

**NOTES:**  
1. TOLERANCES ON UNSPECIFIED DIMENSIONS SHALL BE AS PER IEC:233-1974.  
2. TESTS AS PER IEC:233-1974.  
3. SURFACES MARKED THUS SHALL BE GROUND & UNGLAZED AND PARALLEL TO EACH OTHER AND PERPENDICULAR TO THE AXIS.  
4. SURFACE OF FLANGE & PORCELAIN IN CONTACT WITH CEMENT SHELL BE GIVEN ONE (1) COAT OF TAR (BITUMINOUS PAINT).  
5. SEALING SURFACE MUST BE FREE AT RADIAL MARKS OR SCRATCHES & NO CRACKS ARE ALLOWED.  
6. GROUND SURFACE PERPENDICULAR TO CENTER LINE WITHIN = 4.0 mm.  
7. MARK AT BOTTOM FLANGE AFTER HYDRO TEST COMPLETED ON ASSEMBLED INSULATOR.  
8. WALL THICKNESS VARIATION < 3.0 mm.  
9. END DIAMETERS OUT OF ROUNDNESS OD. = 4.0 mm.  
10. TILT OF SHEDS TOP SHEDS = 7.0 mm, BOTTOM SHEDS = 9.0 mm (MAX).  
11. GLAZE OF COLOUR = LIGHT BLUE GREY (ANSI 70).  
12. MIN. NOMINAL CREEPAGE DISTANCE 4699 mm (185").

**TOLERANCES ON ASSEMBLED INSULATORS :**

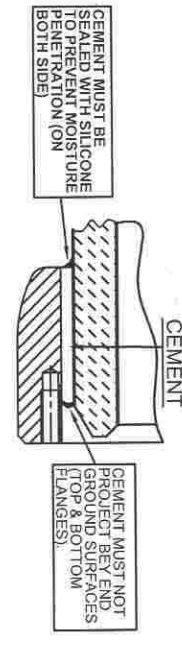
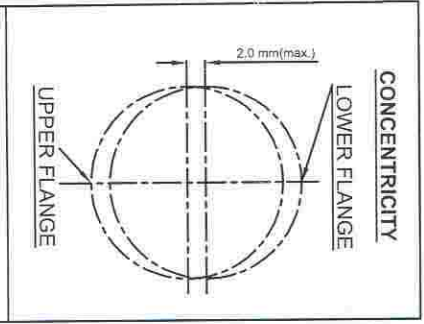
1. PORCELAIN I.D. CONCENTRIC WITH BOLT CIRCLE DIA WITHIN -- 4.0 mm AT EACH END.
2. PARALLELISM BETWEEN FLANGE FACES - 0.2 mm.
3. MISMATCH BETWEEN HOLES OF UPPER & LOWER FLANGES = 5.0 mm.

**TYPE TESTS (ON 3 SAMPLES):**

1. IMPORTANT DIMENSIONS & VISUAL EXAMINATION.
2. TEMPERATURE CYCLE TEST.
3. CANTILEVER LOAD TEST (UPRIGHT) - 1704 kgf.
4. INTERNAL BURST PRESSURE TEST 44.2 bar FOR 5 MINUTES.
5. POROSITY TEST.
6. LIGHTNING IMPULSE WITH STAND VOLTAGE -- 650 kVp (TEST TO ARRANGED BY CUSTOMER).

**ROUTINE TEST :**

1. IMPORTANT DIMENSIONS & VISUAL EXAMINATION.
2. 4 - WAY CANTILEVER LOAD TEST - 852 kgf.
3. DIE ELECTRIC TEST - 55 kV.
4. ULTRASONIC TEST.
5. DYE PENETRATION TEST ON PORCELAIN GROUND SURFACE.
6. INTERNAL PRESSURE TEST ON STAND TEST - 31 bar FOR 5 MINUTES.



**SHED DETAILS**

TT NO	DESCRIPTION	MATERIAL	QTY/CST	DRG. NO.	IEC DRG. NO.	REMARKS
4.	CEMENT	PORTLAND	--	--	--	--
3.	BOTTOM FLANGE	AL ALLOY.	1 (4 OF 4)	DT13C1412585	51D0838/H2	LM - 25
2.	INSULATOR SHELL	PORCELAIN	1 (1 OF 4)	DT13C1412585	PF/51D1553	--
1.	TOP FLANGE	AL ALLOY.	1 (1 OF 4)	DT10C1410892/30F4 DT13C1412585/30F4 DT13C1412585/30F4	51D0838/H1& 51D1554/H1	LM - 25

**PSN COMPONENTS**

DRN	PROBANT	DATE
CHD		03.02.00
APPD		03.02.00

ASSY. DRG. REF. SCALE PROJECTION MATERIAL FINISH  
MIS NTS AS ABOVE GLAZED

DRG. NO. DT 13C 1 412 585 (2 OF 4)

TITLE **170-kV DT 185" CREEPAGE BUSHING**

DRAWING NO. **5 1 D 1554**

REV	DATE	APPD	REV	DATE	APPD	REV	DATE	APPD	REV	DATE	APPD
4.	14.08.04	APPD	3.	04.07.01	APPD	2.	09.03.01	APPD	1.	28.02.00	APPD

REV 4. APPD DRAWING RE-DRAWN IN AutoCAD.

REV 3. APPD PART NO. -1412-585-63 IN MARKING ADDED.

REV 2. APPD TOP FLANGE DRG. NO. 5 1 D 1554/H1 AND NO. OF SHEDS ADDED.

REV 1. APPD BUSH OVERHANG CHANGED AND TOP & BOTTOM SHEDS DIA. WERE 300 & 400.