



BHEL-EPD

ELECTROPORCELAINS DIVISION
BENGALURU – 560012, INDIA
Purchase Specification
Group: Photovoltaic Module

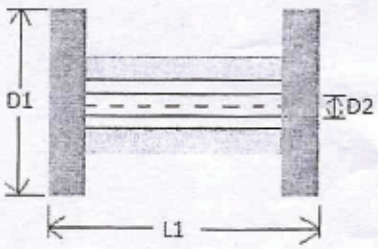
SPEC. NO: PS-901-01-0010

REV. 00

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CELL INTERCONNECT - 4 BB

1.0	ITEM	: Cell Interconnect – 4 BB
2.0	MATERIAL	: Electrolytic tough pitched (ETP) copper as per IS 191-2007
3.0	WIDTH	: 1.3 ± 0.1 mm
4.0	THICKNESS	: 0.2 ± 0.01 mm (Basic copper Thickness)
5.0	COMPOSITION	: Copper purity 99.95% min.
6.0	CONDUCTIVITY (%IACS)	: 101%
7.0	SURFACE FINISH	a) Coating - Coated with 62:36:2 Tin-lead-Silver Solder. - Coating thickness: 16 to 25 microns all around. - Uniform and bright coating, good adhesion all around. b) Mechanical - Natural rounded edges.
8.0	CAMBER	: ≤ 5 mm / meter, uniformity in winding & with good tension.
9.0	FUNCTIONAL REQUIREMENT	Required to be attached to silicon solar cells by automated soldering process.
10.0	PACKING & MARKING	a) To be supplied in spools of max. 6.0 Kg (Net Wt.) including Interconnector wt. 5.0 ± 0.5 Kg per spool. b) Each spool to be sealed in air tight polythene covers. c) To be labelled on the packing consignment: 1) Manufacturers Name 2) Lot No 3) Specification No. - BHEL / PS-901-01-0010 4) Cell interconnect-4 BB (Tin-Lead-Silver 62:36:2) 5) Dimension : $1.3 * 0.2$ mm, Coating: 16 to 25 μ 6) Date of Manufacture 7) No of spools 8) Weight a) Each Spool – on the spool b) Packed Box – net of packed spools.
11.0	TYPICAL SPOOL DIMENSION WITH TYPE- "H"(ALL DIMENSIONS ARE IN mm)	 ▪ Dia. $D1 \leq 152$ ▪ Dia. $16 \leq D2 \leq 17$ ▪ $L1 \leq 122$ The construction of spool should be strong enough for loading and operation in: automated Tabber and Stringer.

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Revision (00):

Issued By

Prepared By

Checked By

Approved By

Date

1st Issue

SPV Eng.

RKP

NAR

CNP

30.08.2017



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12.0	PRECAUTION	a) Wound interconnector on spool shall be free from dents, scratches, burrs and loose winding. b) The Design of spools, winding and packing to ensure safe packing & avoid any possibility of handling / transit damages. c) Coating shall be uniform and free from blister / peel-off.
13.0	INSPECTION	1. Vendor to Submit inspection report for each lot / batch of manufacture for the parameters indicated in this specification viz., visual, dimensional and properties. 2. BHEL reserves the right for pre-dispatch inspection at vendor works. BHEL at its discretion may waive the pre-dispatch inspection at vendors work based on review of vendor inspection report. However, the vendor responsibility is not absolved till the material is finally inspected and accepted at BHEL. Rejections if any at BHEL, vendor to replace good quality materials confirming with this purchase specification.
14.0	INSPECTION AT BHEL	a) Visual Inspection, Dimensional and properties evaluation. b) Single sampling plan as per IS : 10673-1983, Special inspection level S-4, AQL 1.0

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