BSES

Technical Specification

For

66kV, Single core Cable

Specification no – BSES-TS-40-1C66-R0

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1.0 SCOPE

The scope of supply includes Design, Manufacture, testing at manufacturer's works before dispatch, packing, delivery including unloading and stacking of 66kV Single Core cable complete with all accessories at site/store.

2.0 STANDARDS & CODES

Materials, equipment and methods used in the manufacture of Cable shall conform to the latest edition of following:

S No.	STANDARD	DESCRIPTION
2.1	IS–8130	Conductor for insulated electric cables & flexible cords
2.2	IS-5831	PVC insulation and sheath of electric cables
2.3	IS-3975	Mild steel wires strips and tapes for armoring cables
2.4	IS-5216	Guide for safety procedures and practices in electrical works
2.5	IS-7098 (Part – III)	Cross-linked polyethylene insulated thermoplastic sheathed cables specification.
2.6	IS – 10810	Methods of test of cables
2.7	IEC-60811	Common test methods for insulating and sheathing materials of electric cables and optical cables
2.8	IEC-60228	Conductor for insulated cables
2.9	IEC-60840	Power cable with extruded insulation and their accessories for rated voltage above 30kV up to 150kV- Test methods and requirements

3.0 SERVICE CONDITIONS

Cables to be supplied against this specification shall be suitable for satisfactory operation under the following service conditions-

3.1	Average grade atmosphere	Heavily polluted, Dry
3.2	Maximum altitude above sea level	1000M
3.3	Relative Humidity	100%
3.4	Ambient air temperature	Highest 50 Deg C Average 40 Deg C Minimum 0 Deg C
3.5	Operating temperature	0 Deg C - 50 Deg C
3.6	Rainfall	750mm concentrated in four months

4.0 DESIGN FEATURES

S No.	Parameters	Technical Requirements	Offered by Vendor
4.1.0	Manufacturing process	The cable shall be manufactured by "Triple head extrusion process". The conductor screen, Insulation & Insulation screen shall be co-extruded by onetime process to ensure homogeneity and reduction of voids in the insulation and the screening system of the cable, whereby enhancing the life of the cable. The cable shall be strictly manufactured by "DRY CURE and DRY COOLING " process.	
4.2.0	Conductor	Electrolytic grade aluminum conductor shall consist of flexibility class-2 in accordance with IS 8130/IEC 60228. The shape of conductor shall be compacted, stranded, and circular.	
4.3.0	Longitudinal water sealing of conductor	Shall be achieved by water swelling fibers in the interstices of the conductor. The fibers shall turn into jelly/swell, when in contact with water making the conductor water tight.	
4.4.0	Semi conducting separator tape	Semi-conducting separator tapes shall be applied over the conductor, suitable for continuous operating conductor temperature of 90^0C.	
4.5.0	Conductor screen	The conductor screen shall consist of extruded semi-conducting compound which shall be fully compatible with the conductor and extruded insulation. Outer surface of semiconductor screen shall be super smooth, cylindrical and firmly bonded to the overlaying insulation.	
4.6.0	Insulation	The extruded WTR - XLPE insulation shall be of very high degree of purity. The average thickness shall not be less than nominal value as given in annexure "B". The minimum thickness at any point shall not be less by more than 10% of the nominal value. Percentage eccentricity of the insulation shall not be more than10%.	
4.7.0	Insulation Screen	The insulation screen shall consist of extruded semi-conducting compound which shall be fully compatible with extruded insulation. Insulation screen shall be firmly bonded to the insulation.	

S No.	Parameters	Technical Requirements	Offered by Vendor
4.8.0	Make of insulation and semi conducting screen	For Insulation: WTR-XLPE of Dow/Borealis/Hanwa For Conductor & Insulation Screen: Semiconducting compound of Dow/Borealis/Hanwa Any deviation to above shall not be acceptable.	
4.9.0	Core	The ovality of the core shall not be more than 5%.	
4.10.0	Inner Longitudinal water sealing bedding	Semi-conducting water swell-able tapes shall be applied over the extruded semi-conducting insulation screening with a minimum overlap of 10%.	
4.11.0	Metal screening (if required to meet the short circuit rating)	The metallic screen shall consist of a layer of copper tape applied in helical form. Copper tape overlap: Minimum 10%	
4.12.0	Outer Longitudinal water sealing bedding (if metallic screening is provided)	Semi-conducting water swell-able tapes shall be applied over the metallic screen again with a minimum overlap of 10%.	
4.13.0	Metallic sheath	The metallic sheath shall be made of Corrugated aluminum sheathing with minimum thickness of 1.75mm and nominal thickness of 1.8mm, provided with high-viscosity bitumen-based compound coating, in conjunction with textile tape as carrier material for corrosion protection of the outer surface of corrugated aluminium sheathing. Further the corrugations shall be filled with compatible filler material to provide smooth round surface over the aluminium corrugated sheathing, so as to prevent ingress / traveling of water along the corrugations	
4.14.0	Outer Sheath	The outer sheath shall consist of extruded black colored HDPE type ST-7 with anti-termite protection. The Minimum thickness shall be 3.3 mm at any point. Nominal Thickness shall be 4 mm. Carbon black content shall be 2.5 ±0.5%	
4.15.0	Semi conductive layer over the	Extruded Semi conductive layer shall be either extruded or graphite coating.	

