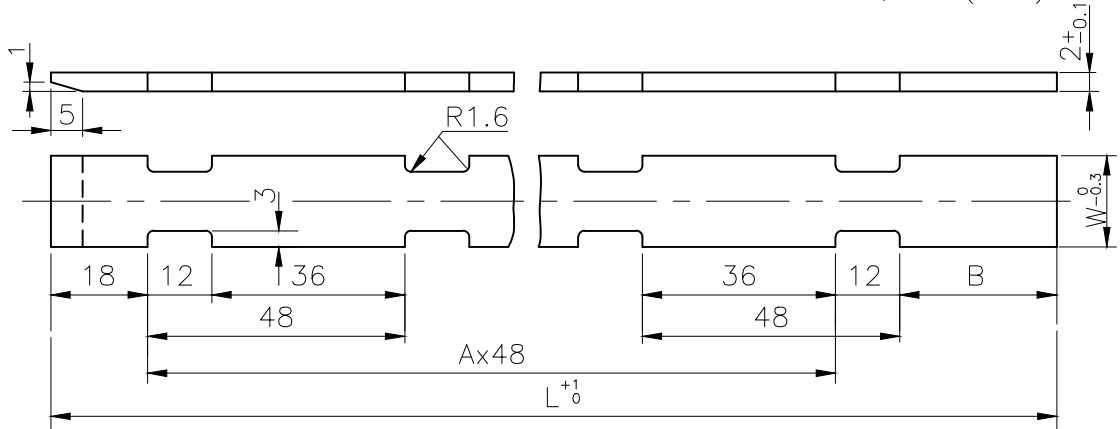
INVENTORY NO.

RV/AMDrg./44020546235

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

REV	DATE	ALTERED	REV	DATE	ALTERED	ADDITION INFORMATION
13	29.08.09	CHECKED	12	29.07.09	CHECKED	—
		APPROVED			APPROVED	STATUS OF DRAWING
ITS. 19&20 ADDED.			ITS. 17&18 ADDED.			DISTRIBUTION OF PRINT AME-1, PLM-3, TEX(PLM)-1



ITEM NO.	A	B	W	L	WEIGHT kg	W.O.
01	6	43	16.8	361	0.017	41273A421-11
02	5	43	16.8	313	0.015	41273A421-11
03	7	33	12.0	399	0.017	42082A421-21
04	10	43	20.3	553	0.040	43032A421-11
05	9	43	20.3	505	0.037	43032A421-11
06	9	43	19.8	505	0.036	43077T421-11
07	9	43	21.8	505	0.040	43103A422-71,81
08	7	33	19.2	399	0.0272	43157A421-11
09	9	43	18.1	505	0.033	43186A421-11
10	10	43	18.1	553	0.036	43186A421-11
11	7	33	19.8	399	0.028	44178A423-11
12	8	33	19.8	447	0.04	44178A423-11
13	9	43	17.3	505	0.031	47063A423-21
14	8	43	16.3	457	0.0265	48041A423-11
15	7	43	16.3	409	0.024	48041A423-11
16	8	43	17.3	457	0.026	48129A423-51
17	10	91	16.3	601	0.033	48064P423-71
18	9	91	16.3	553	0.030	48064P423-71
19	10	43	16.8	553	0.033	49054A423-11
20	9	43	16.8	505	0.03	49054A423-11

AM 54239

REF. DRG. NO.

SIGN. & DATE



BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

DRN

NAME

SIGN

DATE

73 NO. OF
74 VAR

CKD

RPG

Sd/-

29.1.02

APPD

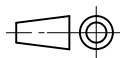
SB

Sd/-

29.1.02

DEPT.

AME

GRADE OF UNTOL.
DIM. C/M/F

SCALE

NTS

WEIGHT (kg)

—

REF. TO ASSY. DRG.

ITEM NO.

75 NO. OF
77 ITEMS

INVENTORY NO.

CODE

404

TITLE

STATOR SLOT WEDGE
(‘L’ TYPE)

DRAWING NO.

4 402 05 46239

REV.

13

SHEET NO.

