

IOW702-667		PAGE - 1		
SPEC. NO.		TITLE		
A0267		SPECIFICATION OF SPIRAL TUBE (KCTUN-CI)		
H	DY.CEE/TMD	DIMENSION $6.5 \pm 0.2 \text{ mm}$ CHANGED TO $6.5 \pm 0.3 \text{ mm}$ AND DIMENSION $8.5 \pm 0.2 \text{ mm}$ CHANGED TO $8.5 \pm 0.5 \text{ mm}$ VIDE (I) CLW/TM/2026/15120 DT. 25.8.12 (II) RDSO'S L/NO: EL/2.2.8/Htachi DT. - 16.10.2012	fdv	10.10.2012
G	SEE/TMD	DIMENSION 6 OF TABLE 1 CHANGED TO $6.5 \pm 0.2$ AND NOTE 7 CHANGED ACCORDINGLY REF. (I) EL/TM/2026/15120 DT. 06.06.2011 (II) RDSO'S L/NO: EL/2.2.8/HTM DT-15.7.11	Ah	11.11.2011
F	DY.CEE/TMD	NOTE 7 INCORPORATED REF. CLW/TM/15120, DT. 17.2.2010	25m	18.02.10
E	DY.CEE/TMD	PARA-2 AND PARA-6 MODIFIED REF. CLW/TM/20060 DT. 25.6.09	hon	29.8.2009
D	DY.CEE/TMD	PARA-2 AND TABLE-1 MODIFIED, NOTE 6 ADDED REF. L.NO. EL/TM/2013, DT. 01.12.2004	De Anu	15.01.2005
C	DY.CEE/TMD	PARA. 2 MODIFIED AS PER CEE/TM'S NOTE NO. EL/TM/2039 DT. 16.04.2004	Anu	17.04.2004
B	DY.CEE/TMD	Para 5 modified. Ref. L/NO. EL/TM/2013 dt. 26.5.04	SEH	27.5.04
A	SEE/TMD-II	SHELF LIFE INDICATED IN PARA 5.	De ta	13.6.95
ALT. NO.	AUTHORITY	DESCRIPTION	INITIAL	DATE
		MATERIAL SPEC.	IOW702-667	
		12	SH. NO. SH. 1 OF 3	

Signature Not Verified

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L99-702A01

SPEC. NO.

TITLE

A0267

Specification of Spiral Tube (KCTUN-C1)

## 1. Scope

This specification describes Spiral Tube (KCTUN-C1) (hereafter abbreviated as tube) to be used for insulation of electrical machines.

## 2. Construction

ALT. C

Construction of this tube is shown in Fig. 1.

ALT. D

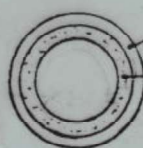


Fig. 1

~~1.6~~  $\times$  13mm Wide  
0.025mm polyimide tape

which is adhered by silicone resin,  $\frac{1}{10}$  lap  $\times$  2

~~1.0~~  $\pm$  0.1mm thick

~~0.8~~mm polyamide non woven tape, which

contains accelerator (P-200-Spec. No. A0271), SOURCED FROM OEM i.e. M/S HITACHI CHEMICAL LTD OR ANY OTHER FOREIGN FIRM MFG. SUCH CHEMICAL TO ITS EXACT SPECIFICATION.

POLYIMIDE ADHESIVE (SILICONE) TAPE TO SPECN. NO. A0123 SHALL BE SOURCED FROM RDSO APPROVED VENDORS ONLY.

## 3. Classification, Dimension and Tolerance

Classification, dimension and tolerance of this tube are given in Table I.

Table 1

Symbol	Nominal inner dia. (mm)	Nominal length (mm)	Tolerance	
			Inner dia. (mm)	Length (mm)
KCTUN-C1 - a	2	1000/ 500	$\pm 0.3$	More than the nominal length
	4		SEE NOTE - 7	
	6.5		$\pm 0.3$	
	7		$\pm 0.5$	
	8			
	10			
	12			
	14		+1.0	
	16		-0.5	
	18			
	20			

Note : a : Nominal inner dia.



DWN. J. M. S. 17.12.13  
CHKD. K. Mishra  
APPD. D. K. S.

MATERIAL SPEC.

Hitachi, Ltd.  
Tokyo Japan

HITACHI WORKS DWG. No.

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SH. No. 1 SH. 2 OF 2



L99-204M01

118-142-3

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4. Quality

Quality of this tube is given in Table 2.

Table 2

No.	Item		Unit	Quality	Remarks
1	Breakdown voltage	Average	kV	$\geq 6$	
		Minimum		$\geq 4$	

ALT. B

5. Shelf life <sup>12</sup> months at  $20 \pm 15^\circ\text{C}$ ,  $65 \pm 20\%$  RH.

ALT. E

ALT. D

6. SPECN. NO. ~~A0133~~ <sup>4TMS.095.038</sup> FOR POLYIMIDE ADHESIVE (SILICONE) TAPE (~~KAPTON-N~~).  
SPECN. NO. A0271 FOR CATALYST/ACCELERATOR - P200 AND SPECN. NO. A0298 FOR POLYAMIDE NON-WOVEN TAPE SHALL BE THE PART OF THIS SPECIFICATION.

ALT. F

7. TEST METHOD. i) INNER DIA SPECIFIED AS  ~~$6.0 \pm 0.3 \text{ mm}$~~   <sup>$6.5 \pm 0.3$</sup>  CAN BE ENSURED BY GO THROUGH A ROD OF  ~~$\phi 6.0 \pm 0.1 \text{ mm}$~~   <sup>$6.5 \pm 0.1 \text{ mm}$</sup> .

ALT. G

ALT. H

ii) OUTER DIA HAVE TO BE MEASURED OVER SPIRAL TUBE HAVING INNER ROD OF  ~~$6.0 \pm 0.1 \text{ mm}$~~   <sup>$6.5 \pm 0.1 \text{ mm}$</sup>  AND O/D SHOULD BE SPECIFIED. VALUE AS  ~~$8.0 \pm 0.3 \text{ mm}$~~   <sup>$8.5 \pm 0.5 \text{ mm}$</sup> .

REGD  
12.15

DWN. *S. Murugan* 12.13  
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MATERIAL SPEC.

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SH. No. SH. 32E OF 3