

[illegible]

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm.)

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.	REV.	DATE	ALTERED	REV.	DATE	ALD PANKAJ	ADDITIONAL INFORMATION	
			CHECKED	01	22.06.13	CHD AKM	W.O. 41271A404-61	
			APPROVED			APPD BSR	STATUS OF DRAWING	
				DIMENSION 22 WAS 7mm.			DISTRIBUTION OF PRINTS	
						AME - 1      TEX (IMM) - 1 IMM - 3      CIM - 1		

**NOTE :-**  
ALL SHARP CORNERS TO BE ROUNDED OFF.

REF. DRG. NO.	BOT-OUT	001	SUPPORT BRACKET 20 x 45 x 154	AA22414	0.250
REMARKS	ITEM NO.	DESCRIPTION	MATL. CODE	A/C	UNIT WT.
			MATL. SPECN.		QTY.

SIGN & DATE	BHARAT HEAVY ELECTRICALS LTD. BHOPAL	DRN	P.K.DUBEY	SIGN.	-sd-	DATE	21.02.13	NO. OF ITEM
		CHD	AKM		-sd-	21.02.13		
		APPD	BSR/BA		-sd-	21.02.13		

DEPT. AME	UNTOL DIMS GR.	SCALE	WEIGHT(KG.)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEM
CODE 404		NTS	0.20	24026042313	11	

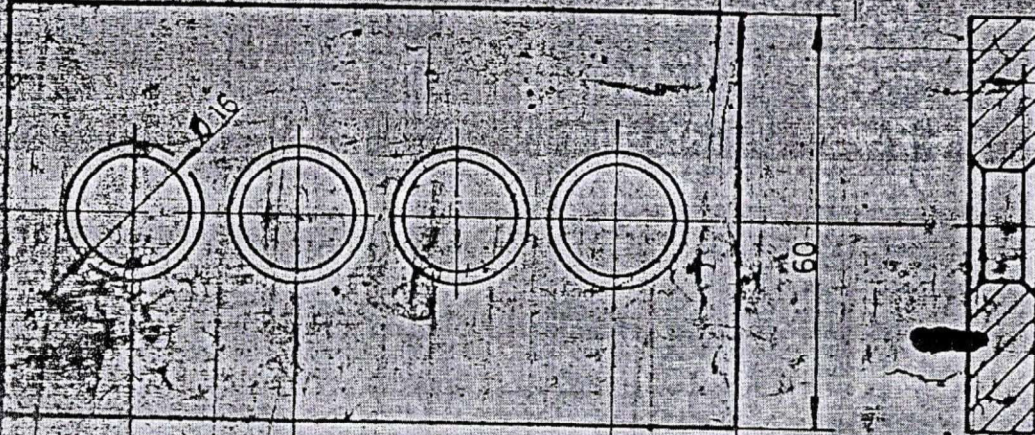
TITLE	DRAWING NO.	REV
SUPPORT BRACKET 1LA7714-4	4 40261 47901	01
	SHEET NO. 1	NO. OF SHEETS 1





44





01		BRACING PLATE		900302715		0.19	
		10TKX60X105		AA22414			
65	75	25	27	29	58	59	34
REMARKS		ITEM NO.		DESCRIPTION		MTRL CODE	
						56 58 UNIT WT. 65	
						A 57	
						C UNIT 66 QTY. 71	
CARD TYPE 3		28		28		CARD TYPE 1	
						CARD TYPE 2	
Bharat Heavy Electricals Ltd		Bhopal		NAME		SIGN	
				B.		23.4.85	
				S.		26.4.85	
						26/4	
NAME		GRADE OR INTOL.		SCALE		WEIGHT (	
LGL		DRL C/MF		N.TS		0.19	
						ASSY. DRG.	
						ITEM NO. 75 77	

