



BHARAT HEAVY ELECTRICALS LIMITED
BOILER AUXILIARIES PLANT
ELECTRICAL, CONTROLS AND INSTRUMENTATION
RANIPET - 632 406.

TDA:STD:DAE:OCIS
REV. 04
SHEET 1 OF 15

SPECIFICATION
FOR
ELECTRIC DAMPER ACTUATORS
(OPEN/CLOSE TYPE)
WITH INTEGRAL STARTERS

REV NO.	DATE	DESCRIPTION	PREPARED	REVIEWED	APPROVED
00	12.01.2007	INITIAL RELEASE Prepared inline with C&I/FB/ BHEL Trichy spec no. CI:SIPA: DAE:O/C REV.00	P. Britto Corthis	PBC	J. Balachandran
01	03.05.2008	Actuator power supply healthy/faulty signal is added	P.Muthukumar	S.Rangarajan	S.Rangarajan
02	27.11.2009	i. CI.No.A7.1 (RPT) P.1 (Paint and finish) is corrected. ii.CI.Nos.5.0 and 6.0 of integral starters are corrected	-sd-	-sd-	-sd-
03	27.05.2014	CI.No.G.3.5 to G.3.17, G.4.3 to G.4.7 & M.2.6 are added.	K.Priyadharshini	S.Rangarajan	S.Rangarajan
04	19.11.2014	CI.No.M.2.6 is removed.	K.Priyadharshini <i>Priyadharshini</i>	S.Rangarajan <i>S.Rangarajan</i>	S.Rangarajan <i>S.Rangarajan</i>



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ENGINEERING DEVELOPMENT CENTRE

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RANIPET

The vendor shall furnish clearly along with quotation details for each of the items listed out in the specification without ambiguity.

GENERAL

G.1 ENCLOSURE

- G.1.1 Actuators shall be of a totally enclosed, weatherproof and dust proof construction with minimum IP 55 enclosure and shall be suitable for outdoor applications.
- G.1.2 Actuator shall be suitable for operation in damp, dusty polluted atmospheres of 95% relative humidity and ambient temperatures varying from -20° C TO +50° C.

G.2 VOLTAGE

- G.2.1 The unit shall be suitable for operation on a 415V 3 phase 50 c/s. A.C. supply.

G.3 CONSTRUCTION

- G.3.1 Damper actuators are open/close duty, direct shaft mounting type.
- G.3.2 The exact mounting arrangement with dimensions shall be clearly furnished along with the offer.
- G.3.3 Each actuator shall have a hand wheel fitted on it for emergency operation. The hand wheel shall be designed such that it is declutched automatically when the power supply to the motor is restored. The hand wheel engaging lever shall give trouble-free performance under repeated operations.
- G.3.4 Actuators offered shall be with self-locking worm.
- G.3.5 Actuators should consist of a basic actuator and secondary gear box and should be supplied in Toto (properly coupled).
- G.3.6 For connecting actuator secondary gear box damper necessary fasteners should be supplied along with actuators.



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- G.3.7 Double compression type cable glands (brass nickel plated) 3 Nos. for control cables and one No. for power cable shall be provided in the actuators. The exact cable size will be informed during drawing approval.
- G.3.8 Actuator shall be clockwise to close.
- G.3.9 All RH mounted actuators shall be clockwise to close. Clockwise rotation of manual hand wheel shall always result closing of actuators.
- G.3.10 Key way length shall be for total length of bore.
- G.3.11 The Bore and key way tolerance are given below.

Description	Main Dimension	Tolerance allowed
Bore Diameter	All	+0.05mm to -0.00 mm
Key way width	≤ 16 mm	-0.06 to -0.02 mm
Key way width	> 16 mm	-0.07 to -0.02 mm
Key way depth	≤ 3.8 mm	0.1 mm to -0.00
Key way depth	> 3.8 mm	0.2 mm to -0.00

- G.3.12 All actuators shall have removable output bush.
- G.3.13 No part of actuator shall protrude beyond secondary gear box flange.
- G.3.14 Separate name plate shall be provided in the actuator.
- G.3.15 All the basic actuators and the gear boxes should have undergone endurance testing. Reference standards are EN15714 for basic actuator and AWWA standard for Gear box.
- G.3.16 Supplier shall confirm self locking is provided in their design. Further to self Locking, the supplier shall confirm over travel will not be there in their design i.e., when power is switched off, gear box should not rotate and gate should not come down on its own. Supplier shall give specific confirmation to this point.
- G.3.17 Sizing calculation to be furnished along with the offer for new models which are not supplied to BAP Ranipet earlier.