01

NO. OF SHEET

01

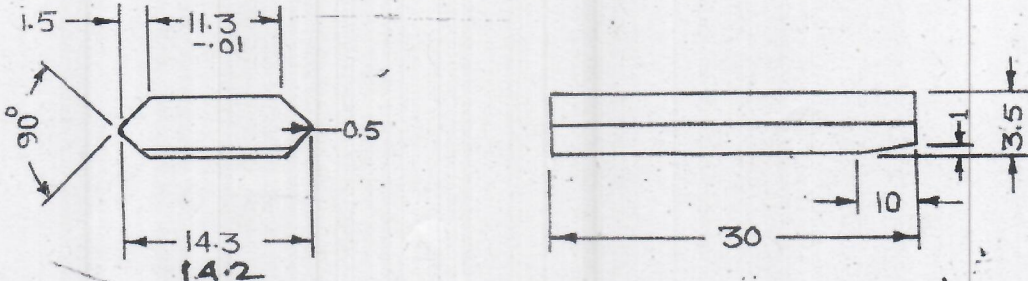
SIZE A4

RV/AMDrg./44020546239

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REV. 02	DATE 1/6/88	CHECKED <i>[Signature]</i>	REV. 01	DATE 26/10/87	CHECKED <i>[Signature]</i>	ALTERED <i>[Signature]</i>	ADDITIONAL INFORMATION
LIMIT OF DIMENSION 14.3 WAS NOT ON			STYLE NO. ADDED			STATUS OF DRAWING	
						DISTRIBUTION OF PRINTS	
						AME - 1	
						IMM - 3	
						TEX - 1	
REV. 03		DATE 25/1/99	ALTD. (SPV)		CKD. <i>[Signature]</i>		
12 DIGITS NEW ST. NO. BP 9064032882, ADDED.							



NOTE :-
ITEM IS BOUGHTOUT.

STYLE NO. BP9064032882

REF. DRG. NO.	3.5X143X30.0	DESCRIPTION	SLOT WEDGE	ITEM NO.	1	MATERIAL CODE	PS 22415	UNIT WT (Kg)	3.09
QTY.	1	UNIT OF QTY.		DRAWING NO.		MATERIAL SPECN.		QTY.	
CARD TYPE 2 ← 21 21 → CARD TYPE 1									
SIGN & DATE		BHARAT HEAVY ELECTRICALS LIMITED BHOPAL							
DEPT. ISE	CODE 419	SCALE	NTS.	WEIGHT (Kg.)	REF. TO	DRG. K 149537		ITEM NO.	
TITLE						DRAWN	NAME R.P.S.	SIGN.	DATE 1.9.83
SLOT WEDGE						CHECKED	J.L.R.		1.9.83
						APPROVED	RPA/PNS		1.9.83
DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN				CARD CODE	DRAWING NO. 4025146002				
MACHINING TOLERANCE ± .25 mm., UNLESS OTHERWISE SHOWN.				SHEET NO. 01					
NON-MACHINING TOLERANCE ±				NO. OF SHEETS					

3150138

INVENTORY NO.

MM20400

CHECKED

REV

DATE _____

ALTERED

CHECKED

ADDITIONAL INFORMATION

STATUS OF DRAWING	
1	2
3	4
5	6
7	8
9	10
11	12
13	14
15	16
17	18
19	20
21	22
23	24
25	26
27	28
29	30
31	32
33	34
35	36
37	38
39	40
41	42
43	44
45	46
47	48
49	50
51	52
53	54
55	56
57	58
59	60
61	62
63	64
65	66
67	68
69	70
71	72
73	74
75	76
77	78
79	80
81	82
83	84
85	86
87	88
89	90
91	92
93	94
95	96
97	98
99	100

