



TSD 6206 A

PLANT PURCHASING SPECIFICATION BHOPAL

BP 22599

Rev. No. 04

PAGE 1 OF 3

SUPERSEDES
BP 22599 Rev.03

POLYVINYL FLOURIDE FILM

1. GENERAL :

This specification governs the requirement of shell white, glossy, unplasticised polyvinyl fluoride film with good ageing and mechanical properties with a tendency to self-extinguish. Film is impermeable to grease and oils and capable of being heat sealed using impulse and dielectric methods.

Film has a temperature index of at least 105.

2. APPLICATION :

Used as release film for coils of Hydro generator and large Electrical Machines.

3. COMPLIANCE WITH NATIONAL STANDARDS :

There is no Indian Standard covering this type of material.

4. DIMENSIONS AND TOLERANCES :

Thickness, width and length shall be stated on the order.

4.1 Standard thickness and tolerance: $0.025 \pm 10\%$.

However, any other thickness can also be ordered.

3.2 Preferred Width and Tolerance: $40 \text{ mm} \pm 1 \text{ mm}$.

4.3 Length/Roll : 50 metres.

5. FINISH :

The film shall be free from surface or edge defects, inclusions, voids, pin holes, cracks which may affect its suitability for use.

6. TEST METHOD :

Unless otherwise specified the tests shall be conducted in accordance with relevant methods of IS :7809 (Pt.II).

Revision :
Reviewed & No Tech. Change

Issued by :

Prayal
STANDARDS AND MATERIALS GROUP
TECHNICAL SERVICES DEPARTMENT

Rev No : 04

Date : 12.02.2020

Date of first issue : Jan-1969



TSD 6207 A

PLANT PURCHASING SPECIFICATION BHOPAL

BP 22599

Rev. No. 04

PAGE 2 OF 3

7. SAMPLE FOR TEST :

A roll of 15-meter length from the same batch shall be supplied for testing and approval purpose.

8. PHYSICAL PROPERTIES :

- 8.1 Moisture Absorption: 0.5%, Max.
After 24±1 hr of water immersion on 200 mm long sample.
- 8.2 Shrinkage in Air : 8.0 % Max.
After heating at 170 ± 3 deg.C for 30 minutes.

9. MECHANICAL PROPERTIES :

- 9.1 Breaking Strength : 1.5 N/mm, Min.
- 9.2 Elongation: 100%, Min.

10. ELECTRICAL PROPERTIES :

Electric Strength (BDV) in air at Room Temp.: 3 kV, Min.

11. CHEMICAL PROPERTIES :

11.1 Identification of Material :

The material shall be polyvinyl fluoride when identified by infra-red spectrophotometer or by any conventional method.

11.2 Resistance to chemicals :

No visible effect after boiling for 2 hours in any or the following 10 percent Hydrochloric acid. 10 percent Sodium Oxide, Acetone, Benzene, Carbon Tetrachloride, Methyl Ethyl Ketone.

12. TEST CERTIFICATE :

Three copies of test certificate shall be supplied with each consignment giving following information. In addition, the supplier shall ensure to enclose one copy of test certificate alongwith their dispatch documents to facilitate quick clearance of the material.

BP 22599: Polyvinyl Fluoride Film.
Rev.04



TSD 6207 A

PLANT PURCHASING SPECIFICATION BHOPAL

BP 22599

Rev. No. 04

PAGE 3 OF 3

BHEL Order No.

Batch / Lot No.

Test values obtained / certificate for compliance for clauses 4, and 8 to 11.

13. PACKING AND MARKING :

13.1 The film shall be supplied in rolls / reels wound on suitable bobbins with both side well protected so as to prevent distortion of the roll under normal conditions of transportation and use.

13.2 Film shall be packed in such a manner that it is adequately protected from damage in transportation and from deterioration due to climatic condition.

13.3 Each package shall be marked with the following information.

BP 22599 - Polyvinyl Fluoride Film.

BHEL Order No.

Manufacture's Name and Grade.

Thickness, Width & Length.

Month & Year of Manufacture.

Quantity.