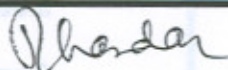


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	<u>HOT COPPER PRESSINGS</u>		SUPERSEDES BP 19897 Rev.03
	1. GENERAL: This specification governs the quality of high conductivity Hot Copper Pressings. 2. APPLICATION: For electrical purposes. 3. CONDITION OF DELIVERY: The pressings shall be supplied in the as pressed condition. 4. COMPLIANCE WITH STANDARDS: The material shall comply with the requirements of the following National Standard and also meet the requirements of this specification. IS:6912 – 2005 } Copper and Copper Alloy Gr: ETP/FRHC } Forging Stock and Forging. 5. DIMENSIONS AND TOLERANCES: As per drawing accompanying our order, the tolerance on the pressing allowed is ± 0.75 mm, unless otherwise stated. 6. MANUFACTURE: By any convenient process of forging / pressing. 7. FREEDOM FROM DEFECTS: The pressings must be smooth, of uniform quality & condition & shall be free from laps, cracks or other injurious defects. 8. CHEMICAL COMPOSITION: The pressings shall be manufactured from copper conforming to our Corporate Purchasing Specification AA 12024 9. TEST SAMPLES:		
Revision : Reviewed and upto dated.		ISSUED by :  STANDARDS AND MATERIALS GROUP TECHNICAL SERVICES DEPARTMENT	
Rev. No 04		Date: 16.10.07	
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- 9.1 One sample per heat shall be taken for chemical analysis.
- 9.2 In any consignment, all the pressings produced from the same batch of raw material under similar conditions shall be grouped together to constitute a lot. One sample per heat / lot shall be taken for mechanical tests. The test pieces shall be taken directly from pressings and shall receive no further heat treatment.
- 9.3 Electrical conductivity measurement shall be performed on each sample, per lot, as above.
10. **HARDNESS-VICKERS:**
The material when tested in accordance with IS:2866 shall show a Vicker's Hardness of 45-60 HV.
11. **ELECTRICAL CONDUCTIVITY:**
When tested in accordance with ASTM E 1004, Eddy current probe test method, the electrical conductivity shall be 95% minimum of I.A.C.S standard for annealed copper (0.01724 ohm mm² / m at 20°C is the resistivity corresponding to 100% conductivity).
Refer IS: 613 Appendix - B for temperature correction factor.
12. **TEST CERTIFICATES:**
Three copies of test certificates shall be supplied, unless otherwise stated on the order.
The supplier shall ensure, to enclose one copy of the above test certificate along with their despatch documents to facilitate quick clearance of material.
The test certificate shall bear the following information.
BP 19897 (Rev.04) Hot Copper Pressing.
BHEL Order No.
Supplier's Name.
Drawing No.
Method of Manufacture.
Consignment/Identification No.



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Results of tests :

Results of chemical analysis, mechanical test & electrical conductivity, dimensional tolerances and all other tests called for in this specification/order.

13. PACKING AND MARKING

The pressings shall be suitably packed to prevent corrosion and damage during transit. Machined surfaces, if any shall be properly protected with anti-corrosive compounds.

Each package shall be marked with the following information.

BP 19897 : Hot Copper Pressing.

BHEL Order No.

Identification No.

Weight.

Supplier's reference / Name.