DISTRIBUTION OF PRINTS

DISTRI
O.C. = 1

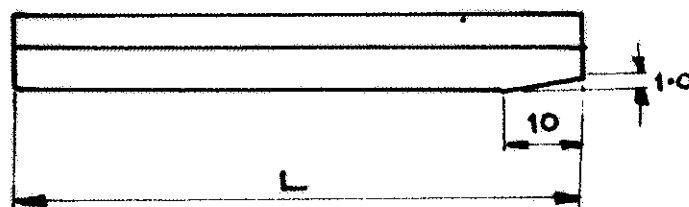
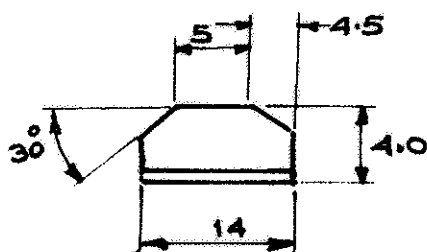
1MM AC -1

AMEH

IMM-3

IMM-TCX-4

NOTE:- ITEMS 001 TO 023 BOTOUT



012	265	}					
011	250			023	430	}	
010	235			022	415		
009	220			021	400		
008	205	EPOXY	020	385	EPOXY		
007	190	}	GLASS	019	370	}	GLASS
006	175		LAMINATE	018	355		LAMINATE
005	160		TO	017	340		TO
004	145		AA 22415	016	325		AA22415
003	130			015	310		
002	115			014	295		
001	100	}		013	280		

L-LENGTH										L-LENGTH																					
66	64	63	62	63	52	51	22	18	20	22	23	34	35	36	39	50	58	59	64	65	73	79	80								
QTY. BASIC				UNIT OF QTY.		DESCRIPTION						ITEM NO.		STOS.		DRAWING NO.		ITEM NO.		MATERIAL CODE		AC		COMP		GROUP		UNIT WT (Kg)		QTY	
VARI- ANT Q.O.				VARI- ANT		RM UNIT QTY.								37 38 VARI- ANT		54		MATERIAL SPECN		57											

CARD TYPE 2

CARD TYPE 1



BHARAT HEAVY ELECTRICALS LIMITED
BHOPAL



DEPT.	CODE		SCALE	WEIGHT (Kg.)	REF. TO ASSY. DRG.	ITEM NO.
-------	------	---	-------	--------------	--------------------	----------

TITLE
ROTOR SLOT WEDGE

DRAWN	NAME KAUSHIK	SIGN. <i>[Signature]</i>	DATE 1.2.90
CHECKED	JLR	<i>[Signature]</i>	1.2.90
APPROVED	<i>[Signature]</i>	<i>[Signature]</i>	1-2-90

**DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN
MACHINING TOLERANCE $\pm .25$ mm., UNLESS OTHERWISE
SHOWN**

NON-MACHINING TOLERANCE +

**CARD
CODE**

DRAWING NO.

44028046029

SHEET NO.

NO. OF SHEETS :-

15 16 17
1 REV



CORPORATE PURCHASING SPECIFICATION

AA 224 15

Rev. No. 02

PAGE 1 OF 5

EPOXY LAMINATED GLASS FABRIC BASE SHEET (TEMPERATURE INDEX 155)

1.0 GENERAL:

This specification governs the quality requirements of laminated sheet made from layers of fine and plain woven glass fabric (non-alkaline glass type E) having suitable silane/volan finish with good electrical properties using thermosetting epoxy resin as the bonding medium. The material has a temperature index of at least 155.

2.0 APPLICATION:

This material may be used with discretion for insulating spacers, wedges, packers and pressed parts of electrical machines.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply, in general, with the requirements of the following standards and also meet the requirements of this specification.

NEMA-LI-1: 1989, Gr. G-11.

4.0 DIMENSIONS AND TOLERANCES:

4.1 Sizes:

Thickness, width and length shall be as stated on BHEL order.

4.2 Preferred thickness (mm):

0.5, 1, 1.5, 2, 3, 4, 5, 6, 8, 10, 12, 15, 20, 25, 30, 40, 50 and 70.
Other thickness can also be ordered.

4.3 Tolerances:

4.3.1 Thickness:

Thickness of the sheet shall not depart at any point from the nominal thickness by more than the appropriate value as shown in the following table:

Revisions :

Cl: 32.4.43 of MOM of MRC-E

APPROVED :

INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (E)

Rev. No. 02

Amd.No.