	outer sheath		
4.16.0	Cable Rating	The cable size shall be suitable to carry rated load current on 66 kV continuously without exceeding the maximum conductor temperature of 90^0 C.	
4.17.0	Drum Length	500 meter +/- 5% (short lengths not acceptable except the last length and minimum acceptable short length shall be 250 meters.). The Overall tolerance - 2 % for the total cable length of the entire order Manufacturer shall not be allowed to put two cable pieces of different short length in same cable drum.	
4.18.0	Embossing	The extruded outer sheath shall be embossed with meter marking at interval of 1 meter. Meter marking shall start from zero in every drum. The ”A” end meter marking and “Z” end meter marking and the drum lengths shall be printed on the drum flange along with other markings. The outer sheath shall also be embossed with (min.) a) Voltage designation b) Type of construction/cable code (e.g.A2X2Y) c) Number of core and nominal cross sectional area. d) Type of cable “Electric Cable” e) Manufacturers name & trademark f) Name of buyer (e.g.BSES) g) Month & year of manufacturing h) Batch no / Lot no. i) Sequential length marking j) Purchase order number & date k) ISI mark l) Individual Drum number Progressive sequential marking shall be start at zero for each drum	
4.19.0	Joints and Terminations	The Joints and Terminations to be offered with the cable shall be fully type tested as per IS 60840. The Joints and Terminations shall match all technical performance parameters of the specified cable. The Joints and Terminations would be either Heat Shrink or Cold-Shrink.	

5.0 INSPECTION & TESTING

S No.	Parameters	Technical Requirements	Offered by Vendor
5.1.0	Type test	The cable and the associated accessories like Joints and terminations of same voltage, design and number of cores shall be Type Tested from CPRI/ERDA as per IEC 60840/IS7098 (part-3) with latest amendments. Type test report (from CPRI/ERDA only) of not more than five (5) years old shall be submitted for the same type, size and voltage rating of the cable offered, along with the bid to qualify in the tender. All type tests shall be carried out in accordance with IEC-60840 / IS 7098 (part-3) and in accordance with the sequence prescribed therein. Type Test Required After Award of PO: Type test on one cable drum of each type/rating from any lot shall be conducted at CPRI/ERDA on sample basis as per relevant IS/IEC. Sample shall be sealed by BSES during inspection of cable. This type test is applicable subject to BSES requirement and cost shall be borne by BSES	
5.2.0	Routine test	a) Each drum length of cable shall be subjected to the tests as mentioned in IEC 60840, IS 7098 (Part-3), IEC 60229 and IS 10810 b) Impulse voltage test of one drum and Physical dimension of each and every layer along with component.	
5.3.0	Acceptance Tests	The sampling & acceptance tests shall be conducted as per IEC: 60840 / IS: 7098 (Part-3) and approved BSES QA plan for each lot of cable during the inspection of lot at manufacturer's works.	

5.4.0	Special tests	The following tests shall be carried out as special tests a) Conductor examination as per IEC-60840 for conformance of IEC 60228/IS 8130. b) Measurement of thickness of insulation as per Clause 10.6 of IEC- 60840 and Clause 8 of IEC-60811-1-1./ IS 10810 part 6 c) Void and contamination as per IS 7098 (Part-3) d) Sheath Integrity Test e) Carbon black content test in Inner sheath & Outer Sheath f) Hot set test for TR-XLPE insulation as per Clause 10.9 of IEC-60840/ IS 10810 Part 30	
5.5.0	Inspection	The buyer reserves the right to inspect cables at the Seller's works at any time prior dispatch, to verify compliance with the specifications. In-process and final inspection call intimation shall be given in 10 days advance to purchaser. In the event of any discrepancy in the test reports i.e. test reports not acceptable or any type tests(including special /additional tests, if any) not carried out , same shall be carried out without any cost implication to BSES before dispatch of cable.	
5.6.0	Test certificates	Three sets of complete test certificates shall be submitted along with the dispatch documents.	