G.4 TORQUE

- G.4.1 The actuators shall be capable of giving the required torque at the output shaft. (Required torques are given in the data sheet).
- G.4.2 Indicate the adjustable range of run torque and starting torque of actuator in Kgm for each actuator offered. The actuator shall be designed to operate at the running torque for a period of 15 min or 3 successive open-close

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operations whichever is longer.

G.4.3 Starting torque of the actuator (Basic actuator + Secondary Gearbox) shall be greater than the damper starting torque.

G.4.4 The actuator (Basic actuator+sec.GB) Run Torque (6 min or 15 min) shall be greater than the Damper Run torque (6 min or 15 min).

G.4.5 The stall torque of the actuator (Basic actuator + sec. Gear box) shall be lesser than the damper stall torque.

G.4.6 The momentary torque capacity, continuous torque capacity and maximum torque capacity of the secondary Gear box shall be greater than the starting torque of the actuator (Basic actuator + sec. Gear box).

G.4.7 The run torque range of the actuator (Basic actuator + sec. Gear box) shall cover the required run torque mentioned in the data sheet.

G.5 **REVOLUTIONS**

G.5.1 Each actuator shall be capable of giving total operating turns as indicated in the data sheet. Please furnish actual number of turns available for each actuator offered.

G.6 **SPEED**

G.6.1 Desired output speeds are indicated in the data sheet. Actual speeds of actuators offered shall be clearly indicated.

G.7 **WEIGHT**

G.7.1 Furnish weight of actuators including all accessories.

G.8 **LUBRICANT**

G.8.1 The gearbox of the actuator shall preferably be oil filled. The actuator shall have proper seals to prevent leakage of oil into the limit switch compartments, terminal box and motor. Actuator shall be designed for mounting in any position without lubricant leakage or other operational difficulty.

G.9 **DIMENSIONAL CATALOGUES**

G.9.1 Three copies of catalogues of the actuators in English language describing the constructional details shall be sent along with the offer. The catalogues shall also provide over all dimensions of the actuators and other details called for in the specification.



G.10 O & M INSTRUCTION MANUALS

- G.10.1 25 copies of operating and maintenance instruction manual shall accompany each actuator ordered.

ACCESSORIES

A.1 TORQUE SWITCHES

- A.1.1 Two numbers adjustable torque switches (one for open and one for close), each with 2 NO and 2 NC potential free contacts.
- A.1.2 It is required to have calibration in Kg-m (for whole actuator including secondary gear box) for the torque switches so that the switches could be easily set to any value desired, within the range specified for each actuator.
- A.1.3 Gear train shall be made of metal (Fiber gears are not acceptable).

A.2 LIMIT SWITCHES

- A.2.1 Two numbers of position limit switches, rotary drum type capable of being set at any position (one for open and one for close) each with 2 NO & 2 NC potential free contacts.
- A.2.2 Two auxiliary limit switches rotary drum type capable of being set at any position (one for open and one for close) each with 2 NO and 2 NC potential free contacts.
- A.2.3 Gear train shall be made of metal (Fiber gears are not acceptable).

A.3 MICRO SWITCHES

- A.3.1 Limit switches & torque switches shall be enclosed in weatherproof compartment suitably for damp atmospheres and shall not cause any trouble during commissioning and operation.
- A.3.2 Limit switch compartment shall be weatherproof and spacious enough for easy setting.
- A.3.3 The switches shall be suitable for 5A at 240V AC; 0.5A (Inductive) at 220V DC.

A.4 LOCAL POSITION INDICATORS

- A.4.1 Each actuator shall have a local position indicator to indicate 0 to 100% of travel.



A.5 **ELECTROMAGNETIC BRAKES**

- A.5.1 In case electromagnetic brakes are provided in the actuators the same shall have IP 55 weatherproof enclosures.

A.6 **SPACE HEATER**

- A.6.1 Each actuator shall have a space heater of adequate rating in the limit switch compartment suitable for 240V AC, 50 C/S single phase supply.

