



PRODUCT STANDARD
BUSHING & CYLINDER ENGINEERING
INSTRUCTIONS

NO. : BC 00118

BCE-2009

Page 1 of 4

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KRAFT INSULATING PAPER- MEDIUM AIR PERMEABILITY

1.0 GENERAL:

This specification governs the quality requirements of kraft Insulating Paper for electrical purpose made entirely from soft-wood pulp manufactured by the sulphate process. The paper shall be manufactured in natural colour (undyed) and shall be free from metallic particles. The material in insulating oil shall have a temperature index of at least 105°C.

2.0 APPLICATION:

Used in building condenser core for oil impregnated paper bushings.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

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

IS: 9335 (Part 3/Sec.5)-1985 | Cellulosic paper for electrical purposes. Part3: Spec.
 Gr.: 5B2-2M3 | for individual materials. Sec.5: Special papers.

IEC 60554-3-5- 1984 | Cellulosic paper for electrical purposes. Part3: Spec.
 Gr.: 5B2-2M3 | for individual materials. Sec.5: Special papers.

4.0 DIMENSIONS AND TOLERANCES:**4.1 Sizes:**

Thickness and width shall be as stated on BHEL order.

4.2 Thickness And Tolerances:

Normal Thickness And Tolerances shall be in accordance with IEC 60554-3-5, as shown below:

<u>Nominal Thickness, micron</u>		Tolerance, ±%
Over	Upto & Incl.	
-	75	10
75	105	7
105	125	6
125	-	4

REV.00
 Date
 02.11.13

DISTRIBUTION
 BCM
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Date

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Page 2 of 4

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4.3 Width:

915, 1525, 1780, 2030, 2285, 2540, 2795, 3050, 4050 mm with a tolerance of ± 5 mm. However any other width can also be ordered.

5.0 FINISH:

The paper shall have smooth but unglazed surface.

6.0 TEST METHODS:

Unless other wise specified, the tests shall be conducted in accordance with the relevant methods of IEC 60554-2/IS:9335 Part 2 / ISO 1924-2.

7.0 SAMPLE FOR TEST:

20 sheets of size 300 X 300 mm of ordered thickness suitably packed shall be supplied for testing and approval purposes. Machine direction shall be marked clearly on all the sheets.

8.0 PHYSICAL PROPERTIES:**8.1 Substance (grammage):**

Normal Thickness (μm)	Substance (g/m^2)	Tolerance ($\pm\%$)
75	60	5
100	80	5
125	100	5

Note: Substance for intermediate thickness shall be 0.8 times of the thickness, in micron.

8.2 Apparent Density : 0.80 $\pm$ 0.05 g/cm³

8.3 Moisture Content : 8%, max.

8.4 Water absorption : 10 mm, min.

8.5 Air permeability : 0.2 to 0.5 $\mu\text{m/Pa.S}$

9.0 MECHANICAL PROPERTIES:**9.1 Tensile Strength (Expressed as tensile index):**

Machine Direction (MD) : 80 Nm/g, min.

Cross Direction (XD) : 35 Nm/g, min.



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Page 3 of 4

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9.2 Heat Stability (Type Test):

Paper shall be heated in air at $120^{\circ}\text{C} \pm 2^{\circ}\text{C}$ for 168 hours and following requirements shall be met.

- Increase in Conductivity of aqueous extract shall not be more than 23 ms/m.

9.3 Tear Index:

The material when tested shall show a minimum Internal Tearing Resistance as shown below, expressed as Tear Index

<u>Weight, g/m²</u>		<u>Machine Direction</u>	<u>Cross Direction,</u>
Above	Upto & Incl.	m N m ² / g, min	m N m ² /g, min
30	80	5.0	6.0
80	120	6.0	7.0
120	-	8.0	9.0

10.0 ELECTRICAL PROPERTIES:**10.1 Electric strength in air:**

<u>Thickness, micron</u>		<u>BDV, (kV/mm), min.</u>
Above	Upto & Incl.	
-	100	7.5
100	125	7.0
125	-	6.5

Electric Strength shall be determined at room temperature after drying the paper for 1 to 2 hours at $105^{\circ}\text{C} \pm 2^{\circ}\text{C}$ and then tested within 2 minutes of removal from the oven.

11.0 CHEMICAL PROPERTIES:

11.1	Ash Content	:	1%, max.
11.2	Conductivity of 5% aqueous extract	:	10 mS/m, max.
11.3	pH of 5% aqueous extract	:	6 to 8
12.0	Degree of Polymerisation (Average viscometric)	:	1000 to 2000



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Page 4 of 4

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12.1 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied alongwith each consignment.

In addition, the supplier shall ensure to enclose one copy of the test certificate along with their despatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information:

BC 00118 (Rev.No 00): Kraft Insulating Paper - Medium Air Permeability.

BHEL order No.

Manufacturer's/Supplier's Name.

Batch/Lot No.

Thickness & Width.

Net weight/No. of rolls.

Test values obtained and certificate for Physical, Mechanical, Electrical and Chemical

Properties called for in this specification.

13.0 PACKING AND MARKING:

The paper shall be supplied in rolls tightly wound on suitable single piece hollow formers of strong straw board with 90 mm inside diameter. The rolls shall be adequately wrapped with suitable sea-worthy packing for transit through tropics so as to prevent any moisture ingress or damage to the roll. The ends of the rolls shall be protected during packing to avoid any radial or telescopic deformation. The paper shall normally be supplied in one continuous length and in no case the number of lengths shall exceed two. In such a case the number of lengths shall be indicated by a tag projecting from one end of the roll. For 190 nm thick paper, the outside dia of the roll shall be between 500-610 mm and for other thickness the outside dia and the weight for the roll shall be as stated on the order.

Each roll shall be clearly and indelibly marked with the following information:

BC 00118: Kraft insulating Paper-Medium At- permeability.

BHEL order No.

Manufacturer's / Supplier's Name

Batch/Lot No.

Thickness, Width and outside diameter.

Net weight.

14.0 REFERRED STANDARDS (Latest Publications Including Amendments) :

- (1) IS:9335, Part 2 & 3 (2) IEC 60554-3-5 and IEC 60554-2 (3) AA 21112
(4) AA 21117 (5) AA 21110 (6) ISO 1924-2.



BHARAT HEAVY ELECTRICALS LIMITED BHOPAL
VENDOR QUALIFICATION REQUIREMENT FOR
KRAFT INSULATING PAPER

Date: 29.01.2026

DOC. NO.: VQR/KRAFT PAPER/BUSHING REV.00

TECHNICAL:

Sl. No.	Description	Vendor's remarks (Y/N)
1	The vendor should be either manufacturer of KRAFT INSULATING PAPER or their authorized representative. Authorized representative to submit authorization letter from the manufacturer as a documentary proof.	
2	The manufacturer should have supplied at least 10% of tender quantity of KRAFT INSULATING PAPER having thickness of 0.125mm (or less), width of minimum 1000mm and technical parameters as per IEC 60554-3-5 / BHEL technical specification no. BC00118 for condenser bushing application of 52KV or above rating. Supplier to submit the un-priced copy of purchase order with Invoice / dispatch documents. Supplier to also submit performance certificate from bushing manufacturer to whom they are supplying the paper.	

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