6.0 SHIPPING, HANDLING & SITE SUPPORT

6.1.0	Packing	The cable shall be wound on non-returnable steel drums of suitable size of minimum hub diameter of 20D (where D is the overall diameter of the cable) and packed conforming to international standards. The drum shall be fully enclosed by suitable packing preferably PP sheeting. Cable shall have sea worthy packing in case cables are dispatched by shipping lines.

6.2.0	Pulling eye & sealing of Cable ends	A cable pulling eye shall be provided at "Z" end of cable on each drum. Suitable fillings/putty shall be used for sealing gap between outer sheath and pulling eye. Heat shrinkable sleeves with the pulling eye shall also be provided. The pulling eye shall be directly connected to the conductor and be capable to withstand a tensile load of 30N/mm^2 of conductor area. The "A" end of the cable shall be sealed with filling material/putty and heat shrinkable cap. Drawing of the pulling eye shall be submitted along with the bid for review.
6.3.0	Drum identification label	The following information shall be marked on the drum: The following information shall be marked on the drum: a) Drum identification number b) Trade name or trade mark; if any c) Name of manufacturer d) Name of buyer i.e. BSES e) Nominal sectional area of the conductor of the cable f) Type of cable and voltage for which it is suitable g) Length of the cable on the drum, with "A" end and "Z" end markings h) Purchase order number with SAP item code i) Year and month of manufacturing j) Direction of rotation of drum (an arrow) k) Net weight of cable in drum and gross weight of cable with drum l) Batch no or Lot no.
6.4.0	Shipping	The seller shall give complete shipping information concerning the gross weight, size of each packing.
6.5.0	Handling & Storage	Manufacturer instruction shall be followed. Detail handling & storage instruction sheet/manual needs to be furnished before commencement of supply.
6.6.0	Transit damage	The seller shall be responsible for any transit damage due to improper packing.

7.0 DEVIATIONS

7.1	Deviation	Deviations from this Specification shall be stated in writing with the tender by reference to the Specification clause/GTP/Drawing and a description of the alternative offer. In absence of such a statement, it will be assumed that the bidder complies fully with this specification.

Annexure – A

Scope, Documentation and Delivery schedule

Document/Drawing submission shall be as per the matrix given below:

i. All documents/drawings shall be provided in soft copy only in returnable Pen drives
ii. Language of the documents shall be English only.
iii. Incomplete submission shall be liable for rejection.
iv. Document check sheet compliance shall be the first sheet for each submission stage i.e. Technical bid, Drawing Approval, Pre Dispatch.
v. No submission is acceptable without check list compliance.
vi. Deficient/ improper document/ drawing submission shall be liable for rejection.
vii. Order of documents shall be strictly as per the check list.
viii. Any drawing not included in the below table but necessary for detailed engineering shall be deemed to be included in bidder's scope.

S No.	Description	Bid	Approval	Pre Dispatch
8.1	Guaranteed Technical Particulars (GTP)	required	required	
8.2	Deviation Sheet, if any	required	required	
8.3	Detailed cross sectional drawing of cable	required	required	
8.4	Type test reports for the offered type and rating of cable and joints & terminations	required	required	
8.5	Complete product catalogue and Manual	required	required	
8.6	Certification for quality standards	required		
8.7	Make of Raw Materials	required	required	
8.8	Cable de-rating factors	required	required	
8.9	Dimensional drawing for pulling eye & End cap		required	
8.10	Manufacturer's Quality Assurance Plan		required	
8.11	Program for production and testing		required	
8.12	Detailed installation & commissioning instructions		required	
8.13	Test certificates of all raw materials			required
8.14	Inspection and routine test reports, carried out in manufacturer's works			required

Annexure–B: Guaranteed Technical Particulars (Data by Supplier)

S No.	Description	Unit	Data specified by the purchaser	Data to be filled by the manufacturer
1	Name of Manufacturer			
2	Country of manufacturer			
3	Type of cable			
4	Standard according to which cable is manufactured			
5	Rated voltage	kV	38/66	
6	Highest system voltage	kV	72.5	
7	System frequency	Hz	50	
8	No of phases per circuit	Nos	3	
9	System earthing		Solidly grounded	
10	Rated short time current of conductor	kA		
11	Rated short time current of metal sheath (alone)	kA		
12	Rated short time current of metal screen (if provided)	kA		
13	Rated short time current of metal sheath and screen	kA	19	
14	Duration of short circuit current	Sec	1	
15	Impulse withstand voltage 1.2/50 micro sec wave	kVp	325	
16	Power frequency withstand voltage	kV(rms)	140	
17	Conductor			
a)	Nominal cross sectional area	mm^2	1000 / 630	
b)	Type class of conductor		Compacted Stranded Circular	
c)	Material of conductor		Aluminum	
d)	Flexibility class of conductor		Class -2	
e)	Minimum numbers of strands	No.		
f)	Diameter of strands before compaction. (nominal / Minimum)	mm / mm		
g)	Material of longitudinal water sealing filling of conductor			

