



PLANT PURCHASING SPECIFICATION  
BHOPAL

BP 12389

REV NO. 04

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ALUMINIUM FOIL

SUPERSEDES  
BP 12389 Rev.03

1. GENERAL:

This specification governs the quality requirements of 0.025 mm & 0.018 mm Aluminium Foil.

2. APPLICATION:

For use as condenser layers in the primary windings of Instrument Transformers.

3. COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian Standard covering this material.

4. DIMENSIONS AND TOLERANCES:

4.1 Thickness : 0.025 mm and 0.018 mm.

The tolerance on thickness shall be  $\pm 10\%$ .

4.2 Width : As stated on our order.

The tolerance on width shall be  $\pm 1.6$  mm.

5. COVERING CAPACITY:

13 to 16 sq.m/kg for 0.025 mm thick.

18 to 22 sq. m/kg for 0.018 mm thick.

6. STRAIGHTNESS:

Edges of foil in coil, shall not vary from a straight line by more than 10 mm in any 750 mm length.

7. FINISH:

Both surfaces of foil shall be completely wettable with distilled water.

8. FREEDOM FROM DEFECTS:

Clean, free from wrinkles, uncontaminated with oil, grease and any other imperfections.

Revision :

Reviewed & Brought upto date

ISSUED by :

*Phosdar*

STANDARDS AND MATERIALS GROUP  
TECHNICAL SERVICES DEPARTMENT

Rev. No 04

Date: 16.10.07

Date of first issue : April 1970



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9. CHEMICAL COMPOSITION:

The chemical composition of Aluminum Foil shall be as follows:

Element	Percent
Aluminium	99.0 Min.
Combined iron, silicon & other impurities.	1.0 Max.

10. TEST SAMPLES:

One sample per size, per roll, per consignment shall be selected for test.

11. PHYSICAL PROPERTIES:

The foil should unroll evenly and freely from the rolls without sticking, breaking, buckling or tearing across the web.

12. TEST CERTIFICATE:

Unless otherwise stated, three copies of test certificate shall be supplied giving the following information.

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

BP 12389 ( Rev.03 ) : Aluminium Foil.

BHEL Order No.

Manufacturer's / Supplier's Name.

Batch No.

Consignment/Identification No.

Results of Tests

Results of chemical composition, physical properties and dimensional tolerances as specified in this specification.

13. PACKING AND MARKING:

The foil shall be wound in a continuous length on metal tubes having 60 mm ID and 0.8 mm thickness approximately. The OD of the rolls shall not exceed 150 mm.

The rolls of foil shall be packed in damp proof packing to avoid ingress of moisture and oxidation.



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All rolls must be packed suitably to prevent damage in transit and marked with the following information.

BP 12389 : Aluminium Foil.

BHEL Order No.

Manufacturer's / Supplier's Name.

Date of manufacture and / or identification no.

Nominal thickness and width of the aluminium foil.

When packed, the outside of the packing cases shall also be marked with the above details.

The inner core shall bear the following information.

The manufacturer's name or trade mark for identification.

Batch or Identification No.

14. REJECTION AND REPLACEMENT:

If the material does not comply with the requirements of this specification during receipt inspection at BHEL or if any defect is found during further processing of the material, BHEL reserves the right to reject the whole consignment and the supplier shall replace the material free of cost.