



PRODUCT STANDARD
BUSDUCT ENGINEERING DIVISION

RU/BDE/ENGG/
COPPER STRIP
FLEXIBLE/001
REV-00

PAGE 1 OF 2

TECHNICAL REQUIREMENTS OF COPPER STRIP FLEXIBLE

SPECIFICATION, PROCESS & DRAWING

- 1) THE COPPER STRIP FLEXIBLES TO BE MADE BY HOT FUSION PROCESS.
- 2) ALL TECHNICAL SPECIFICATION, TESTING REQUIREMENTS ETC. SHALL BE GOVERNED BY BHEL CORPORATE PURCHASE SPECIFICATION NO. AA 12007 REV-03 WHICH IS FORMING PART OF THIS ENQUIRY.
- 3) HOT FUSED CU PORTION WILL BE SUBJECTED TO METALLOGRAPHIC TEST ON SAMPLE TO VALIDATE PROCESS.
- 4) PROPER PROCESS SHALL BE ENSURED TO AVOID GREEN SULPHATE FORMATION DUE TO MOISTURE ENTRY/RETENTION DURING MANUFACTURING OR ANY OTHER REASON. IN CASE SUCH DEFECTS ARE OBSERVED DURING GUARANTEE PERIOD - REPAIR/ REPLACEMENT SHALL BE IN THE SCOPE OF SUPPLIER.
- 5) ALL SPECIFICATION & DETAILS IN DRAWINGS SHALL BE FOLLOWED IN ADDITION TO CORPORATE PURCHASE SPECIFICATION AA 12007 REV-03.
- 6) TYPICAL DRAWINGS OF STRIP FLEXIBLES ATTACHED DRG.
(I) RST0145
(II) 41001200030

DIMENSIONS

- 1) THE COPPER STRIP FLEXIBLE THICKNESS SHALL VARY BETWEEN 10 MM TO 20 MM AFTER HOT PRESS FUSION.
- 2) THICKNESS OF CU STRIPS TO BE USED FOR MAKING FLEXIBLE SHALL BE RANGING BETWEEN 0.3 MM TO 0.6 MM.
- 3) WIDTH OF COPPER STRIP SHALL VARY BETWEEN 50 MM TO 150 MM.
- 4) LENGTH OF FLEXIBLE SHALL VARY BETWEEN 450 MM TO 750 MM.
- 5) VARIATIONS IN FINISHED THICKNESS AT HOT FUSED ENDS SHALL NOT EXCEED BY 0.25MM.
- 6) TRIMMING OFF SURPLUS LENGTH AFTER FORMING AT ENDS TO BE DONE.

REV.	00	PRINTS TO:-		APPROVED -		
ALTD.				A. NARAYAN		
APPD.				PREPARED	ISSUED	DATE
DATE.				RUPESH KUMAR		06/04/2018

COPYRIGHT AND CONFIDENTIAL

The information on this document is the property of Bharat Heavy Electricals Limited
It must not be used directly or indirectly in any way



PRODUCT STANDARD
BUSDUCT ENGINEERING DIVISION

RU/BDE/ENGG/
COPPER STRIP
FLEXIBLE/001
REV-00

PAGE 2 OF 2

FINISH, PAINTING & PLATING

- 1) BOTH ENDS OF THE COPPER FLEXIBLE (PRESSED ENDS OF LENGTH UPTO 100 TO 150 MM ON BOTH SIDE) SHALL BE SILVER PLATED WHEN MARKED IN DRAWING.
- 2) SILVER PLATING AT HOT FUSED ENDS IF REQUIRED AND CALLED IN P.O. SHALL BE DONE AND SHALL BE ACCOUNTED SEPARATELY ON THE BASIS OF PER SQCM RATES.
- 3) IN CASE SILVER PLATING IS NOT SPECIFIED, BOTH ENDS SHALL BE TINNED UP TO 13 MICRONS. NO SEPARATE CHARGES FOR TINNING AT ENDS SHALL BE ADMISSIBLE.
- 4) BALANCE LENGTH OF THE STRIP FLEXIBLE SHALL BE BLACK MATT PAINTED.
- 5) SAMPLE DRAWINGS ARE ATTACHED FOR REFERENCE TO UNDERSTAND THE VARIOUS TYPES OF CONSTRUCTION.

IMPORTANT NOTES

- 1) BELOW MENTIONED INFORMATION GIVEN TO FACILITATE ESTIMATION. BUT THIS IS NOT BINDING ON US.
- 2) WE HAVE MENTIONED A LARGE RANGE OF DIMENSIONS WITH A VIEW TO KEEP OPTIONS OF FURTHER DEVELOPMENT. HOWEVER, THERE IS LIKELY TO BE NOT MORE THAN FIVE TYPES OF FLEXIBLES FOR OUR 95% REQUIREMENT. FOLLOWING DIMENSIONS SHALL BE MOST PREVALENT (FOR 95% REQUIREMENT):
 - (I) THICKNESS OF STRIPS 0.40 MM OR NEARBY - MOSTLY ONE THICKNESS SHALL BE FOLLOWED.
 - (II) WIDTH 50 MM REQUIREMENT 40%/ WIDTH 150 MM REQMT. 55%/ OTHER REQMT 5%.
- 3) SUGGESTIONS REGARDING SUITABLE SIZE SELECTION BASED ON AVAILABILITY, EASE IN PROCESSING MAY BE CONSIDERED BY US DURING TECHNICAL BID REVIEW.

REV.	00	PRINTS TO:-	APPROVED -		
ALTD.			A. NARAYAN		
APPD.			PREPARED	ISSUED	DATE
DATE.			RUPESH KUMAR		06/04/2018

COPYRIGHT AND CONFIDENTIAL

The information on this document is the property of Bharat Heavy Electricals Limited
It must not be used directly or indirectly in any way