S No.	Description	Unit	Data specified by the purchaser	Data to be filled by the manufacturer
18	Details of semi conducting tape over the conductor			
19	Conductor Screen			
a)	Material and type			
b)	Minimum thickness	mm	0.8	
c)	Make and grade of semi conducting compound.			
20	Insulation			
a)	Material of Insulation		TR-XLPE	
b)	Nominal thickness	mm	11	
c)	Minimum thickness		9.9	
d)	Make and grade of insulation compound			
e)	Maximum dielectric stress at the conductor surface	kV/mm		
21	Insulation screen			
a)	Material and type			
b)	Minimum thickness	mm	0.8	
c)	Make and grade of semi conducting compound.			
22	Inner water swellable tape			
a)	Nominal thickness	mm	0.3	
b)	Minimum swell height in one minute.	mm	12 mm in one minute	
c)	Water swallable tape overlap	%	min 10%	
23	Copper tape required to meet the short circuit rating (if provided)			
a)	Thickness and width of copper tape	mm / mm		
24	Outer water swellable tape	mm		
a)	Nominal thickness	mm	0.3	

S No.	Description	Unit	Data specified by the purchaser	Data to be filled by the manufacturer
b)	Minimum swell height in one minute.	mm	12 mm in one minute	
c)	Overlap	%	10% min	
25	Nominal diameter under metal sheath	mm		
26	Material of the metal sheath		Corrugated aluminum(with corrosion protection& corrugation filling)	
27	Minimum thickness of Corrugated Aluminum sheath	mm	1.75	
28	Nominal radial clearance allowed under metal sheath (in case of corrugated aluminum sheathing)	mm	Vendor to provide	
29	Nominal diameter over metal sheath	mm		
30	Outer Sheath			
a)	Material and type		HDPE type ST 7	
b)	Minimum thickness	mm	3.3	
c)	Nominal thickness	mm	4	
d)	Anti termite treated?		Yes / No	
e)	Color		Black	
31	Material of semi-conductive coating/extrusion over the outer jacket			
32	AC test voltage at works for insulation.	KV(rms)	90	
33	DC test voltage at works for outer jacket.	KV (DC)	25	
34	Overall dia of completed single core cable	mm		
35	Weight per meter of complete cable	kg/m		

S No.	Description	Unit	Data specified by the purchaser	Data to be filled by the manufacturer
36	Short circuit capacities with maximum conductor temperature of 250Deg C : (conductor temperature of 90 Deg C at the commencement of short circuit) a) 0.5 second duration b) 1 second duration c) 2 second duration d) 3 second duration	kA		
37	Minimum radius of bend round: which cable can be laid a) Direct burial inground b) Inducts	mm		
38	Maximum D.C. resistance of conductor per KM at 20^0C	Ohm/km	0.0469 for 630 mm^2 cable 0.0291 for 1000 mm^2cable.	
39	Maximum AC resistance of conductor per KM at 90 deg. C	Ohm		
40	Equivalent star reactance per KM of 3 phase circuit at 50 Hz	Ohm		
41	Maximum electrostatic capacitance per KM of cable	pf		
42	Maximum continuous current carrying capacity per circuit when laid in ground as per the following parameters (with screens cross bonded) -Maximum continuous conductor temperature of 900 C -Maximum conductor temperature during short circuit of 2500 C -Ground temperature of 300C -Soil resistivity of 1500C- cm/Watt -Depth of laying of 150cm	Amp		
43	Maximum continuous current carrying capacity per cable when laid inair with ambient temperature of 40^0C and other	Amp		

S No.	Description	Unit	Data specified by the purchaser	Data to be filled by the manufacturer
	parameters as per S no 42 (with screens cross bonded)			
44	Rating factors for ambient air temperature attached	Yes/No		
45	Rating factors for ground temperature attached	Yes/No		
46	Rating factors for phase spacing in flat formation attached	Yes/No		
47	Rating factors for grouping of cable laid in ground in horizontal formation attached	Yes/No		
48	Rating factors for grouping of cable laid in ground in tri-foil touching formation attached	Yes/No		
49	Rating factors for thermal resistivity of soil attached	Yes/No		
50	Rating factors for depth of laying attached	Yes/No		
51	Max.power factor of charging KVA of cable when laid direct in the ground at normal voltage frequency at conductor temperature at 90^0C			
52	Max.dielectric power loss of cable per km of 3 phase circuit laid direct in ground at normal voltage, frequency and maximumconductortemperatureo f90^0C	Watt /km		
53	Sheath loss of cable per KM of 3 phase circuit at normal voltage frequency at maximum continuous current rating. a) Laid direct inground b) Drawn intoducts c) Installed in air	Watt/km		
54	Impedance per KM of 3phase circuit at 50 C/s and maximum conductor temperature. a. Impedance	Ohm		

