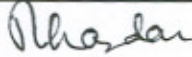
	<b>PLANT PURCHASING SPECIFICATION BHOPAL</b>	BP 22998 REV. NO. 06 PAGE 1 OF 4									
<b><u>POLYIMIDE FILM SELF - ADHESIVE TAPE</u></b> <b>(TEMP. INDEX 200)</b>		<b>SUPERSEDES BP 22998 Rev.05</b>									
<p>1. <b>GENERAL:</b></p> <p>This specification governs the quality of polyimide film self adhesive tape coated on one side with silicone adhesive. On curing, the adhesive shall attain its highest adhesion and solvent resistance properties. The temperature index of composite tape shall be at least 200.</p> <p>2. <b>APPLICATION:</b></p> <p>Used for end sealing, lead and evolute taping of the armature coils of Traction Machines with class 'H' insulation.</p> <p>3. <b>COMPLIANCE WITH NATIONAL STANDARDS:</b></p> <p>There is no Indian Standard covering this type of material.</p> <p>4. <b>DIMENSIONS AND TOLERANCES:</b></p> <p>4.1 <b>Sizes:</b></p> <p>Thickness, width and length of the tapes shall be stated on order.</p> <p>4.2 <b>Standard Thickness &amp; Tolerance:</b></p> <table style="margin-left: auto; margin-right: auto; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: center; border-bottom: 1px dashed black;">Thickness (mm)</th> </tr> <tr> <th style="text-align: center; border-bottom: 1px dashed black;">Backing</th> <th colspan="2" style="text-align: center; border-bottom: 1px dashed black;">Finished</th> </tr> </thead> <tbody> <tr> <td style="text-align: center; border-bottom: 1px dashed black;">0.025</td> <td style="text-align: center; border-bottom: 1px dashed black;">0.06</td> <td style="text-align: center; border-bottom: 1px dashed black;">± 0.01.</td> </tr> </tbody> </table> <p>4.3 <b>Standard Width &amp; Tolerance:</b></p> <p>12 mm with tolerance of ± 0.5 mm.</p> <p>However any other width can also be ordered.</p>			Thickness (mm)			Backing	Finished		0.025	0.06	± 0.01.
Thickness (mm)											
Backing	Finished										
0.025	0.06	± 0.01.									
Revision : Reviewed & Brought uptodate	Issued by :  <b>STANDARDS AND MATERIALS GROUP TECHNICAL SERVICES DEPARTMENT</b>										
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- 4.4 Length/Roll : 50 Metres.  
However any other length can also be ordered.
5. ADHESIVE:
- 5.1 The adhesive used shall be silicone adhesive of at least 200 temperature class as identified by Infra-Red-Spectrophotometer or by any standard method.
- 5.2 The supplier shall submit make and trade name of the adhesive, curing cycle and technical details, along with the quotation.
6. POLYIMIDE FILM:
- 6.1 The base material shall be polyimide film as identified by spectrophotometer or by any standard method.
- 6.2 The supplier shall submit make and trade name of the polyimide film along with quotation.
7. FINISH:
- The tape shall be free from surface or edge defects, inclusions, voids, pin-holes, cracks which may effect its suitability for use. Interleaving material between layers of tape shall not be used.
8. 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.
9. SHELF LIFE:
- 12 months at normal room temperature.
10. TEST METHODS:
- Unless otherwise specified, the tests shall be conducted in accordance with the relevant methods of IS:7809 (Part 2).
11. SAMPLES FOR TEST:
- A roll of 50 m length from the same batch shall be supplied for testing and approval purposes.
12. PHYSICAL PROPERTIES:
- 12.1 Adhesion Strength:
- 12.1.1 After curing for 1 hour at 150 ± 4 deg.C on Steel plates.  
2.5 N/cm width, min.



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12.1.2 After heating for 24 hours at  $200 \pm 4$  deg.C followed by humidity conditioning for 48 hours at  $55 \pm 2$  deg. C and 95-100% RH. 2 N/cm width, Min.

13. MECHANICAL PROPERTIES:

13.1 Breaking Strength: 40 N/cm width, Min.

13.2 Elongation at Break: 25%, Min.

14. ELECTRICAL PROPERTIES:

14.1 Electric Strength (BDV) in air at ambient temp. : 6 kV, Min.

15. TEST CERTIFICATES:

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

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.

BP 22998 : Polyimide Film Self Adhesive Tape.  
Rev.06 Temp.Index.200.

BHEL Order No.

Batch/Lot No.

Shelf life.

Test values obtained/certificate for compliance for clauses 4 to 7 and 12 to 14.

16. PACKING AND MARKING:

16.1 The tape shall be supplied in rolls cardboard reels wound on spools with both sides well protected as to prevent distortion of the roll under normal conditions of transportation and use.

16.2 The adhesive side of the tape rolls shall be on the inside surface and no interleaving material between the layers of tape shall be used.



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16.3 Each roll shall be marked with 'USE BEFORE-----  
(Date of expiry). Manufacturer's Name and our Specification No.

16.3 Tape shall be packed in such a manner that it is adequately protected from damage in transportation and from deterioration due to climatic conditions. Rolls shall be protected in such a manner that they will not adhere to each other to the container.

16.5 Each package shall be marked with the following information.

BP 22998 : Polyimide Film Self Adhesive Tape.  
Temp. Index. 200.

BHEL Order No.

Batch/Lot No.

Manufacturer's Name and Grade.

Thickness, Width and length.

Month & Year of Manufacture.

Quality.