Reaffirmed

Prepared

Issued

Dt. of 1st Issue

Dt:15.01.2003


Dt :

Year :

HYDERABAD

Corp. R&D

May, 1980

AA 224 15		CORPORATE PURCHASING SPECIFICATION	
Rev. No. 02			
PAGE 2 OF 5			

Thickness, mm		Permissible variation from nominal thickness, mm
Above	upto & including	
-	0.5	0.10
0.5	2	0.20
2	3	0.25
3	5	0.50
5	7	0.75
7	10	0.90
10	15	1.10
15	20	1.25
20	25	1.40
25	30	1.50
30	40	1.75
40	50	2.00
50	60	2.50
60	70	3.00

4.3.2 Width and Length:

Size, mm	Tolerance, ± mm
Below 1000	35
Above 1000	50

4.4 Flatness (for sheets 3.0mm and above):

The flatness of sheets shall be such that when a sheet is placed without restraint on a flat surface, concave side, if present, up, departure at any point of the surface from a light straight edge laid in any direction upon it shall not exceed the following:


- a) 0.50 mm under a 300 mm straight edge.
- b) 3.00 mm under a 600 mm straight edge.
- c) 6.00 mm under a 1000 mm straight edge.

5.0 FINISH:

The surface of the sheets shall be even, smooth, free from visible defects like blisters, loose fibres, resin concentration, delamination, wrinkles, local deformation and dents. The materials shall be supplied with trimmed edges.

6.0 TEST METHODS:

Unless otherwise specified the tests shall be conducted in accordance with the relevant methods of BHEL standard AA 085 17 01.

	CORPORATE PURCHASING SPECIFICATION	AA 224 15
		Rev. No. 02
		PAGE 3 OF 5

7.0 SAMPLING AND ACCEPTANCE:

7.1 Routine and Acceptance Tests:

Unless otherwise stated, one sheet chosen at random out of every 20 sheets of a supply shall be subjected to routine tests. One sheet of 300 X 300 mm of 10 mm thickness shall be supplied with each consignment.

The arithmetic mean of the test results for an individual test shall meet the requirement of this specification.

The lowest value obtained for any test shall not be less than 90% at the specified value.

7.2 Type Tests:

Type tests shall be carried out at the time of first approval and subsequently once in two years and whenever doubt arises, on the quality of the material.

8.0 PHYSICAL PROPERTIES:

8.1 Specific Gravity : 1.8 ± 0.1

8.2 Marten's Heat distortion Temperature (Type test)
(For thickness 10mm and above) : 240°C , min


8.3 Water Absorption at 20°C for 24 hours (Type test):

Thickness (mm)		Water absorption %, max.
Above	upto & including	
-	1	0.40
1	1.5	0.30
1.5	3	0.20
3	10	0.15
10	25	0.10
More than	25*	0.10

* Thickness above 25 mm shall be machined to 25 mm keeping one side intact.

8.4 Texture of Glass Fabric:

For laminates upto 20 mm thickness a fine woven glass cloth of 0.18mm thick shall be used. For laminates above 20mm thickness a glass cloth of not more than 0.255 mm thick shall be used. This shall be checked by burning the bonding at 600°C for sufficient time.

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8.5 Heat Shock Test:

A specimen of size 100x100 of ordered thickness is kept in an oven maintained at 250±5⁰ C for 15 minutes. The specimen is removed directly to ambient conditions (ie. Room temperature) after this period and observed. The material is considered satisfactory in this test, if no delamination, cracks, splitting, blistering or resin oozing is observed at the end of the test.

9.0 MECHANICAL PROPERTIES:

9.1 Tensile Strength (For sheets 1.5 mm thick and above) (Type test):
250 N/mm² (25.5 kg/mm²), min.

9.2 Cross Breaking Strength (For sheet 1.5 mm thick and above):

9.2.1 As received condition: 350 N/mm² (35.6 kg/mm²), min.

9.2.2 After heating at 150⁰C for 1 hour and tested at 150⁰C. The reduction shall not be more than 50% of the value obtained in received condition.