S No.	Description	Unit	Data specified by the purchaser	Data to be filled by the manufacturer
	b. Reactance c. Positive and negative sequence d. Zero sequence e. Capacitance f. Conductance g. Inductive susceptance h. Conductive susceptance			
55	Standard drum length of cable	meters	500 +/- 5% (short lengths not acceptable except the last length)	
56	The overall quantity tolerance	%		
57	Cable to be wound on non returnable steel drum.	Yes/No	Yes	
58	Normal delivery length	meters		
59	Cable pulling Eye to be provided at "Z" end A End shall be provided with sealing end cap	Yes		
60	Tensile load withstand capacity for pulling eye		30 N / mm^2	
61	Approximate shipping weight for the normal deliver length with the drum size (flange dia. in mm and width in mm)	kg		
62	Drum size and weight (Flange dia X flange width X hub dia)			
63	Embossing details on outer sheath			
64	Sequential marking at every meter		Provided	
65	Process of cross linking of polyethylene.			
66	Induced Voltage in sheath, cable			
a)	In trefoil formation	V/km		
b)	In flat formation with D+70	V/km		

S No.	Description	Unit	Data specified by the purchaser	Data to be filled by the manufacturer
67	Cross Sectional Drawing of offered cable design with layer wise component details		To be provided by bidder	

Annexure - C

List of Sub-Vendors for critical items

Vendor/Bidder to state sub-vendors' names for other items, wherever approved names are not mentioned, for purchaser's approval during tendering stage else purchaser shall impose as per their requirement and bidder to follow the same in post-order stages.

Ser. No.	Raw Materials		Name of the Make
1.	XLPE Compound	1	Dow Chemicals , U.S.A.
		2	Borealis , Sweden
		3	Hanwha , South Korea
2.	Semi-Conducting Compound	1	Dow Chemicals, U.S.A.
		2	Borealis , Sweden
		3	Hanwha , South Korea
3.	Conductor Water-Blocking tapes / yarn	1	Lantor
		2	Geca
		3	Miracle
		4	Scapa
		5	Sneham International
4.	Water-Swellable Tapes (Pre-slitted)	1	Lantor
		2	Geca
		3	Miracle
		4	Scapa
		5	Sneham International

Ser. No.	Raw Materials		Name of the Make
5.	Aluminium Rod	1	Bharat Aluminium Co. Ltd. (BALCO)
		2	Hindustan Aluminium Co. Ltd. (HINDALCO)
		3	National Aluminium Co. Ltd. (NALCO)
		4	Vedanta (Sesa Sterlite)
6.	Copper Tape	1	Aggarwal Metal
		2	Indian Smelting
		3	Luvata Swedan
		4	Outokumpu Copper Strip AB, Swedan
7	Galvanised Steel Wires / Strips	1	Tata
		2	Balaji
		3	Systematic
		4	Mica Wires Pvt. Ltd.
		5	Bansal Industries
8	PVC Compound	1	Kalpana
		2	Universal
		3	SCJ Plastic
		4	Sriram Polytech
		5	Shri Ram Vinyl, Kota
9	P. P. Fillers	1	Vijoy Polymers
		2	Yash Polymers
		3	AVSL Industries
10	Core Identification Tape	1	AVSL Industries
		2	Yash Polymer

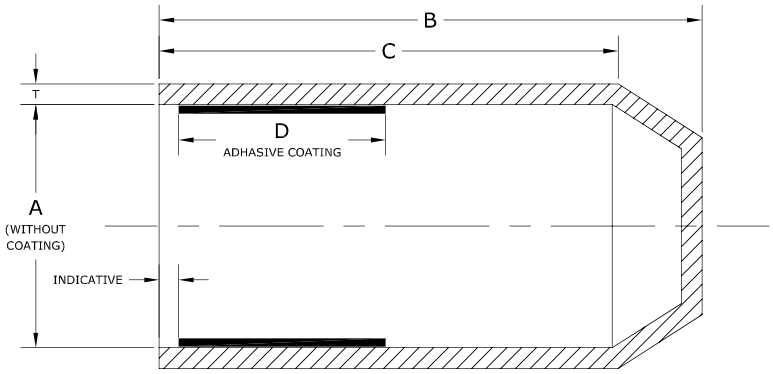
Ser. No.	Raw Materials		Name of the Make
		3	Vijoy Polymers
11	PE Compound	1	Borealis
		3	Shakun
		4	Kalpana

