



PRODUCT STANDARD
SWITCHGEAR ENGINEERING DIVISION

SG12649 REV.00

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SPECIFICATION FOR JAW CONTACT ASSEMBLY TO DRAWING NO.
15212001531-V03 REV08 FOR PRESS TENDER

1. GENERAL:

This specification governs, the manufacturing, testing, Inspection, packing and supply of jaw contact assembly to drawing no. 15212001531-V03. This assembly shall be manufactured as per BHEL drawing and specification attached as annexure-1.

2. APPLICATION:

To be used in Switchgear as current transfer part.

3. DIMENSIONS & TOLERANCES

All dimensions and tolerances shall be as per BHEL drawing.

4. ELECTRICAL CONDUCTIVITY:

Electrical conductivity shall be 97% minimum IACS (Refer appendix B of IS613).

5. FREEDOM FROM DEFECTS:

The material shall be clean and free from harmful defects, such as burrs, cuts, scratch mark, broken faces, cracks etc.

6. INSPECTION AT SUPPLIER'S WORK:


The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed tests at recognized lab. Supplier shall have the equipment for contact pressure measurement. Supplier shall set contact pressure for each pair of finger assembly as per drawing.


7. TEST CERTIFICATES:

Three copies of certificates shall be supplied along with consignment giving the following information.

- BHEL Order No.
- Manufacturer's/Supplier's Name.
- Batch/Lot No.
- Sizes and Quantity Supplied.
- Detailed dimension report.
- Mechanical and electrical tests reports as per corporate standard specification.
- Contact pressure setting 30-35 kgf for each pair of finger assembly.
- Silver plating thickness and ant tarnishing test.

REV.		PRINTS TO:-		APPROVED –		
ALTD.		MM (SCR) -1 SWM (Plg) -1		Neelam Bhogal		
APPD.				PREPARED	ISSUED	DATE
DATE.				H R Patel	AP Singh	23.12.10

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<div>COPYRIGHT AND CONFIDENTIAL</div> <div>The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in any way detrimental to interest of Co.</div>		<div>8. <u>ACCEPTANCE CRIETERIA</u></div> <div><div><div>- Verification of dimensions and test reports furnished by vendor.</div><div>- Visual observation for burrs, cuts, cracks etc.</div><div>- Silver plating thickness, anti tarnishing, conductivity test on each lot at BHEL works meeting as per specification.</div><div>- Assembly completeness with all hardware’s.</div><div>- Contact pressure measurement at BHEL works.</div></div></div> <div>9. <u>QA PLAN</u></div> <div>Vendor shall confirm to follow QA Plan as per annexure-2.</div> <div>10. <u>IDENTIFICATION MARKINGS FOR TRACEABILITY</u></div> <div>Each Assembly shall have following markings on the L connector locations side edge at bending location.<div><div>- Suppliers name or logo</div><div>- Year of manufacturing and unit serial no.</div></div>The markings shall be long lasting and should not affect the electrical properties.</div> <div>11. <u>PACKING AND MARKING:</u></div> <div>BHEL Order No. Each assembly shall be packed in separate boxes wrapped in bubbled polythene. To prevent damage during transit each package shall be legibly marked or labeled with the following information.<div>Manufacturers /Suppliers Name. Batch/Lot No. Size and Quantity supplied.</div></div> <div>12. <u>REJECTION AND REPLACEMENT:</u></div> <div>If the material does not comply with the requirements of this product standard during receipt inspection at BHEL or if any defect is found during further processing of the material, BHEL reserves the right to reject the whole consignment notwithstanding any previous certification of satisfactory testing and/or inspection and the supplier shall replace the material free of cost.</div>		

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<div>COPYRIGHT AND CONFIDENTIAL</div> <div>The information on this document is the property of Bharat Heavy Electricals Limited It must not be used directly or indirectly in any way detrimental to interest of Co.</div>		<div>13. <u>QUALIFYING REQUIREMENT</u>:-</div> <div><div>1. Only those vendors (or their authorized representatives), who have supplied similar type of components in the past five years (on the date of opening of tender) shall be considered. The supply reference list with PO copies with qty shall be furnished for evaluating the same.</div><div>2. Vendor should be regular supplier for switchgear manufacturer. The supply reference list to be furnished by vendor.</div><div>3. Supplier’s financial turnover shall be minimum Rs. 6 Crore. Necessary document for this shall be submitted by vendor.</div><div>4. Vendor shall submit 2 no. similar samples during technical evaluation of the offer for evaluating technical competence of the vendor.</div><div>5. Supplier shall have necessary manufacturing and testing facilities such as bending, cutting, pressing machines etc. Facility write-up shall be submitted by vendor alongwith the technical offer.</div><div>6. BHEL reserves the right to verify information provided by vendor. In case the information provided by vendor is found to be false /incorrect, the offer shall be rejected.</div></div>				



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Annexure-1

SL NO.	Description	Specification	Part Number	Rev. No.	Qty
1	CONNECTOR	AA12023	35211001672-001	09	1
2	ISOLATING CONTACT	AA12003	35211001604-001	18	6
3	SPACER	AA10112	45211001707-001	03	1
4	O- RING	AA59803	45211001703-002	04	1
5	STOPPER PLATE	AA10113	45211001708-001	04	2
6	DISC SPRING	BS1449 PART3.8 CS70	D9286056-002	08	18
7	SPRING	AA10301	45216001501-001	05	12
8	DISC SPRING	BS1449 PART3.8 CS70	D9286056-003	08	4
9	WASHER	AA10113	45096301521-001	03	4
10	INSULATING SCREW	BP22962	45095001518-002	05	2
11	WASHER MCD 10.5-ST	AA7161001064			30
12	BOLT HEX AM10x90-8.8	AA7111122135			6
13	NUT HEX PVLNG TORQ A	AA7159101057			6
14	BOLT HEX AM10X80-8.8	AA7111122127			3
15	WASHER MCD 6.4-ST	AA7161001048			2
16	WASHER SPG LOCK SCB-6-ST	AA7164002045			2
17	SCRU HEX A M12X60-8.8	AA7121123428			4
18	NUT HEX A M10-8	AA7151115032			6
19	SCRU HEX SLT A M6X12-8.8	BP7121125986			4
20	NUT HEX A M8-8	AA7151115024			1

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