A.7 **REMOTE POSITION TRANSMITTER**

- A.7.1 Each open/close actuator shall have two position transmitters for remote indication suitable for 50 Volts AC single phase supply and 50 Volts DC supply. Rating of position transmitter 2x100 ohms;100ma, 50Volts. A suitable fixed dropping resistor must be put in series for limiting the power consumption.

MOTORS

M.1 **POWER SUPPLY**

- M.1.1 Motor shall be suitable for operation on a 415V, 3 phase 3 wire ungrounded supply system.
- M.1.2 Motor shall operate without any trouble under the following conditions.
- If the voltage varies within $\pm 10\%$ of the rated value of 415 V.
 - If the frequency of the power source varies within $\pm 5\%$ of 50 C/S.
 - If the voltage and frequency of the source vary simultaneously and the sum of the absolute percentage values in variation does not exceed 10%.

M.2 **CONSTRUCTIONS**

- M.2.1 Motor shall be squirrel cage induction type. The enclosure shall be totally enclosed, self ventilated with minimum IP 55 degree of protection.
- M.2.2 Motor shall be conforming to BS 2613-70, IS 325 or any other equivalent international standard for all requirements unless otherwise specified herein.
- M.2.3 Motor shall be painted with corrosion proof epoxy-resin paint.
- M.2.4 Motor shall be provided with inbuilt thermostat connected in series (one thermostat in each phase) & wired to limit switch compartment.



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M.2.5 Motors shall have double shielded, grease lubricated anti-friction bearings.

M.3 **INSULATION**

M.3.1 Motor shall have class B insulation with tropicalisation suitable for polluted dusty and corrosion atmosphere of relative humidity 90%. If higher insulation is provided, the temperature rise shall be limited to class-B insulation. Motor shall be designed for ambient temperatures varying between -20°C or +50°C.

M.4 **RATING**

M.4.1 For open/close actuator motor shall be short time rated for S2-15 minutes duty or 3 successive open-close operations whichever is longer.

M.5 **STARTING**

M.5.1 Motor shall be suitable for direct on-line starting.

M.5.2 Starting current shall be limited to 6 times the rated current.

M.5.3 Motor shall be capable of

1. Starting at 85% of rated voltage.
2. Running at 80% of rated voltage for a period of 5 minutes.

M.6 **EARTHING TERMINALS**

M.6.1 2 Nos. Earthing terminals shall be provided on the body of the motor.

M.7 **MOTOR DATA**

M.7.1 Motor data sheets for each type of actuators ordered shall be furnished. Internal wiring and limit switch contact development diagram for the actuators ordered shall be furnished.

M.8 **WEIGHT**

M.8.1 Weight of the motor shall be furnished with the offer.

M.9 **TESTS**

M.9.1 Tests are to be conducted as per relevant Indian Standard and required copies of the test certificates are to be furnished for the tests.

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CONTROLS

C.1 INTERNAL WIRING

C.1.1 Internal wiring of the actuators shall be as per our diagram enclosed with enquiry. The terminal marking also shall be according to the enclosed wiring diagram & limit switch contact development shall be as per BHEL drawing.

C.1.2 Internal wiring diagram shall be neatly pasted on the cover of terminal box.

C.2 TERMINAL BOX

C.2.1 All terminals of position limit switches, torque limit switches, space heaters and positions transmitters shall be brought to a common terminal board. The terminals shall be of screw-type with sufficient insulation between 2 adjacent terminals.

C.2.2. Minimum 5 numbers of terminals shall be available in the terminal board as spare terminals.

C.2.3 Terminal box of actuator shall be weatherproof and have enough space for connecting cable glands/ plug and sockets as indicated in BHEL drawing. Insulation voltage for power terminal block & control terminal block is 650V grade.

C.2.4 Terminal box of motor shall be weather-proof and have enough space for connecting 1 number Power cable which will be indicated before placement of order. Motor terminals shall be stud-type.

C.2.5 The terminal boxes shall be fitted with a removal front cover-plate.

C.2.6 Internal wiring shall be done with 650V, 1.5 sq.mm PVC insulated stranded copper wires. Ferrules should be provided on the wires for easy identification.

S.1 SPARES

Vendor shall specify a list of recommended spares for 2/5 years of trouble free operation.