ANNEXURE -D

DIMENSIONS

SIZE	A EXP.(Min.)	A REC.(Max)	B EXP.(Min.)	C EXP.(Min.)	D EXP.(Min.)	LC %	T (WALL REC. ± 20 %)
EC 120/150	75	34	120	105	50	± 10	4.2
EC 240/300	100	62	130	110	70	± 10	3.5
EC 400	145	75	155	120	70	± 10	4.6

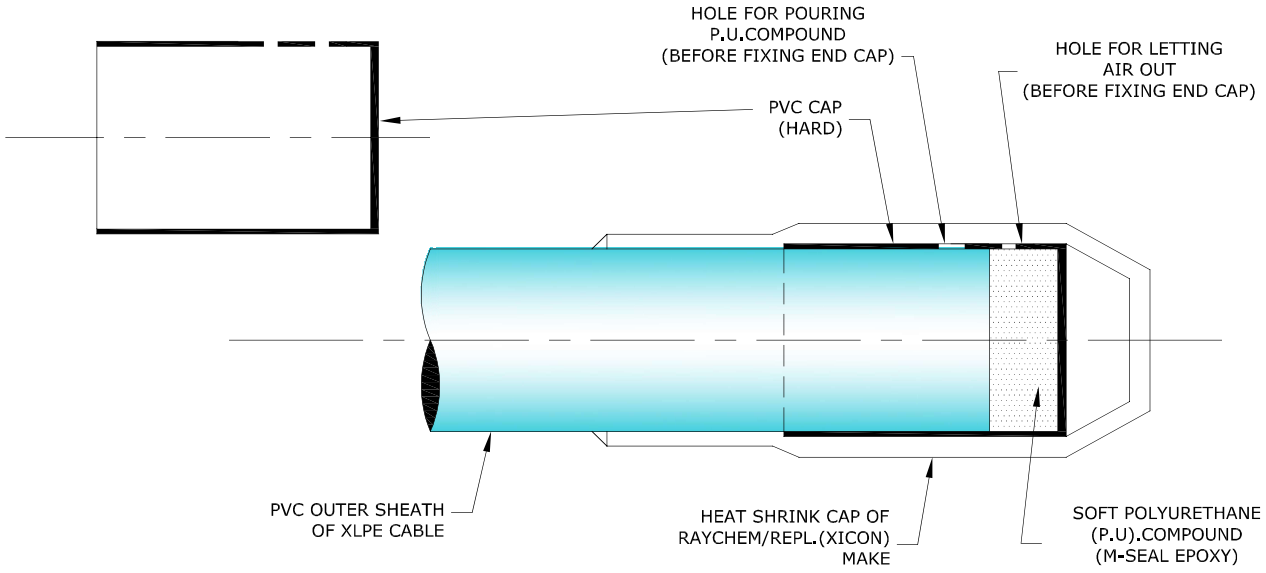
EXP - Expanded (as supplied), REC - Recovered freely, LC - Longitudinal Change,T - Wall Thickness, EC - End Cap



END CAP
(AS SUPPLIED)
SECTIONAL VIEW

MATERIAL SPECIFICATIONS

	Characteristics	Test Class	Value	Test Method
A	**Physical Properties**			
1	Specific Gravity	Type	1.05 ± 0.2	ASTM D-1505
2	Water Absorption	Type	1 % (max)	ASTM D-570 / ISO 62
3	Tensile Strength	Routine	10 N /sqmm (min)	ASTM D-412 / ISO 37
4	Ultimate Elongation	Routine	300% (min)	ASTM D-412 / ISO 37
5	Hardness	Type	45 shore D ± 3	ASTM D-2240
6	**Thermal Test**			
B	Thermal Ageing (120°C for 500 hrs)			
1	Tensile Strength	Type	8 N/sqmm (min)	ASTM D-412 / ISO 37
2	Ultimate Elongation	Type	200% (min)	ASTM D-412 / ISO 37
C	**Electrical Properties**			
1	Volume Resistivity	Type	10^{12} ohm-cm. (min)	ASTM D-257 / IEC 93
2	Dielectrical Strength	Type	10 kV/mm. (min)	ASTM D-149 / IEC 243
3	Dielectric Constant	Type	5 (max)	ASTM D-150 / IEC 250



END CAP
(AFTER HEAT SHRINKING OVER THE CABLE END)

Note : 1) All dimension in mm
2) Colour Black
3) Size as mentioned in the table shall be stencilled on respective item

