



TSD 6206

PLANT PURCHASING SPECIFICATION BHOPAL

BP 59698

REV NO.02

PAGE 1 OF 3

HEAT SHRINKABLE SILICONE RUBBER TUBE

SUPERSEDES

BP 59698 Rev.01

1. GENERAL:

This specification governs the quality of Heat Shrinkable Silicone Rubber Tube, which can be shrunk uniformly by application of heat at temperature of 120 deg. C and above.

2. APPLICATION:

Used for covering exposed portion of flexible lead wires and packing of connections in traction machines.

3. COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian Standard covering this material.

4. DIMENSIONS AND TOLERANCES:

Sizes shall be stated on the order/drawing. However the preferred dimensions and tolerances shall be as follow:

O.D. of Conductor For Covering (mm)	Before Heat Shrinking (As Recd-Nom)	After Heat Shrinking Without Conductor	
	I.D. (mm)	I.D. (mm)	Thickness (mm)
13 - 19	22	11	2.0 + 0.3 - 0.4
17 - 24	28	14	1.3 + 0.3 - 0.4
20 - 30	34	17	2.0 + 0.3 - 0.4

5. FREEDOM FROM DEFECTS:

The tube shall be smooth and free from porosity, breaks and other visible defects.

Revision :

Reviewed & Brought upto date

Issued by : *Sharda*

STANDARDS AND MATERIALS GROUP
TECHNICAL SERVICES DEPARTMENT

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PLANT PURCHASING SPECIFICATION
BHOPAL

BP 59698

REV NO.02

PAGE 2 OF 3

6. IDENTIFICATION:

The material, when identified by infra-red spectrometer or by any other convenient method shall be silicone rubber.

7. TEST METHOD:

As stated against each clause. 5 metre long sample of the tube shall be supplied for testing & approval.

8. PROPERTIES:

8.1 Specific Gravity:

1.23, Nom, when tested by any conventional method.

8.2 Tensile strength (IS:3400, Part 1) (Dumb-bell Method Type 1)

5 N/mm², Min.

8.3 Elongation (IS:3400, Part 1) (Dumb-bell Method Type 1)

300%, Min.

8.4 Breakdown Voltage IS:2584

25 kv/mm, Min.

8.5 Resistivity IS:3396:

2×10^5 Ohm - Cm, Min.

9. KEEPING PROPERTIES:

When stored in a covered area under normal storage condition, the material shall not show any sign of deterioration like hair line cracks, swelling, porosity, flow lines, etc. for a period of 36 months from the date of manufacture which shall be subsequent to the date of placing the order.

The expiry date shall be marked clearly on every metre of the tube.



TSD 6206

PLANT PURCHASING SPECIFICATION
BHOPAL

BP 59698

REV NO.02

PAGE 3 OF 3

10. TEST CERTIFICATE:

Unless otherwise stated, three copies of test certificate shall be supplied giving the following information:

In addition, the supplier shall ensure to enclose one copy of Test Certificate along with their despatch document to facilitate quick clearance of the material.

BP 59698 : Heat Shrinkable Silicone Rubber Tube.

Rev.02

BHEL Order No.

Supplier's Name & Trade Mark, if any.

Date of manufacture and expiry.

Test results of clauses 6 and 8 as well as spring hardness & tear strength as detailed below.

Spring Hardness: 70 + 5 Hs (By any international method)

- 7

Tear Strength : 2.5 Kg/Cm, Min. (BS 903 Part A3).

11. PACKING AND MARKING:

Material shall be suitably packed in continuous rolls of 100 metres to prevent damage from contamination and handling during transit.

Each package shall be legibly marked with the following information.

BP 59698 : Heat Shrinkable Silicone Rubber Tube

BHEL Order No.

Manufacturer's/Supplier's Name & Trade Mark, if any.

Date of manufacture and expiry.

Batch No.

Size

Quantity.