P.1 PAINT & FINISH

All external parts shall be finished and painted to produce a neat and durable surface, which would prevent Rusting & Corrosion. The equipment shall be thoroughly degreased and sharp edges and scales removed and treated with one coat of Primer and two coats of enamel paint. Refer enquiry for paint

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shade.

- P.1:2 All fasteners used in the construction of the equipment shall be either of corrosion resistant material or high cadmium plated. Current carrying fasteners shall be either of Stainless Steel or High Tensile Brass or Copper.

PURCHASE SPECIFICATION FOR ELECTRONIC INTEGRAL STARTER

1.0 GENERAL

Vendors shall furnish point wise confirmation / deviation to each clause of this specification explicitly.

2.0 INTEGRAL STARTER FEATURES

- 2.1 The integral starter shall be provided in a weather proof enclosure with protection class IP67/IP68.
- 2.2 The control logic of integral starter shall be through Electronic logic control. Hardwire control logic is not acceptable. The electronics should be capable of operating in a temperature range of -20 deg.C to +50 deg.C. Entire integral starter unit along with basic actuator shall conform to IP67/68 Encl standards.
- 2.3 Control supply voltage of the starter shall be 24V DC or 110V AC. If 110V AC is used, then the same shall be derived with step down transformer of 415/110V. Necessary primary and secondary fuses shall be provided Opto isolation circuit shall be provided with suitable coupling relays for 24V DC commands from external control system.

2.4 INTEGRAL STARTER COMPONENTS:

- 2.4.1 Electrically and mechanically interlocked contactors shall be provided for forward and reverse operation. Contactor rating shall be sufficient to withstand the extreme conditions like valve jamming and instantaneous reversal of motor.
- 2.4.2 Key lockable Selector switch for LOCAL-OFF-REMOTE selection shall be provided.
- 2.4.3 OPEN-STOP-CLOSE push buttons (for local operation) shall be provided.
- 2.4.4 Thermal overload relay shall be provided in addition to thermostats embedded in motor winding. Overload relay and thermostats shall be connected in control circuit to

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trip actuator in case of overload. OLR set value shall be mentioned in wiring diagram

- 2.4.5 Automatic phase correction facility and single phasing prevention shall be available.
- 2.4.6 Interposing relays provided (with coil burden $\leq 2.5\text{VA}$, one for open and one for close) to initiate opening and closing by 24V DC signal from the external control system.
- 2.4.7 Open/Close command termination logic with position and torque limit switches shall be suitably built in the PCB inside the actuator.
- 2.4.8 Necessary fuses shall be provided.
- 2.4.9 For torque closing valves, open torque switch shall be bypassed initially for 3 secs or 5% of the valve travel.
- 2.4.10 Space heater for switch compartment shall be provided with internally derived power supply.
- 2.4.11 It should also be possible to reverse the direction of travel for inching valves (in LOCAL and REMOTE) without giving stop command.
- 2.4.8 Provision shall exist in electronic control for bypassing the torque switch during initial 5% opening of dampers. Details for this must be indicated in the wiring diagram.

3.0 INPUT COMMANDS:

- 3.1 Open command (24V DC)
- 3.2 Close command (24V DC)

4.0 OUTPUT CONTACTS FOR CUSTOMER USE:

- 4.1 A common potential free contact (monitoring relay) shall be available to annunciate the following faults.
 - a. Thermostat trip
 - b. OLR trip
 - c. Actuator jammed in mid-travel.
 - d. Motor single phasing.
 - e. Control supply failure.
 - f. Local stop
 - g. L/R selector switch not in remote.
 - h. Torque switch trip (In case tripping by close torque switch is chosen, the same should not be considered as a fault signal).

