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BHEL
RUDRAPUR

PRODUCT STANDARD
BUSDUCT ENGINEERING

No: BHE/PACK/SP/001 REV-01

PROCEDURE FOR SILVER/TIN PLATING AND COATING PROTECTION

INTRODUCTION:

This standard covers the procedure for Silver Plating / Tin coating protection on Aluminium / Copper material.

PROCEDURE:

After clearance from inspecting agency, surface of the plated portion to be cleaned by using cotton cloth to remove dust, loose particles etc.

PACKING:

1. Plated surface should be suitably covered with sulphur free adhesive sheet/tape/paper.
2. Sulphur free adhesive sheet/tape/paper shall be covered with cotton tape for providing cushion.
3. Cotton tape wrapped surface shall be covered with bubble sheet in double layer to avoid ingress of moisture and for providing cushion to plated surface (Fig-3A & 3B).
4. Edges of plated palms shall be covered with hard foam to avoid damage to edges during handling (Fig-4A & 4B).
5. Packed components shall be stored under covered shed.
6. Before dispatch of Bus Duct to site, proper packing of Silver / Tin plated surface shall be ensured.
7. If any damage is noticed in the packing, it shall be re-packed by the above given process.

NOTE: SL NO. 4 is applicable for silver plated busduct palms only and not for splice plates and flexible.

REMOVAL OF PACKING:

At the time of erection of Bus Duct at site, all the packing must be removed from plated surface.

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FIG-3A

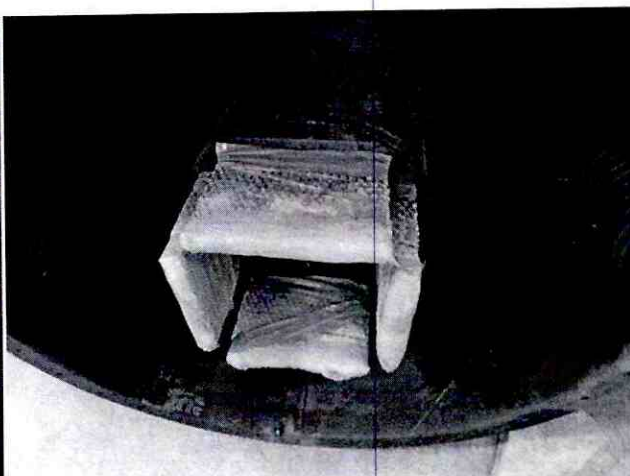


FIG-3B

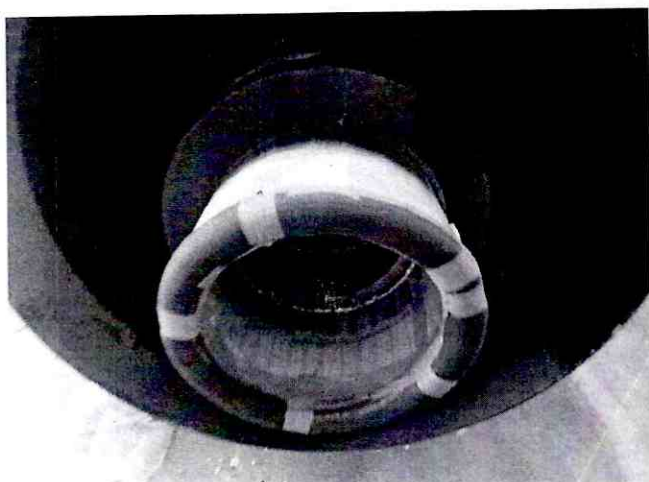


FIG-4A

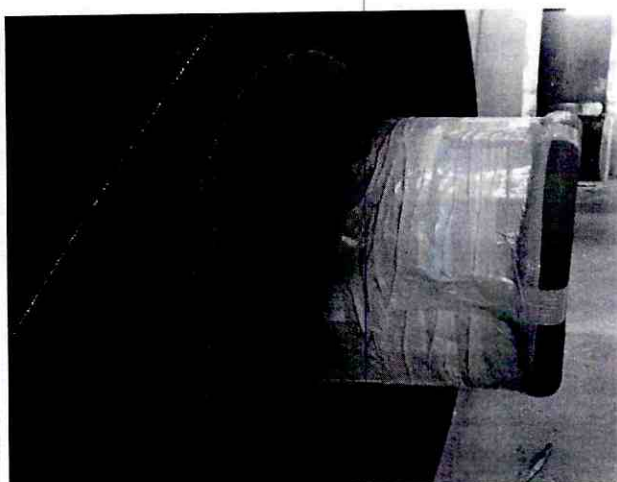


FIG-4B