# BRASS PLATE

44026146102

03




THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

DEPT. AME		CODE 404		TITLE	
GRADE OF UNTOL		SCALE		NTS	
DIM. C/M/F		WEIGHT (kg)		3.5	
REF. TO ASSY. DRG.		ITEM NO.		NO. OF	
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	<div><div><b>BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL</b></div><div><b>QUALITY PLAN FOR – EPOXY LAMINATED GLASS FABRIC BASE SHEET TO SPEC. AA 22414</b></div><div><b>QUALITY PLAN NO. QA/MT/BOI/063 REV 00</b></div><div><b>DATE:07/09/2020</b></div></div>
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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 in 2 years)

SL NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANT AM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
1.0		Physical Properties Specific Gravity, Water Absorption, Marten's Heat Distortion Temperature	T	Sample	AA22414	AA22414	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 Machine ability, Cross Breaking Strength, Tensile Strength, Compression Strength (Proof), Shear strength and Splitting Load, Edge wise (For Sheets of Thickness 10 mm and above)	T	Sample	AA22414	AA22414	TC	BHEL/TPIA	# RT

	<div><div><b>BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL</b></div><div><b>QUALITY PLAN FOR – EPOXY LAMINATED GLASS FABRIC BASE SHEET TO SPEC. AA 22414</b></div><div><b>QUALITY PLAN NO. QA/MT/BOI/063 REV 00</b></div><div><b>DATE:07/09/2020</b></div></div>
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4.0		<b>Electrical Properties</b> Insulation Resistance Electric Strength (Proof) In Oil at 90°C,- Flatwise up to 5 mm thickness & Edgewise above 5 mm thickness:	T	Sample	AA22414	AA22414	TC	BHEL/TPIA	RT
5.0		<b>Comparative Track Index (CTI)</b>	T	Sample	AA22414	AA22414	TC	BHEL/TPIA	TT
6.0	<b>PACKING AND MARKING:</b>	<b>Marking</b> BHEL order No. Manufacturer's / Supplier's Name Batch/Lot No. Thickness, Width and Length. The items shall be suitably packed in wooden case lined with water proof paper from inside.	V	100%	AA22414/PO	AA22414/PO	----	----	
<b>PREPARED BY:</b>  A.K. TELGOTE Asstt. Engineer (QA) / QA Manager (QA) BHEL, BHOPAL					<b>APPROVED BY:</b>  J.A. TOPPO Asstt. Engineer / Asst. General Manager QA, BHEL, BHOPAL				





BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL


QUALITY PLAN FOR – EPOXY LAMINATED GLASS FABRIC BASE SHEET TO SPEC. AA 22414


QUALITY PLAN NO. QA/MT/BOI/063 REV 00

DATE:07/09/2020

SINGLE SAMPLING PLAN FOR NORMAL INSPECTION ( AS PER IS -2500)

Lot or batch size ( In nos. )	Inspection Level	Sample size
2 to 8	I	2
9 to 15	I	2
16 to 25	I	3
26 to 50	I	5
51 to 90	I	5
91 to 150	I	8
150 to 280	I	13
281-to 500	I	20
501 to 1200	I	32
1201 to 3200	I	50
3201 to 1000	I	80
1001 to 35000	I	125
35001 to 150000	I	200
150001 to 500000	I	315

PREPARED BY:  
  
J. N. TELGOTE  
QA/QC Manager (Q.A.)  
HEP-HEAVY ELECTRICALS PLANT (HEP) on 15/06/2026 11:05 am

APPROVED BY  
  
V. S. TOPPO / F.A. TOPPO  
QA/QC Manager / Add. General Manager  
HEP-HEAVY ELECTRICALS PLANT (HEP) on 15/06/2026 11:05 am



# CORPORATE PURCHASING SPECIFICATION

AA22414

Rev No.04

PAGE 1 of 4

## EPOXY GLASS MAT LAMINATED SHEETS

### 1.0 GENERAL:

This specification governs the quality of epoxy based, press moulded, chopped strand glass mat sheets. The material shall have good electrical properties, low water absorption, high mechanical strength and temperature index of at least 155.