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- 4.2 Local stop PB operated.
- 4.3 Actuator opened.
- 4.4 Actuator closed.
- 4.5 Open torque switch acted.
- 4.6 Close torque switch acted
- 4.7 L/R switch local.
- 4.8 L/R switch OFF.
- 4.9 L/R switch remote.
- 5.0 The following status annunciation shall be made available locally in the actuator.**
 - a. Actuator OPEN
 - b. Actuator CLOSE
 - c. Actuator running
 - d. Internal 24V DC control voltage healthy.
- 6.0 The following individual fault annunciation shall be made available locally in the actuator for easy trouble shooting.**
 - a. Torque switch OPEN
 - b. Torque switch CLOSE
 - c. Thermostat trip
 - d. Thermal overload relay trip
 - e. Motor single phasing
- 7.0 The actuator shall be suitable for the following signals interfacing with remote control system.**
 - a. Open command from remote control system (Potential free contact).
 - b. Close command from remote control system (Potential free contact)
 - c. Open feedback from actuator to remote control system (Potential free contact).
 - d. Close feedback from actuator to remote control system (Potential free contact)
- 8.0 Actuator shall also be suitable for remote operation by potential free contacts for open / close and stop, the necessary 24V DC power supply shall be derived internally.
- 9.0 Space heater supply shall be derived internally



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10.0 DOCUMENTS TO BE SUBMITTED ALONG WITH OFFER :

- a. Bill of material and control circuit diagram incorporating all standard starter components.
- b. Actuator GA & cross sectional drawing.

" ELECTRICAL ACTUATOR DATA SHEET "

(VENDOR TO COMPLETELY FILL UP AND FURNISH COPIES ALONG WITH OFFER)

ABSENCE OF ANY DETAIL WILL BE CONSTRUED AS NON RESPONSIVE OFFER AND LIABLE FOR REJECTION.

SPECIFY TOLERANCE WHEREVER APPLICABLE - (REQUIRED TO BE CHECKED DURING TESTING / INSPECTION)

SL.NO	SPECIFICATION REQUIREMENT	ACTUATOR SL.NO			
		001	002	003	004
1.0	Actuator type chosen.				
	<u>MOTOR:</u>				
2.0	Type & frame size.				
2.1	Rating (Voltage / KW)				
2.2	Starting current. (A)				
2.3	Current at run torque (15 min. torque for louver & 6 min. torque for gate).				
2.4	Full load current (at 100% Torque setting)				
2.5	Current at dynamic stall (Locked rotor)				
2.6	Permissible locked rotor withstands time.				
2.7	A. Starting Torque				

VENDOR SIGNATURE:



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SL.NO.	SPECIFICATION REQUIREMENT	ACTUATOR SL.NO.			
		001	002	003	004
	B. Run Torque. C. Class of Insulation. D. Stator winding Star or Delta. (Delta Preferable)				
2.8	Full load torque (100 % Torque setting).				
2.9	A. No. Of starts per Hr at no load condition. B. No. Of starts per Hr with load at specified run Torque. C. Full load RPM. D. Ambient temp. in ° C (- 20° C to + 50° C) E. Duty time (S2-15min.) F. Full load power factor. G. Full load efficiency. H. OLR set value <u>GEAR BOX :</u>				
3.0	A. Primary Gear Box Ratio. B. Primary Gear Box Efficiency.				
3.1	Primary GB maximum output torque (KGM)				

VENDOR SIGNATURE:



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SL.NO.	SPECIFICATION REQUIREMENT	ACTUATOR SL.NO.			
		001	002	003	004
4.0	A. Secondary GB type & make. B. Secondary GB Ratio. C. Secondary GB efficiency.				
4.1	Secondary GB maximum torque (KGM)				
4.2	A. Secondary GB continuous torque capacity. B. Secondary GB momentary torque capacity.				
5.0	Actuator + Secondary GB output RPM.				
5.1	A. Actuator + Secondary GB output torque (KGM) (15 min. torque for louver & 6 min. for gate.) B. Secondary GB lead angle less than or equal to 6°. C. Worm & worm wheel material.				
5.2	Actuator + Secondary GB starting torque (KGM).				
5.3	Actuator + Secondary GB dynamic stall torque (KGM).				
5.4	Bore Dia. x length of Secondary GB (mm).				
5.5	Approximate Weight of actuator + Secondary GB.				

VENDOR SIGNATURE:



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SL.NO.	SPECIFICATION REQUIREMENT	ACTUATOR SL.NO.			
		001	002	003	004
5.6	Lubrication: A. Recommended interval of checking/ filling. B. Type of lubricant. C. Indian equivalent make. D. Qty. in Litres / Kg.				
5.7	Type and make of Limit switches and Torque switches.				
5.8	Actuator + Secondary GB paint. A. Colour. B. Paint thickness.				

VENDOR SIGNATURE: