



PRODUCT STANDARD

SWITCHGEAR ENGINEERING DIVISION

SG14610 Rev 04

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ELECTROPLATING INSTRUCTIONS FOR BUSBARS & CONNECTIONS.

1. **GENERAL: -**

This standard facilitates the selection of Tin / Silver Plating procedure for all connections / bus bar of metal clad switchgear.

2. **APPLICATION: -**

Aluminium/Copper busbars, Connections, Droppers, Link plates, Earth connection and other similar items of metal clad switchgear type VM12, BVM12, VMN12, VN12(Kiosk), VM36.

3. **SELECTION CRITERIA: -**

All, busbars / connections mentioned above shall be electro-tin plated unless otherwise specifically called as silver plating in Drawing / PO / MID / Engg specification of Work Order.

4. **PLATING THICKNESS: -**

Unless otherwise stated in Drawing / PO / MID / Engg specification, Plating thickness shall be minimum 5 microns.

5. **QUALITY CHECKS AND ACCEPTANCE CRITERIA OF MACHINED COPPER CONTACTS: -**

All the clauses called in SG 16054 shall be complied for machined copper contacts.

4. **ELECTRO PLATING PROCESS SPECIFICATIONS: -**

Table-1

CONN. MATERIAL TO BE PLATED	PLATING	PROCESS SPECIFICATION
Aluminium	Tin	SG 15605
	Silver	SG 15600
Copper	Tin	AA 0673602
	Silver	AA 0673613

5. **ACCEPTANCE CRITERIA: -**

- A. Plating thickness as per drawing/specification.
- B. Adhesion test.
- C. Anti-Tarnishing Test.
- D. Packing and marking as per SG16054

Above test shall be performed as per relevant process specification specified in Table-1.

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