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| <b>PSGSG101</b>     | <b>SPECIFICATIONS FOR<br/>SPHERICAL ADAPTERS</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  | Drg.No.          | 25027500240 |
|                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  | Date             | 10.07.2020  |
|                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |  | Product          | GIS-420     |
| <b>1.0</b>          | <b>APPLICATION:</b><br><br>Electrical Grade (HE-30) Aluminum Spherical adapter Assemblies as per the enclosed drawing No. 25027500240 are required for GIS application.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |  |                  |             |
| <b>2.0</b>          | <b>SPECIFICATION:</b><br><br><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.<br><br><b>2.2</b> <b>Outer diameter: 300 mm, Inner diameter: 200 mm</b><br><br><b>2.3</b> <b>Material:</b><br><br>Electrical conductivity of HE-30 material shall be greater than 45 %. (IACS)<br><br><b>2.4</b> Material source certificate and grade certificate shall be provided along with the delivery of the components.<br><br><b>2.5</b> The spherical adapters shall be CNC machined to the dimensions.<br><br><b>2.6</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.<br><br><b>2.7</b> Material must be free from blow holes and the same shall be ensured by the supplier.<br><br><b>3.0</b> <b>Silver Plating:</b><br>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. |  |                  |             |
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| <b>PSGSG101</b>     | <b>SPECIFICATIONS FOR<br/>SPHERICAL ADAPTERS</b>                                                                                                                                                                                                               | Drg.No.          | 25027500240 |
|                     |                                                                                                                                                                                                                                                                | Date             | 10.07.2020  |
|                     |                                                                                                                                                                                                                                                                | Product          | GIS         |
| <b>4.0</b>          | <b>Test Report:</b><br>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><br><br>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><br>In case of doubts in drawings or specifications the supplier shall contact BHEL for clarifications.                                                                                                                                         |                  |             |
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