### 2.0 APPLICATION:

Used for nuts, bolts, slot wedges, insulation brackets, pole flanges, packing blocks and other components of electrical machines.

### 3.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply, with the requirements of the following National Standard and also meet the requirements of this specification.

IS:10192 – 1982 : Synthetic Resin Bonded Glass Fibre Sheets For Electrical Purposes.  
Grade: EP 2

### 4.0 DIMENSIONS AND TOLERANCES:

#### 4.1 Dimensions:

##### 4.1.1 Sizes:

Thickness x Width X Length of the sheet shall be as stated on the order.

##### 4.1.2 Preferred Thicknesses:

3, 4, 5, 6, 8, 10, 12, 20, 25, 30, 40, 50, 60, 70 mm

Any other thickness may also be ordered but not less than 3 mm

#### 4.2 Tolerances:

##### 4.2.1 On Thicknesses:

Nominal Thickness, mm		Tolerance, ± mm
Above	Up to and incl.	
–	6	0.6
6	10	0.8
10	20	1.0
20	30	1.2
30	40	1.5
40	50	1.8
50	–	2.1

#### Revisions:

As per Clause No.40.4 of MOM of MRC – E&IM

#### APPROVED:

INTERPLANT MATERIAL RATIONALISATION  
COMMITTEE – MRC(E&IM)

Rev No.04

Amd No.

Reaffirmed

Prepared

Issued

Dt. of 1<sup>st</sup> Issue

Dt:27-11-2014

Dt:


Year:

30 HEP, Bhopal

Corp.R&amp;D

September, 1979



AA22414	<b>CORPORATE PURCHASING SPECIFICATION</b>	
Rev No.04		
PAGE 2 of 4		

**4.2.2 On Width and Length:**

Width/Length, mm	Tolerance, ± mm
Below 1000	35
1000 and above	50

**4.2.3 On Flatness:**

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) 0.5 mm under a 300 mm straight edge
- b) 3 mm under a 600 mm straight edge and
- c) 6 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 wrinkles, local deformation and dents.

The sheet shall be supplied with trimmed edges.

**6.0 TEST SAMPLES:**

**6.1 Test on Sheets:**

One sheet chosen at random out of every 20 sheets of a supply shall be subjected to routine tests. In addition, one sheet of size 300 mm × 300mm × 10mm thick prepared from the same batch of consignment shall be supplied for Marten' s Heat Distortion Temperature test.

**6.2 Test on Components:**

All possible tests shall be carried out on components.

**7.0 COMPOSITION:**

**7.1 Resin:**

Bisphenol A based liquid epoxy resin having epoxy equivalent of 180 to 220, with appropriate hardener for temperature index 155

or


Novalak epoxy resin of low molecular weight having epoxy equivalent of 175 to 200, with appropriate hardener for temperature index 155.

**7.2 Diluents and Viscosity Reducers**

Not to be used.

**7.3 Glass Mat:**

Silane treated, bonded with epoxy compatible binder of 450 GSM (0.8 mm thick) or 300 GSM (0.5 mm thick). Mats shall be thoroughly dried to remove moisture. This shall be checked by burning the bond at 600°C for sufficient time.

