

FIRST ANGLE PROJECTION

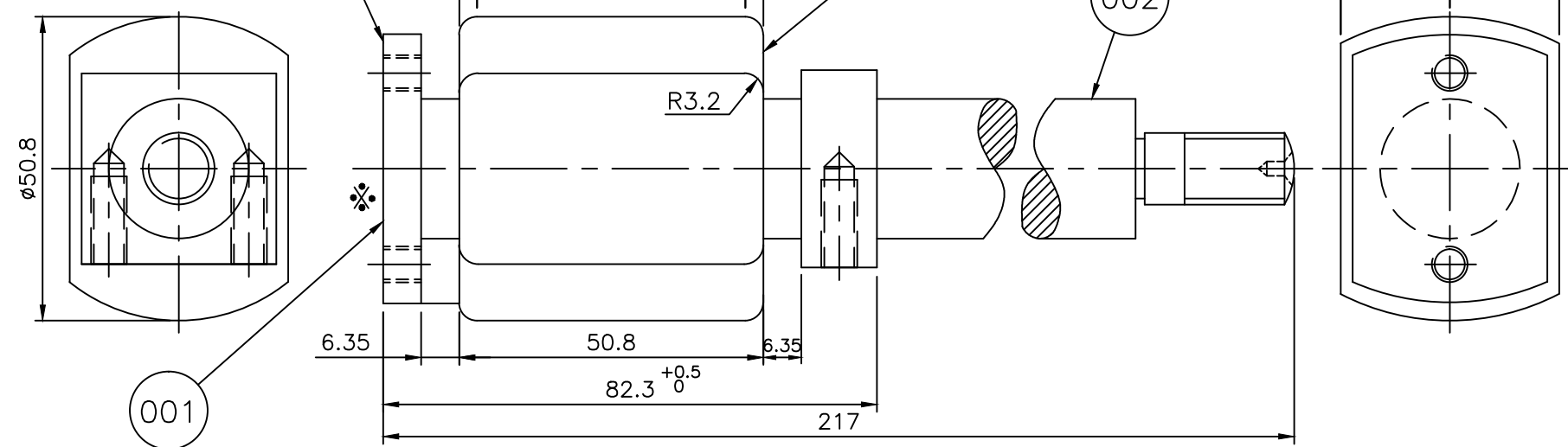
(ALL DIMENSIONS ARE IN mm.)

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9200 8 11 089 8 ON 9NIMVARD  
DRAWING NO.

THIS FACE TO BE SKIMMED SQUARE WITH AXIS OF INSULATOR

PARTING LINE SHALL NOT APPEAR IN THIS REGION ALL ROUND



STYLE LIST				
STYLE NO.	ITEM INCLUDED	DESCRIPTION OR REMARKS	RECORDED	
			SIGN	DATE
BP 9088508453	VAR-00	DMC MOULDED PISTON INSULATOR	Sd/-	09.01.85
BP 9088102287	VAR-01	DMC MOULDED PISTON INSULATOR	Sd/-	09.01.85

TOOL LIST		
ITEM	TOOL	DESCRIPTION
VAR 00&01	1486194	ALIGNABILITY CHECKING TEMPLATE
VAR 00	1489085	MOULDING TOOL
VAR 01	1486491	MOULDING TOOL

- 001
- 005
- 007

**NOTE :-**

- FACE  $\otimes$  TO BE AT RIGHT ANGLE TO AXIS OF COMPLETE INSULATOR.
- THE TWO TAPPED HOLES IN ITEM- 001 TO BE SQUARE WITH ITEM-002.
- INSERTS TO BE CONCENTRIC WITHIN  $\pm 0.4$  AFTER MOULDING.
- INSULATORS ARE TO BE CAPABLE OF WITH STANDING 25 KV FLASH TEST FOR ONE MINUTE BETWEEN INSERTS.
- TOLERANCES ON MOULDED DIMENSIONS TO BE TO CLASS III TOLERANCE OF B.S. 2026-1953.
- TORQUE TEST :- SUBJECT 3 % (MIN 5 NOS.) OF EACH BATCH OF PRODUCTION TO A TORQUE TEST OF 10 Kg METRE FORCE.
- ITEMS TO BE PELIFILM DIPPED TO PROTECT THE MACHINED SURFACES.
- PREHEATING IS TO BE DONE AT 110-115°C.
- MOULDING TEMPERATURE IS 165 $\pm$ 5°C AND PRESSURE IS 75-80 TONS MINIMUM.

VAR. 02	VAR. 01	VAR. 00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT. NO.	MATL. CODE.	A/C	UNIT	UNIT WT.	QTY.
					007	TOP INSERT		4 580 11 30054	003					
					006	BOTTOM INSERT		3 580 11 30075	002					
					005	TOP INSERT		4 580 11 30054	002					
					004	PHENOLIC MOULDING COMPOUND THD 111/20L								
					003	POLYESTER MOULDING COMPOUND (DMC)				AA 2289026018 AA 22826				
					002	BOTTOM INSERT		3 580 11 30075	001					
					001	TOP INSERT		4 580 11 30054	001					

R/34/85

ADDITIONAL INFORMATION 22PC		STATUS OF DRAWING M		DISTRIBUTION OF PRINTS OFFICE COPY - 1 SWM - 4 TCX (SWM) - 1		उत्पाद का प्रकार या ग्राहक/परियोजना का नाम TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT <b>AC/DC EMU INDIAN RAILWAYS</b>	
विभाग DEPT. CEE		जन.टोल.नाप की श्रेणी UNTOL. DIMS. GR.		अनुपात SCALE 1:1		भार कि. ग्रा. WEIGHT (K.G.)	
कोड CODE. 407		CG 06503		भारत हेवी इलेक्ट्रिकल्स लिमिटेड BHOPAL		जसे. ड्राईंग का संदर्भ REF. TO ASSY. 0 580 11 3 0004 0 580 11 3 0005	
शीर्षक/TITLE <b>MOULDED PISTON INSULATOR</b>		ड्राईंग क्र./DRAWING NO. <b>3 580 11 3 0076</b>		मद्र संख्या ITEM NO. 003 पुन. संख्या NO. OF ITEM 007		शीट क्र./SHT.NO 01 शीटों की सं./NO.OF.SHT. 01	

INVENTORY No. 3 580 11 3 0026 VAR 01 REF. DRG. NO. C904 SIGN. & DATE

REV	DATE	ALTERED	CZ.	---	REV	DATE	ALTERED	R.C.B.	-Sd-
07	19.10.12	CHECKED	D.D.		06	30.10.06	CHECKED	R.K.S.	-Sd-
		APPROVED	R.K.S.				APPROVED	AG.	-Sd-

IN REV.06, NOTES 8 & 9 WERE OMITTED BY MISTAKE.

REV	DATE	ALTERED	M.S.J.	-sd-
05	07.10.04	CHECKED	N.K.M.	-sd-
		APPROVED	AG.	-sd-

VAR. 02 ADDED.

NOTES 8 & 9 ADDED.