9.3 Shear strength (for sheets 1.5 mm thick and above) (Type test):
100 N/mm² (10.2 kgf/mm²), min.

9.4 Compression strength proof (For sheets 5 mm thick & above) (Type test):
400 N/mm² (40.8 kgf/mm²).

9.5 Impact strength Charpy - Flatwise (For sheets 2.5 mm & above) (Type test):

Below 10 mm thick	:	75 kJ/m ² , min.
10 mm thick & above	:	150 kJ/m ² , min.

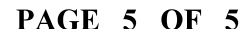
9.6 Splitting load, Edgewise (For sheets 10 mm thick and above): 2.94 kN (300 kg), min.

9.7 Punching (For sheets below 2.5 mm) (Type test):
When the sheet under test is pierced in a single operation with a pattern shown in IS: 1998. There shall not be excessive lifting or cracking around the holes.

9.8 Machinability (For sheets 3.0mm and above) (Type test):
The sheet shall be capable of being sawn, milled, drilled and tapped with a M3.5 tap and shall be capable of being shaped in a shaping machine without showing any sign of cracking or chipping.

10.0 ELECTRICAL PROPERTIES:

10.1 Insulation Resistance after 24 hours immersion in water at 27⁰C (Type test):
10⁴ Megohms, min.



- 1) AA 085 17 01 2) IS;1998 3) NEMA - L1-1



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

QUALITY PLAN FOR – COMPONENTS OF EPOXY LAMINATED GLASS FABRIC BASE SHEET TO SPEC. AA 22415

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DATED: 17.08.2020

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ABBREVIATION:

#	1. In case TCs of NABL Lab, results of TC shall be strictly as per scope/range of NABL accreditation. BHEL/TPIA witness shall be waived off in such case. TC/TR shall be cleared based on Record Review basis.
	2. In case of TCs of Labs other than accredited by NABL, traceability shall be verified by inspection agency for the equipment/ instrument used for conducting the test and shall be reported in the TCs. BHEL/TPIA shall witness the tests in such cases.
V	Visual
M	Measurement
T	Testing
RT	Routine Test
TT	Type test (Validity for 2 years)

SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
1.0		Physical Properties Specific Gravity, Water Absorption, Texture of Glass Fabric, Heat Shock Test	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	#
2.0		Dimensional check	M	Random Sample	Drawing	Drawing	TC	BHEL/TPIA	“Witness” as per Sampling Plan (enclosed)
3.0		Mechanical properties							#
3.1		Cross Breaking Strength (For sheet 1.5 mm thick and above):	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	RT
3.2		Tensile Strength and Shear strength (for sheets 1.5 mm thick and above)	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	TT

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APPROVED BY:

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3.3	Compression strength proof (For sheets 5 mm thick & above)	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	TT
3.4	Impact strength Charpy - Flatwise (For sheets 2.5 mm & above)	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	TT
3.5	Punching (For sheets below 2.5 mm)	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	TT
4.0	Electrical Properties							#
4.1	Insulation Resistance	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	TT
4.2	Electric Strength- Flatwise & Edgewise	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	TT
4.3	Dissipation Factor (Tan delta)	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	RT
4.4	Comparative Tracking Index	T	Sample	AA22415	AA22415	TC	BHEL/TPIA	TT
5.0	PACKING AND MARKING: Marking BHEL order No. Manufacturer's / Supplier's Name Batch/Lot No. Thickness, Width and Length. Packing The items shall be suitably packed in wooden case lined with water proof paper from inside.	V	100%	AA22415	AA22415	---	---	Vendor Record

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SINGLE SAMPLING PLAN FOR NORMAL INSPECTION, AQL=4%, INSPECTION LEVEL= II
(AS PER IS -2500, PART-I)

LOT SIZE	SAMPLE SIZE	PERMISSIBLE NUMBER OF DEFECTIVES
2 – 8	2	0
9 – 15	3	0
16 – 25	5	0
26 – 50	8	1
51 – 90	13	1
91 – 150	20	2
151 – 280	32	3
281 – 500	50	5
501 – 1200	80	7
1201 – 3200	125	10
3201 – 10,000	200	14

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