

REV	DATE	ALTERED	REV	DATE	ALTERED	ADDITIONAL INFORMATION
11	29.07.08	CHECKED			CHECKED	STATUS OF DRAWING
DRAWING RETRACED.						DISTRIBUTION OF PRINTS

1. SURFACE PREPARATION FOR SILVER PLATING (BY FABRICATORS) :-

- WELDED FACES OF CONDUCTOR OR ANY DENT MARK PRESENT ARE TO BE REMOVED EITHER BY SKIM CUT/GRINDING /EMERYING BUT DEPTH OF CUT SHALL NOT EXCEED 1.0 mm.
- DRILLED HOLES SHALL BE DEBURRED ON BOTH SIDE.
- DRILLED END OF THE CONDUCTOR SHALL BE FACED PERPENDICULAR TO THE AXIS OF CONDUCTOR. SILVER PLATING IS TO BE DONE 35 mm FROM LAST HOLE (SEE FIG -1)

2. SPECIAL INSTRUCTION FOR ELECTROPLATERS :-

- SILVER PLATING TO BHEL STANDARD 'BP 0673697/REV.00' SILVER PLATING TO BE MINIMUM 13 MICRON SILVER OR AS SPECIFIED ON CUSTOMERS SPECIFICATION WHICH EXCLUDES THICKNESS OF COPPER STRIKE AND DOUBLE ZINCATE TREATMENT FIG -1 TO BE FOLLOWED FOR SILVER PLATING OF SURFACE IF SPECIFIED ON DRAWING.

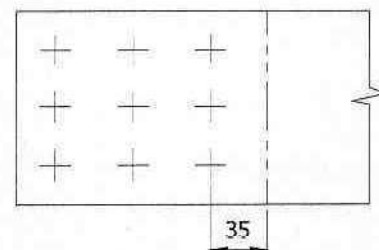




FIG - 1

3. PRECAUTIONS AFTER SILVER PLATING :-

- PROTECTIVE COATING ON PLATED SURFACE : SILVER PLATED SURFACE SHOULD BE COVERED BY COTTON TAPE IMMEDIATELY AFTER PLATING (BY ELECTROPLATERS).
- WHILE DOING WELDING, PRECAUTIONS TO BE TAKEN SO THAT SILVER PLATED SURFACE IS NOT DAMAGED (BY FABRICATORS).
- COTTON TAPE SHOULD NOT BE REMOVED AT ANY STAGE IN THE SHOP. THIS WILL BE REMOVED AT SITE BEFORE MAKING BOLTED JOINTS.

	BHARAT HEAVY ELECTRICALS LTD. RUDRAPUR		NAME	SIGN	DATE
			DRN	VISHAL	29.07.08
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GEN. INSTRUCTION FOR SILVER PLATING ON ALUMINIUM CONDUCTOR & FLEXIBLE			DRAWING NO.		REV.
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