

Rev. 10
Date 04/04/2010



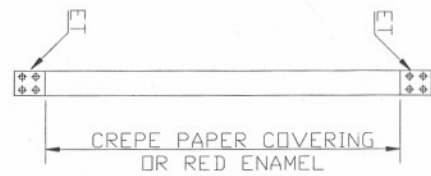
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PRODUCT STANDARD
TRANSFORMER
SHOP/ENGG INSTRUCTIONS

TR10017P
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PAGE 1 OF 1

TITLE : PLATING OF FERROUS & NONFERROUS PARTS & FASTENERS

SL NO	PART/FASTENER	MATERIAL	MEDIUM IN WHICH USED	TYPE OF COATING	COATING THICKNESS	REMARKS
1.	BUS BAR, ROD, PLATE, LUG, JUMPER, PALM & ANY OTHER SECTION FOR CURRENT CARRYING	COPPER OR COPPER ALLOY CONTAINING MORE THAN 50% OF COPPER e.g. BRASS	AIR OR OIL	ELECTROPLATED COATING OF TIN (ET) GRADE Sn 15 C OF IS : 1359	LOCAL THICKNESS =15µm (MIN.)	<p>A. IF THE PART IS INSIDE TANK DURING PROCESSING CONTACT SURFACE ET, (JOINTED PORTION) UNJOINTED PORTION : ONE LAYER OF 50% OVERLAP WOUND CREPE PAPER TO AA21117 TYPE B SEE TR10005P.</p> <p>B. IF THE PART IS NOT MOUNTED DURING PROCESSING CONTACT SURFACE - ET UNJOINTED PORTION : OIL RESISTANT AIR DRYING SYNTHETIC ENAMEL RED SHADE TO AA56132</p>
2.	AIR END TERMINALS OF BUSHINGS PRIMARY TERMINAL OF 400 KV CT ETC.	COPPER OR COPPER ALLOY	AIR	ELECTROPLATED COATING OF SILVER	LOCAL THICKNESS =10µm (MIN.) OR AS SPECIFIED ON WO.	PROCESS FOR ELECTROPLATING OF SILVER AS PER AA0673613
3.	CAP, COLLER, BOLT, SPECIAL NUT WASHER & ANY OTHER ITEM (NORMALLY USED AROUND CURRENT CARRYING COMPONENT FORMING A CLOSED CIRCUIT FROM EDDY CURRENT CONSIDERATIONS	COPPER OR COPPER ALLOY CONTAINING MORE THAN 50% OF COPPER e.g. BRASS	AIR OR OIL	ELECTROPLATED COATING OF TIN (ET) GRADE Sn 15C OF IS 1359	LOCAL THICKNESS =15µm (MIN.)	<p>1. BOLT/SCREW HEAD, NUT OUTER SURFACE, SCREWED ROD/STUD ENDS SHALL BE TAKEN AS SIGNIFICANT SURFACE FOR MEASUREMENT OF LOCAL THICKNESS AS PER CL.4-2.1.1 OF IS : 1573 FOR ZPP & CL. 2.1 OF IS : 1359 FOR ET.</p> <p>2. FOR ZPP OF HARDWARES OF P. CL. 10/10.9 & ABOVE & SPRING WASHERS SEE NOTE-3</p>
4.	ALL TYPE OF HARDWARES/ FASTENERS INCLUDING THOSE IN JOINTED PORTION OF CURRENT CARRYING PARTS. (STUDS, AUTOWELD, STUDS, BOLT, NUT, PLAIN WASHER & SPRING WASHER ETC. SCREW. *	MAGNETIC STEEL, (BLACK, BRIGHT, SHAFT, HIGH TENSILE SPRING STEEL ETC.)	AIR OR OIL	ELECTROPLATED COATING OF ZINC TO GRADE Fe/Zn 12.5 WITH CHROMATE CONVERSION COATING TYPE 'D' AS PER IS : 1573	LOCAL THICKNESS =12.5µm (MIN.)	



NOTES : 1. ALL DRAWINGS WHERE PLATING HAS BEEN CALLED WILL GIVE REFERENCE OF THIS DRG ; i.e. ZPP/ET TO TR 10017P.
2. SILVER PLATING SHALL BE CALLED WHEN SPECIFICALLY ASKED FOR BY THE CUSTOMER.
3. H/W OF P. CL. 10/10.9 & ABOVE & SPRING WASHER WHICH ARE REQUIRED TO BE ZPP SHALL BE HEAT TREATED BEFORE & AFTER PLATING FOR STRESS RELIEF & HYDROGEN EMBRITTEMENT RELIEF AS PER IS : 1573.

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DATE
23.08.83

SHEET REAFFIRMED

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