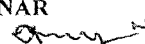


		 BHEL-EPD	ELECTROPORCELAINS DIVISION BENGALURU – 560012, INDIA Purchase Specification Group : Photovoltaic Module		SPEC. NO: PS-901-01-0001		
				REV. 03	JOB NO.-STD.		
				PAGE 01 OF 02			
COPY RIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in anyway detrimental to the interest of the company.		ALUMINIUM FRAMES & CORNER BLOCK, 3.2 mm Thick 1.0 SCOPE: Supply of Aluminum frame, Corner block with electrolytically formed anodic coatings on Aluminum & Al alloy parts which are exposed to direct action of climatic elements (viz sun, wind, rain, dust, salt, and water). 2.0 GENERAL: - Aluminum parts to be anodized are made of Al alloy (63400/6063) as per IS-733 and supplied in W P /T6 (temper) condition. - End use of component is for Solar Photovoltaic module framing. - Anodizing process as per Type-I: IS-7088 - Type of sealing as per IS-7088 (Clause 7) 3.0 DRAWING: 3-988-04-001-10 ALUMINIUM EDGE FRAME 4-988-04-001-10 MAIN EXTRUSION 4-988-04-002-10 CORNER BLOCK EXTRUSION 4.0 VISUAL REQUIREMENTS: The anodic coating shall be continuous, smooth, adherent, uniform in appearance and shall be free from powdery areas, loose films, and discontinuities such as breaks, scratches or other damage.					
		Revision (03):	Issued By	Prepared By	Checked By	Approved By	Date
		4 th Issue	SPV Eng.	RKP	NAR	CNP	18.09.17

	 BHEL-EPD	ELECTROPORCELAINS DIVISION BENGALURU – 560012, INDIA Purchase Specification Group : Photovoltaic Module		SPEC. NO: PS-901-01-0001			
				REV. 03	JOB NO.-STD.		
				PAGE 02 OF 02			
COPY RIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in anyway detrimental to the interest of the company.	5.0 DIMENSIONAL REQUIREMENTS: After anodic coating, the parts shall comply with dimensional requirements of the applicable drawings. a. Extent of surface to be anodized : All over b. Anodic Coating Thickness: 18 ± 3 microns as per IS:1868 (AC 15 grade), Table I c. Surface Texture: Natural matte finish d. Continuity: As per IS-8375 e. Insulation: As per IS-8554, when anodic parts are checked, the break down potential of the coating is to be not less than 500 V DC. f. Corrosion resistance: Each anodized and sealed member when tested as per IS-9000 (part XI) as per procedure 1(5% salt solution) shall not show more than 5 isolated spots or pits (0.8 mm dia max). Note: Supplier shall produce test certificate from reputed labs for SI. nos. 5(d), (e) and (f) which shall not be older than one year as on the date of material supply. 6.0 TEST METHODS: VISUAL AND DIMENSIONAL Parts selected in accordance with the sampling plan and tested for visual and dimensional checks shall comply with clause 7.0 COATING THICKNESS: Parts selected as per sampling plan and tested for coating thickness in accordance with IS-6012 shall comply with clause 5(b). 8.0 SAMPLING PLAN: Sampling Size: Single Sampling Plan as per IS-10673, Special Inspection Level S-4, AQL 1.0						
		Revision (03):	Issued By	Prepared By	Checked By	Approved By	Date
		4 th Issue	SPV Eng.	RKP 	NAR 	CNP 	18.09.17