

Technical Pre-Qualification Requirement for mica segment for HS15250A Traction Motor

The Pre-Qualification Criteria for mica segment of HS15250A Traction Motor are as under

1. Mica segment should be as per BHEL drawing no. 34394260057 Rev 03.
2. Material for Mica segment should be alkyd vinyl bonded mica as per IEC-371-3-1.
3. Supplier to intimate sources of raw material for manufacture of mica segment.
4. The suppliers should be registered with RDSO Electrical Directorate as Part-1 or Part-2 approved source and their names should appear in latest RDSO Electrical Directorate vendor directory for this items.

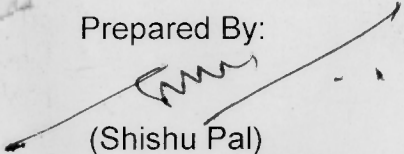
OR

Supplier may submit their sample for evaluation at BHEL as per drawing and specification on chargeable basis. After getting satisfactory results supplier has to take approval from RDSO Electrical Directorate.

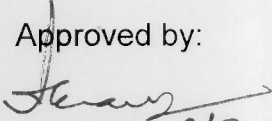
Weblink of latest RDSO vendor directory (valid from 1/7/2013 till 31/12/2013):

<http://www.rdsso.indianrailways.gov.in/works/uploads/File/Electrical%20Item%20Vendor%20Directory%20%20July%20Dec%202013%20Ver%206%20.pdf>

Prepared By:

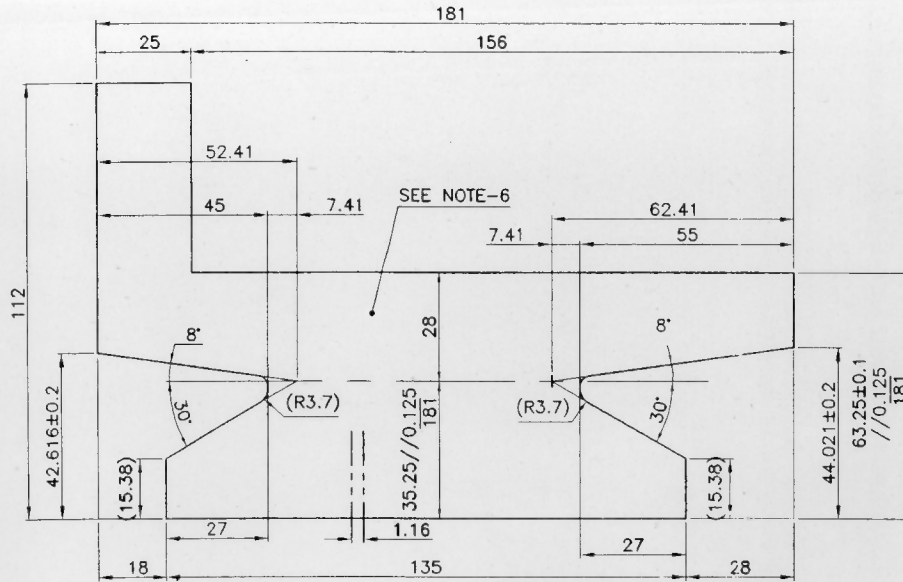

(Shishu Pal)
Sr. Engineer/TME

Approved by:


(A K Varshney)
AGM/TME

DRG. NO. 34394260057

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NOTE :-

FOR THIS PART, DIMENSION ADJUSTMENT OF MATERIAL SHOULD BE MADE THE FOLLOWING PROCEDURES BELOW

- 1) SURFACE PRESSURE TO EACH BLOCK; 420 kg/cm².
- 2) NO. OF BLOCKS FOR ONE COMMUTATOR AND NUMBER OF SHEET IN ONE BLOCK (AFTER CUTTING IN SHAPE)
 - a) NO. OF BLOCKS FOR ONE COMMUTATOR ; 24 BLOCK
 - b) NO. OF SHEET IN BLOCKS ; 12 SHEET
- 3) ALL BLOCK THICKNESS MUST BE MEASURED AND THE MEAN VALUE MUST BE TAKEN AS THE STANDARD BLOCK SIZE. MOREOVER, DIMENSION ADJUSTMENT ERROR BETWEEN BLOCKS MUST BE NOT MORE THAN ±0.03mm TO THE STANDARD DIMENSION.
- 4) STANDARD BLOCK THICKNESS UNDER PRESSURE AND TOLERANCE =13.296±0.2.
- 5) NUMBER OF SHEETS FOR ONE COMMUTATOR AFTER CUTTING IN SHAPE; 288 (INCLUDING SPARE 3 SHEET)
- 6) MANUFACTURER'S IDENTIFICATION TO BE STAMPED AT THE LOCATION SHOWN.
- 7) THIS DRAWING IS EQUIVALENT TO CLW DRG NO. 10S813-324 (ALT-F).
- 8) FOR RAW MATERIAL IN 'L' SHAPE DRG. 34394260064 TO BE REFERRED.

INVENTORY NO. SIGN. & DATE REF. DRG. NO.

VAR 00	REMARKS	VAR NO.	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	IT.N.O.	MATL. CODE	UNIT WT.	UNIT QTY.	CS	ZONE
				001 SEGMENT MICA				ALKYL VINYL BONDED MICA AS PER IEC-371-3-1	0.027			

ADDITIONAL INFORMATION
10S813-324 (ALT-F)
STATUS OF DRAWING

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT
TRACTION MOTOR
HS-15250 A

DISTRIBUTION OF PRINTS
TME- 1 TXM- 3
TNX- 1



BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

DRN	NAME	SIGN	DATE	NO. OF VAR.
ASWINI J.		-SD-	14.09.10	
D.K.		-SD-	14.09.10	
S.P.		-SD-	14.09.10	

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	DEPT.	GRADE OF UN.TOL.	SCALE	WEIGHT(K.G.)	REF. TO ASSY.DRG.	ITEM NO.	NO. OF ITEM	
03	1.02.12	CHANGED APPD.	02	9.09.12	CHECKED APPD.	01	9.08.12	CHECKED APPD.	T.M.E.	'M'	NTS	0.027	24394260052	002	001	
		ALKYL VINYL BONDED MICA AS PER IEC-371-3-1 WAS TM10441			DRG. UPDATED.			NOTE-8 WAS NOT ON.	405				24394260057		03	
													SHT. NO.	01	NO. OF SHEET.	01

SEGMENT MICA

DRAWING NO.
34394260057