

	PLANT PURCHASING SPECIFICATION BHOPAL		BP 25096
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			SUPERSEDES BP 25096 Rev.01
<u>MOULDING MICANITE SHEET ALKYD VINYL BONDED</u>			
<p>1. GENERAL :</p> <p>This specification governs the quality of flexible moulding micanite sheet made from muscovite mica splittings Gr.6 conforming to AA 25003 and bonded with alkyd vinyl resin and consolidated under heat and pressure. The sheets shall be manufactured without any backing or reinforcing material. The material has a temperature index of at least 155.</p>			
<p>2. APPLICATION :</p> <p>Suitable for the manufacture of vee -rings of Traction Machines.</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 <u>Sizes</u> :</p> <p>610 x 810 mm or as stated on the order/drawing .</p>			
<p>4.2 <u>Thickness and Tolerance</u> :</p>			
<p>4.2.1 Nominal Thickness : 0.25 mm</p> <p>However any other thickness may also be ordered.</p>			
<p>4.2.2 <u>Tolerance</u> :</p>			
<p>Average : ± 0.02 mm</p>			
<p>80% of Individual readings : ± 0.03 mm</p>			
<p>100 % of Individual readings : ± 0.04 mm</p>			
<p>4.3 <u>Tolerance on width</u> : ± 5 mm.</p>			
<p>4.4 <u>Tolerance on Length</u> : ± 5 mm.</p>			
Revision: Reviewed & brought upto date		Issued by : <i>Rhanda</i>	
		STANDARDS AND MATERIALS GROUP TECHNICAL SERVICES DEPARTMENT	
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5. FINISH :

Shall be smooth with trimmed edges, bond uniformly distributed and also shall be free from hard patches, through holes, foreign inclusions such as hair, wood splinters, paper, dust, metallic particles etc. Mica should not flake in appreciable quantity. The sheets when stocked together should not stick to each other.

6. TEST METHODS :

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

7. SAMPLE FOR TEST :

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

8. PHYSICAL PROPERTIES :

8.1 Substance : $560 \pm 30 \text{ gm/m}^2$, Deviations allowed subject to approval by BHEL.

8.2 Mica Content : 89 – 93 % by weight.

8.3 Bond Content : 7 - 11 percent by weight.

8.4 Mouldability :

Shall be mouldable around a 25 mm diameter mandrel without showing any cracks at 140 deg.C.

8.5 Volatile Content at 150 Deg.C for 10 Minutes : 1% Max.

9. SHELF LIFE:

At $27 \pm 3 \text{ Deg.C}$. : 3 Months, Min.

At 10 Deg.C : 6 Months, Min.

10. TECHNICAL DETAILS WITH QUOTATION :

Supplier should give full technical details of the materials used and offer clause by clause comments in his offer. No changes should be made in the material or binder by the supplier without getting approval from BHEL. Supplier should submit an infrared spectrograph for the alkyd vinyl binder which will be used to check the regular supplies.



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11. TEST CERTIFICATE :

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

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

The test certificate shall bear the following information:

BP 25096 : Moulding Micanite Sheet Alkyd Vinyl Bonded.
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Our Order No.

Batch / Lot No.

Test values obtained / certificate for compliance for clauses 4,5 8 & 9.

12. PACKING AND MARKING :

Moulding micanite sheets shall be suitably packed to avoid damage during transit & storage.

Each package shall be marked with the following information.

BP 25096 : Moulding Micanite Sheet Alkyd Vinyl Bonded.

BHEL Order No.

Supplier's / Manufacturer's Name & Grade.

Date of Manufacture & Date of Expiry.

Thickness /Width/Length.

Batch / Lot No.

Net and Gross weight.