BSES

DRAWING No. MISC/E/4-1131/1698

SCALE :NOT TO SCALE | DATE: 09-05-2011

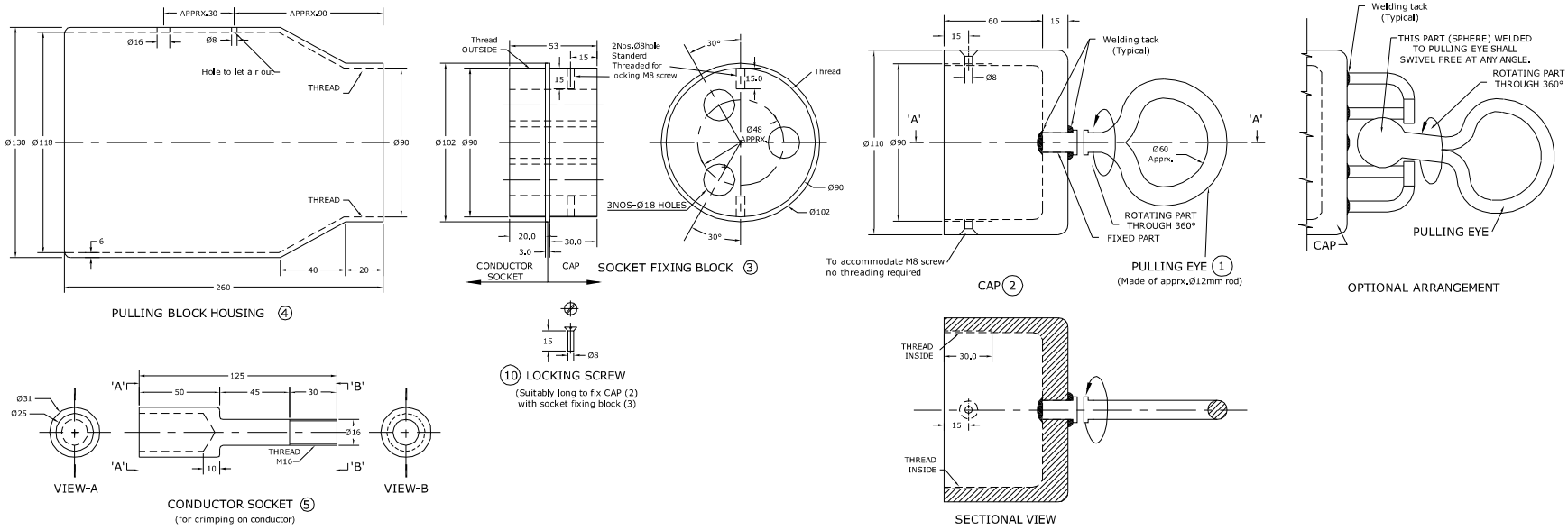
END SEALING CAP
(FOR XLPE CABLE)

DRAWN BY:	CHECKED BY:	APPROVED BY:

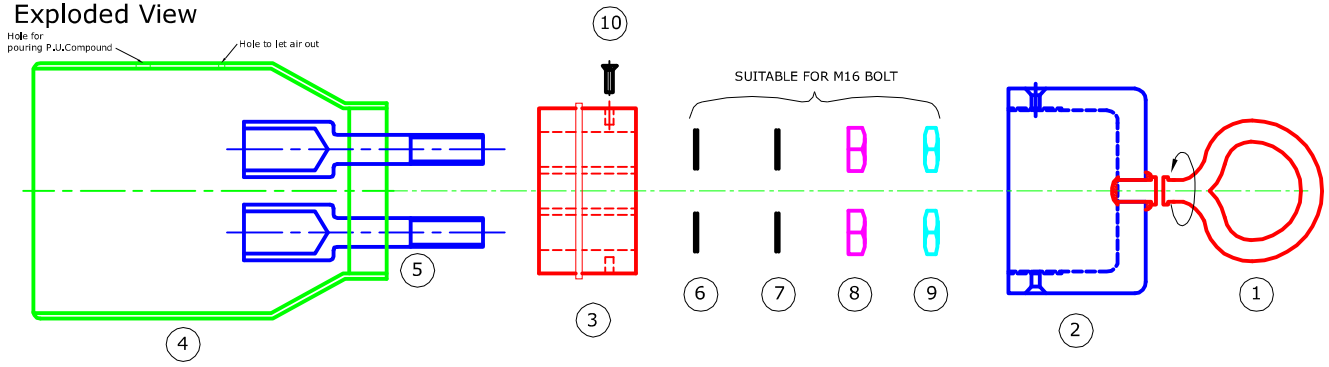
REVISIONS

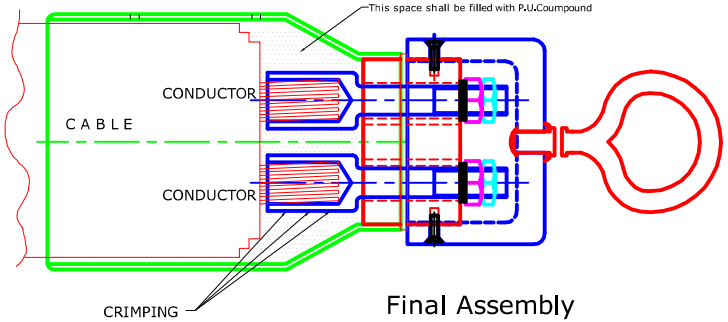
Addl V.P.

