



TSD 6206
A

PLANT PURCHASING SPECIFICATION
BHOPAL

BP 22962

REV NO. 03

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SUPERSEDES
BP 22962 Rev.02

NYLON EXTRUSIONS AND MOULDINGS
(TYPE 6)

1. GENERAL:

This specification governs the quality of nylon extrusions and mouldings made from Type 6 general purpose nylon. The material shall not be affected by alkalis, weak acids, alcohols and other common solvents. Superior electrical grade materials are covered by BP 22961 (Nylon Type 11).

2. APPLICATION:

Used as cable bush and oil injection plugs in A.C.Machines, as rod form in switchgear and for manufacturing of sealing washers for use in Transformers.

3. COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian Standard covering this type of material.

4. DIMENSIONS AND TOLERANCES:

Shall be stated on order or the drawing accompanying the order.

5. FINISH:

The material shall be smooth and free from surface imperfections and blow holes.

6. TEST METHODS:

Unless otherwise specified, the tests shall be conducted in accordance with the relevant methods of BS: 7663-1993. In case of components, density, water absorption and hardness shall be done on the components itself.

7. SAMPLE FOR TEST:

Six No. of samples in size 3 tk x 150 x 150 mm moulded from the same batch and in the same manner as the consignment concerned, shall be supplied for testing and approval purposes.

Revision :
Reviewed & Brought upto date

Issued by : *Sharda*
STANDARDS AND MATERIALS GROUP
TECHNICAL SERVICES DEPARTMENT

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8. PHYSICAL PROPERTIES:

8.1 Density at Room Temp. : 1.13 ± 0.05 g/cc.

8.2 Water Absorption at Room.Temp.: 1.5%. Max.

9. MECHANICAL PROPERTIES:

9.1 Tensile Strength: 60 N/mm², Min. (OPTIONAL TEST)

In case of rod, the test shall be done in as received condition.

9.2 Hardness (ASTM D 785) : 110 ± 10 , Rockwell 'L'.

10. ELECTRICAL PROPERTIES:

10.1 Electrical Strength (BDV) at Room Temp.

Unless otherwise specified on the drawing, BDV value shall be 10 kV/mm on a 3 mm thick test specimen.

11. CHEMICAL PROPERTIES:

11.1 Identification of material:

The material shall be nylon when identified by Infra-red spectrophotometer or by any conventional method.

12. TEST CERTIFICATE:

Three copies of test certificates shall be supplied with each consignment.

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

The Test Certificate shall bear the following information

BP 22962 : Nylon Extrusions and Mouldings (Type 6) :
Rev.03

Our Order No.

Batch/Lot No.

Test values obtained/certificate for compliance for clause 5 and 8 to 11.



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13. PACKING AND MARKING:

The nylon extrusions and mouldings shall be suitably packed to avoid contamination and damage in transit. Packages shall be labelled with the following information.

BP 22962: Nylon Extrusions and Mouldings (Type 6)

Our Order No.

Supplier's/Manufacturer's Name and Grade.

Date of Manufacture.

Drawing and Item Nos.

Net and gross weight.