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FORM NO. 2038		उत्पाद मानक परिणामित्र शाप/अभि. निर्देश	
PRODUCT STANDARD TRANSFORMER		TR 10017P	
SHOP/ENGG INSTRUCTIONS		1 पृष्ठों में PAGE 1 OF 1	
TITLE : PLATING OF FERROUS & NONFERROUS PARTS & FASTENERS			
SL. NO 1.	PART/FASTENER BUS BAR, ROD, PLATE, LUG, JUMPER, PALM & ANY OTHER SECTION FOR CURRENT CARRYING	MATERIAL COPPER OR COPPER ALLOY CONTAINING MORE THAN 50% OF COPPER e.g. BRASS	MEDIUM IN WHICH USED AIR OR OIL
		TYPE OF COATING ELECTROPLATED COATING OF TIN (ET) GRADE Sn C OF IS:1359	COATING THICKNESS LOCAL THICKNESS =15µm (MIN)
		REMARKS A. IF THE PART IS INSIDE TANK DURING PROCESSING CONTACT SURFACE ET. (JOINTED PORTION). ONE LAYER OF 50% OVERLAP WOUND CREPE PAPER TO AA21117 TYPE B. SEE TR10005P. B. IF THE PART IS NOT MOUNTED DURING PROCESSING CONTACT SURFACE-ET. UNJOINTED PORTION:- OIL RESISTANT AIR DRYING SYNTHETIC ENAMEL RED SHADE TO AA56132	
2.	AIR END TERMINALS OF BUSHINGS, PRIMARY TERMINAL OF 400 KV, CT ETC.	COPPER OR COPPER ALLOY	AIR
		ELECTROPLATED COATING OF SILVER	LOCAL THICKNESS=15 µm (MIN)
3.	CAP, COLLAR, BOLT, SPECIAL NUT WASHER & ANY OTHER ITEM (NORMALLY USED AROUND CURRENT CARRYING COMPONENT FORMING A CLOSED CIRCUIT FROM EDDY CURRENT CONSIDERATIONS)	Cu OR Cu ALLOY/CONTAINING MORE THAN 50% OF Cu e.g. BRASS.	AIR OR OIL
		ELECTROPLATED COATING OF TIN (ET) GRADE Sn 15 C OF IS : 1359	LOCAL THICKNESS =15µm (MIN)
4.	ALL TYPE OF HARDWARES / FASTENERS INCLUDING THOSE IN JOINTED PORTION OF CURRENT CARRYING PARTS. (STUDS, AUTOWELD STUDS, BOLT, NUT, PLAIN WASHER & SPRING WASHER ETC. SCREW	MAGNETIC STEEL (BLACK, BRIGHT, SHAFT, HIGH TENSILE, SPRING STEEL	AIR OR OIL
		ELECTROPLATED COATING OF ZINC TO GRADE Fe/Zn 12.5 WITH CHROMATE CONVERSION COATING TYPE 'D' AS PER IS:1573	LOCAL THICKNESS 12.5µm (MIN)
		REMARKS (I) BOLT/SCREW HEAD, NUT OUTER SURFACE, SCREWED ROD/STUD ENDS SHALL BE TAKEN AS 'SIGNIFICANT SURFACE' FOR MEASUREMENT OF LOCAL THICKNESS AS PER CL-4.2.1.1 OF IS:1573 FOR ZPP & CL-2.1 OF IS:1359 FOR ET. (II) FOR ZPPOF HARDWARES OF P.CL. 10/10.9 & ABOVE & SPRING WASHERS SEE NOTE:3	

NOTES: 1. ALL DRAWINGS WHERE PLATING HAS BEEN CALLED WILL GIVE REFERENCE OF THIS DRG: i.e. ZPP/ET TO DRG. i.e. ZPP/ET TO TR10017P.
 2. SILVER PLATING SHALL BE CALLED WHEN SPECIFICALLY ASKED FOR BY THE CUSTOMER.
 3. HARDWARES OF P.CL. 10/10.9 & ABOVE & SPRING WASHER WHICH ARE REQUIRED TO BE ZPP SHALL BE HEAT TREATED BEFORE & AFTER PLATING FOR STRESS RELIEF & HYDROGEN EMBRITTELEMENT RELIEF AS PER IS: 1573.

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