



CORPORATE PURCHASING SPECIFICATION

AA 250 12

Rev. No. 03

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MOULDING MICANITE –SHELLAC BONDED

1.0 GENERAL:

This specification governs with the quality requirements of moulding micanite sheet made from muscovite mica splittings and bonded with shellac powder and free from metallic inclusions being consolidated under heat and pressure . The material shall have a temperature index of at least 130.

2.0 APPLICATION:

Suitable for use in manufacture of vee-rings, bushes, spool washers etc., of Traction motors, Industrial machines etc.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian standard covering this material. However, assistance has been derived from IS 2464-1963 : "Commutator separators and materials".

4.0 DIMENSIONS AND TOLERANCES:

4.1 DIMENSIONS:

4.1.1 Sizes:

Shall be as stated on BHEL order/ drawing.

4.2 Tolerances:

4.2.1 Tolerance on Thickness (Nominal)- IEC 60371-2:

Average value	: ± 0.025 mm.
80% of the Individual results	: ± 0.03 mm
100% of the Individual results	: ± 0.04 mm

4.2.2 On width : ± 5 mm.

4.2.3 On length: ± 5 mm.

5.0 FINISH:

Shall be smooth with trimmed edges, bonds uniformly distributed and also shall be free from hard patches, through holes, foreign inclusions, etc..

6.0 TEST SAMPLES:

3 Sheets of ordered thickness of size 300 x 300 mm, prepared from the same batch, shall be supplied for test and approval.

Revisions :

Cl 33.5.19 of MOM of MRC-E

APPROVED :

INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (E)

Rev. No. 03

Amd.No.

Reaffirmed

Prepared

Issued

Dt. of 1st Issue

Dt.:01.10.2003

Dt :

Year :

BHOPAL

Corp. R&D

JANUARY,1980

**7.0 PROPERTIES:**

Unless otherwise specified, the tests shall be conducted in accordance with the relevant methods of IS 2464.

7.1 Physical Properties:

7.1.1 Density : 1.9 to 2.2 g/cc.

7.1.2 Bond Content:

Average value : 10 ± 2%.
 80% of the Individual results : 10 ± 4%.
 100% of the Individual results : 10 ± 5%.

7.1.3 Mouldability:

Shall be mouldable around a 25 mm diameter mandrel at 100 to 150°C.

7.2 Electrical Properties:

Electrical strength (Proof-1 minute): 7 kV/mm

8.0 TEST CERTIFICATES:

Unless otherwise stated, three copies of test certificates shall be supplied along with each consignment giving following information:

In addition, the supplier shall ensure to send one copy of test certificate along with the dispatch documents to facilitate quick clearance of the materials.

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BHEL order No.

Manufacturers/suppliers Name:

Trade name/mark, if any:

Batch/Lot No.;

Quantity supplied

Test results of clauses 4.0 and 7.0

9.0 PACKING AND MARKING:

Identification slips shall be pasted suitably on all four corners of each board giving the size and manufacturer's reference. The sheets shall be interleaved with paper/polythene sheets and assembled in stacks. The stacks shall be wrapped with moisture proof polythene paper and placed suitably in wooden cases. The packing shall be such that there is no ingress of moisture and damage to boards during transit and storage.

Each package shall be legibly marked with the following information:

AA 250 12: Moulding micanite – shellac bonded

BHEL order No.

Manufacturer's / Supplier's Name

Grade/Trade mark, if any

Thickness, width and Length

Month and year of manufacture

10.0 REFERRED STANDARDS (Latest Publications Including Amendments):

1. IS:2464

2. IEC 60371-2