

SPECIFICATION
FOR
NON-ADHESIVE POLYIMIDE FILM TAPE

Ah
AEE/TMD.

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DRN.

SPECIFICATION FOR NON-ADHESIVE POLYIMIDE FILM TAPE FOR 3-PHASE TRACTION MOTOR 6FRA 6068 & 6FXA 7059


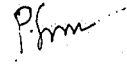





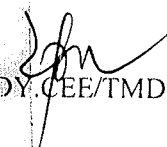
Dr. S. S. Chatterjee
BY: CBE/TMD.

CHITTARANJAN LOCOMOTIVE WORKS
WEST BENGAL, INDIA

NO. **4TMS.096.029**
DATE: 14.09.2009

ALTERATION SHEET

SHEET NO. 2 OF 4

	ALT. NO.	AUTHY.	DESCRIPTION	INITIAL	DATE
 AEE/TMD.	3.	DY.CEE/TMD	ROLL LENGH 50 METRES (MAXIMUM 20% OF THE LOT CAN BE ACCEPTED AS ROLL LENGH 30-50 METER WITHOUT ANY JOINT).		11.06.2020
 CHKD.	2.	DY.CEE/TMD	THICKNESS CORRECTED TO 0.0508 FROM EXISTING IN CLAUSE 1.3 & 2.1 VIDE NOTE NO. CLW/TM/12153 DTA 29.12.17		8.1.2018
 CHKD.	1	DY.CEE/TMD	ALT-1 SPOOL DIA MODIFIED FROM 55-76 m.m		31.7.2012
 DRN.	SPECIFICATION FOR NON-ADHESIVE POLYIMIDE FILM TAPE FOR 3-PHASE TRACTION MOTOR 6FRA 6068 & 6FXA 7059		 DY.CEE/TMD	CHITTARANJAN LOCOMOTIVE WORKS WEST BENGAL, INDIA NO. 4TMS.096.029 DATE:14.09.2009	

1.0. General:**1.1. Scope:**

This specification cover the manufacture and supply of Non-Adhesive Polyimide Film Tape 2 mil thk x 20 mm wide to be used in 3-phase Traction Motor 6FRA 6068 / 6FXA 7059 application as winding of over hang portion on stator coils. The materials shall comply with this specification, instruction, mechanical properties and electrical properties and all other listed requirement. This specification is based ABB delivery instruction/Specn. No.HZN02575 and Dupont's technical data sheet.

1.2. Construction Structural Requirement:

The material is made of aromatic Polyimide Foil.

1.3. Size:

0.0508mm

(ALT 2)

Thickness – 2 mil (~~0.058 mm~~) x 20 mm width (in continuous roll of 50 m).

2.0. Requirements :**2.1. Properties:**

Size & terms	Unit	Values *	Test method
Thickness	mm	0.058 ± 0.004 (ALT 2)	
Mass per unit area Permissible deviation	g/m ²	72 ± 5	DIN 53352
Tensile strength at 23°C	N/m m ²	> 160	ISO 1184
Elongation at rupture at 23°C	%	> 45	ISO 1184
Dielectric strength at 23°C	KV/ mm	> 197	IEC 243
Shrinkage % MD. &TD at 400°C (752°F) max.	%	≤ 2.5	DIN 40634 Page --I Section 2.9.3

* 0.0508 ± 0.004 mm

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3.0. Marking :

Each roll shall be legibly marked at both ends with the following Information –

- (k) Manufacturer's name or trademark.
- (l) Purchase order reference and date.
- (c) Description, size, quantity, batch No., date of mfg. and date of expiry.

4.0. Packing:

ALT-3

The material shall be supplied in 50 m roll wound on a hard tubular core/spools with an inside diameter of 55 mm. also sufficient tension to form a compact roll without deforming the construction of the tape. The tape shall wound tightly over the core such that the edges are not uneven and shall not get loosened when dropped over a floor from one-meter height. Each roll of the material shall be suitably packed so that no damage can arise during transportation and it can be unloaded easily.

5.0. Inspection:

The material shall be inspected by an authorized representative of CLW as per Clause.2.1 at the firm's premises for which necessary testing facilities shall be made available by the supplier free of cost.

5.1. Inspection authority must check original Challan/Invoice of imported raw-material. Quantity of raw-material consumed against P.O. under inspection must be endorsed under Challan/Invoice.

5.2. In case of import, the firm must produce original TC, GC & import document to the Inspecting authority. TC should not be older more than 90 days at the time of inspection.

ALT-1

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*** SHEET END ***

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