	<h1>CORPORATE PURCHASING SPECIFICATION</h1>	AA22414 Rev No.04 PAGE 3 of 4																							
<b>8.0 PROPERTIES:</b>																									
<p>When tested as per relevant clauses of the BHEL Standard AA0851701: Methods of Tests for Laminated Sheets, the test sample shall show the following properties.</p>																									
<b>8.1 PHYSICAL PROPERTIES:</b>																									
<b>8.1.1 Specific Gravity:</b>																									
<p>1.8 ± 0.1</p>																									
<b>8.1.2 Water Absorption:</b>																									
<p>The maximum permissible water absorption after immersion in water for 24 hours at 20°C shall be as follows:</p>																									
<table border="1"> <thead> <tr> <th colspan="2">Thickness, mm</th> <th rowspan="2">Percent, Maximum</th> </tr> <tr> <th>Above</th> <th>Up to and incl.</th> </tr> </thead> <tbody> <tr> <td>-</td> <td>5</td> <td>0.30</td> </tr> <tr> <td>5</td> <td>10</td> <td>0.20</td> </tr> <tr> <td>10</td> <td>15</td> <td>0.20</td> </tr> <tr> <td>15</td> <td>20</td> <td>0.15</td> </tr> <tr> <td>20</td> <td>25</td> <td>0.15</td> </tr> <tr> <td>25</td> <td>-</td> <td>0.15</td> </tr> </tbody> </table>			Thickness, mm		Percent, Maximum	Above	Up to and incl.	-	5	0.30	5	10	0.20	10	15	0.20	15	20	0.15	20	25	0.15	25	-	0.15
Thickness, mm		Percent, Maximum																							
Above	Up to and incl.																								
-	5	0.30																							
5	10	0.20																							
10	15	0.20																							
15	20	0.15																							
20	25	0.15																							
25	-	0.15																							
<p><b>Note:</b> Thickness above 25 mm shall be machined to 25 mm keeping one side intact.</p>																									
<b>8.1.3 Marten's Heat Distortion Temperature:</b>																									
<p>160°C minimum</p>																									
<b>8.2 MECHANICAL PROPERTIES:</b>																									
<b>8.2.1 Machine ability:</b>																									
<p>The material shall be capable of being sawn, milled, drilled tapped with a M 3.5 tap and being shaped in a shaping machine without showing any signs of splitting, cracking or chipping.</p>																									
<b>8.2.2 Tensile Strength:</b>																									
<p>230 N/mm<sup>2</sup> minimum</p>																									
<b>8.2.3 Cross Breaking Strength:</b>																									
<p>320 N/mm<sup>2</sup> minimum</p>																									
<b>8.2.4 Shear Strength:</b>																									
<p>100 N/mm<sup>2</sup> minimum</p>																									
<b>8.2.5 Compression Strength (Proof):</b>																									
<p>360 N/mm<sup>2</sup></p>																									
<b>8.2.6 Splitting Load, Edge wise:</b>																									
<p>(For Sheets of Thickness 10 mm and above)</p>																									
<p>2.25 kN minimum</p>																									
<b>8.3 ELECTRICAL PROPERTIES:</b>																									
<b>8.3.1 Insulation Resistance:</b>																									
<p>(After immersion in water at 20°C for 24 hours)</p>																									
<p>2500 Megohms minimum</p>																									



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8.3.2 Electric Strength (Proof) In Oil at 90°C

8.3.2.1 Flatwise up to 5 mm thickness:

10 kV/mm

8.3.2.2 Edgewise above 5 mm thickness:

30 kV

9.0 TYPE TEST:

9.1 Comparative Track Index (CTI):

200 minimum

10.0 TEST CERTIFICATES:

Unless otherwise stated, three copies of test certificates shall be supplied along with each consignment giving the following information:

AA22414 (Rev No.04): EPOXY GLASS MAT LAMINATED SHEETS  
BHEL Order No.  
Manufacturer's/Supplier's Name.  
Batch/Lot No.  
Date of Manufacture.  
Test Results of clause 4, 7, 8 and 9

11.0 PACKING AND MARKING:

Identification slips shall be pasted suitably on all the four corners of each board giving the size of the board and manufacturer's code number/grade.

The boards shall be packed in wooden cases lined with water proof paper from inside. Each sheet shall be separated from other sheet by a thick paper or card board.

Each container shall be marked with the following information

AA22414 : EPOXY GLASS MAT LAMINATED SHEETS  
BHEL Order No.  
Manufacturer's/Supplier's Name.  
Batch/Lot No.  
Thickness, Width and Length.  
Number of Sheets.  
Date of Manufacture.  
Quantity supplied.

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