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<u>POLYESTER FILM ADHESIVE TAPE</u>			SUPERSEDES BP 22886 Rev.02										
<p>1. GENERAL:</p> <p>This specification governs the quality of polyester film adhesive tape coated on one side with an electrical grade heat curing rubber adhesive which is self-adhesive at ambient temperature and on heat curing, the adhesive attains its highest adhesion and solvent resistance properties.</p> <p>The tape shall have a nominal curing cycle of 1 hour at 120°.C. or 1/2 hour at 130°.C.</p> <p>Exact curing cycle shall be furnished by the supplier.</p> <p>The tape shall have temperature index of at least 130.</p> <p>2. APPLICATION:</p> <p>Used as Bus-bar insulation in Switch Gear and for other technological applications.</p> <p>3. COMPLIANCE WITH NATIONAL STANDARDS:</p> <p>There is no Indian Standard covering this type of material.</p> <p>4. DIMENSIONS AND TOLERANCES:</p> <p>4.1 Sizes:</p> <p>Backing Thickness, Width and Length of the tape shall be stated on the order.</p> <p>4.2 Standard Thickness & Tolerance:</p> <p style="text-align: center;">Thickness (mm)</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th>Backing</th> <th>Finished</th> <th>Tolerance</th> </tr> </thead> <tbody> <tr> <td>0.025</td> <td>0.05</td> <td rowspan="3" style="text-align: center;">±15%</td> </tr> <tr> <td>0.05</td> <td>0.08</td> </tr> <tr> <td>0.075</td> <td>0.10</td> </tr> </tbody> </table>				Backing	Finished	Tolerance	0.025	0.05	±15%	0.05	0.08	0.075	0.10
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Revision : Reviewed & Reaffirmed		Issued by : <i>Rhanda</i> STANDARDS AND MATERIALS GROUP TECHNICAL SERVICES DEPARTMENT											
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4.3 Preferred Width & Tolerance:

15, 20, 25 mm with tolerance of ± 0.75 mm.

4.4 Length/roll

50 metres.

However any other length can also be ordered.

5. COLOUR:

Unless otherwise specified, the tape shall be in yellow colour. However the tape can also be ordered in red, blue, black or natural colour.

6. FINISH:

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

7. SPLICES:

The splices in the tapes shall be not more than one in a length of 10 m and also not more than one in a roll.

8. SHELF LIFE:

12 Months at normal room temperature.

9. TEST METHODS:

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

10. SAMPLES FOR TEST:

A roll of 50 m length from the same batch shall be supplied for testing and approval purposes.

11. PHYSICAL PROPERTIES:

11.1 Adhesion Strength:

2 N/cm Width, Min.



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12. MECHANICAL PROPERTIES:

12.1 Breaking Strength:

Backing thickness (mm)	N/cm Width, Min.
0.025	30
0.05	60
0.075	100

13. ELECTRICAL PROPERTIES:

13.1 Electric Strength (Proof-1 minute) in air at room temp.

Backing Thickness (mm)	kV
0.025	3
0.05	4.5
0.075	6

13.2 Insulation Resistance (IS:2259):

5×10^5 Meg - Ohms, Min.

14. TEST CERTIFICATE:

Unless otherwise specified three copies of test certificate shall be supplied with each consignment.

In addition, the supplier shall ensure to enclose one copy of test certificate along with their despatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information.

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Rev.03

BHEL Order No.
Batch/Lot No.
Shelf Life.

Test values obtained/certificate for compliance for clauses 4 to 8 and 11 to 13.

15. PACKING AND MARKING:

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



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- 15.2 Each roll shall be marked with "USE BEFORE -----
(Date of Expiry), Manufacturer's Name and our Specification No.
- 15.2 Tape shall be packed in such a manner that it is adequately
protected from damage in transportation and from deterioration due
to climatic condition. Rolls shall be protected in such a manner
that they will not adhere to each other or to the container.
- 15.4 Each package shall be marked with the following information.
- BP 22886 : Polyester Film Adhesive Tape.
- BHEL Order No.
- Batch/Lot No.
- Manufacturer's Name and grade.
- Backing Thickness, Width and Length.
- Month & Year of Manufacture.
- Quantity.