

<b>PSGSG101</b>	<b>SPECIFICATIONS FOR SPHERICAL ADAPTERS</b>	Drg.No.	35027500425
		Date	10.07.2020
		Product	GIS-420
<b>1.0</b>	<b>APPLICATION:</b>  Electrical Grade (HE-30) Aluminum Spherical adapter Assemblies as per the enclosed drawing No. 35027500425 are required for GIS application.		
<b>2.0</b>	<b>SPECIFICATION:</b>		
<b>2.1</b>	The spherical adapters shall be machined electrical grade aluminum (HE-30) block and to be supplied to the dimensions as per enclosed drawings.		
<b>2.2</b>	<b>Material:</b>  Electrical conductivity of HE-30 material shall be greater than 45 %. (IACS)		
<b>2.3</b>	Material source certificate and grade certificate shall be provided along with the delivery of the components.		
<b>2.4</b>	The spherical adapters shall be CNC machined to the dimensions.		
<b>2.5</b>	Any sharp corners shall be removed as per the drawing. Wherever not specified in the drawing, a chamfer of 0.5x45° shall be provided at the sharp corners and edges.		
<b>2.6</b>	Material must be free from blow holes and the same shall be ensured by the supplier.		
<b>3.0</b>	<b>Silver Plating:</b> The components shall be <b>CNC</b> finished to final dimensions prior to silver plating. Silver plating to a thickness of 10-12 microns shall be done on the marking area. An initial flash of 2 micron nickel is advised.		
<b>Page 1/2</b>	<b>PSGSG101.doc</b>		<b>Signature</b>

<b>PSGSG101</b>	<b>SPECIFICATIONS FOR SPHERICAL ADAPTERS</b>	Drg.No.	25027500240
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<b>4.0</b>	<b>Test Report:</b> The dimensional checks shall be carried out in presence of BHEL inspector. Deviations in dimensions are not acceptable.		
<b>5.0</b>	<b>Packing:</b>  The component shall be packed in high density cardboard boxes, with a primary wrapped in polyethylene and packed individually in dust free boxes after degreasing. The component shall be guaranteed against all manufacturing defects.		
<b>6.0</b>	<b>General:</b> In case of doubts in drawings or specifications the supplier shall contact BHEL for clarifications.		
<b>Page 2/2</b>	<b>PSGSG101.doc</b>	<b>Signature</b>	