ANNEXURE -E



Exploded View





Final Assembly

EXAMPLE:
1) For cable size 33kV, 3/C X 400sq mm Al XLPE.
2) Diameter over conductor : 23.8mm apprx.
   Overall diameter : 108±3mm apprx.
   Pulling force applicable on the cable : 30 N/sq mm
   Pulling eye shall withstand total force of : 36000N+Safety margin

NOTE:
1) All Dimensions are in mm, unless otherwise stated.
2) This drawing is typical / indicative.Separate dimensioned drawing for cable pulling eye assembly, suitable for required size & rating of cables, shall be submitted for approval,prior to manufacturing.
3) After fixing cable pulling eye, P.U.(Poly-Urethane) Compound shall be poured to occupy inner spaces to avoid ingress of Water / Moisture.
4) After P.U.Compound oozes/flows out from the cable side,the same edge shall be sealed with suitable sleeve/Tape.

NO.	DISCRIPTION	QTY.	MATERIAL
10	LOCKING SCREW	2	M.S.Zinc-Plated
9	LOCK NUT	3	M.S.Zinc-Plated
8	NUT	3	M.S.Zinc-Plated
7	SPRING. WASHER	3	M.S.Zinc-Plated
6	PLAIN WASHER	3	M.S.Zinc-Plated
5	CONDUCTOR SOCKET	3	AL.
4	PULLING BLOCK HOUSING	1	M.S.Zinc-Plated
3	SOCKET FIXING BLOCK	1	M.S.Zinc-Plated
2	CAP	1	M.S.Zinc-Plated
1	PULLING EYE	1	M.S.Zinc-Plated

BSES

DRAWING No. MISC/E/4-1133/1699

SCALE :NOT TO SCALE | DATE: 09-05-2011

CABLE PULLING EYE ASSEMBLY (TYPICAL)

DRAWN BY: | CHECKED BY: | APPROVED BY:

REVISIONS

Addl V.P.

ANNEXURE-F

BSES

QUALITY ASSURANCE PLAN (QAP)
FOR 66 kV EHV CABLES

S. NO.	COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			Remark
									SV	MFR	BSES	
1	2	3	4	5	6	7	8	9	10	11	12	13
	Legend : SV : Sub-Vendor of Cable Manufacturer, MFR : Cable Manufacturer, MPS : Material Purchase Specification,											
	P : Perform, W : Witness, V : Verification											
A	**RAW MATERIAL**											
1	Aluminium/Copper Rod	a) Tensile strength	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		b) Resistivity	Major	Electrical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		c) Diameter	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		d) Chemical composition	Major	Chemical	Sample	MPS	MPS	Test certificate	P	V	V	
		e) Surface finish	Major	Visual	Sample			-	P	P	_	
2	PVC Compound	a) Tensile Strength	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		b) Elongation at break	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		c) Thermal stability	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
3	**TR-XLPE** Compound (Borealis/Dow chemical/ Hanwa)	a) Packing	Minor	Visual	100%	MPS	MPS	-	P	V	-	
		b) Tensile Strength	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		c) Elongation at break	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		d) Hot set test	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		e) Volume Resistivity	Major	Electrical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		f) Cure Curve (Max. Torque)	Major	Physical	Sample	MPS	MPS	Reg./Sheet	-	P	V	
		g) Density	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
4	Semi-conducting Compound (Borealis/Dow chemical/ Hanwa)	a) Packing	Minor	Visual	100%	MPS	MPS	-	P	V	-	
		b) Volume Resistivity	Major	Electrical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		c) Tensile Strength	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		d) Elongation at break	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		e) Cure Curve (Max. Torque)	Major	Physical	Sample	MPS	MPS	Reg./Sheet	-	P	V	
		f) Density	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
5	Copper tape	a) Thickness & width	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		b) Tensile Strength	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		c) Elongation at break	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		d) Resistivity	Major	Electrical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
6.	Armour wires/strips (Galvanised steel)	a) Dimensions	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		b) Surface condition/finish	Major	Visual	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		c) Tensile Strength	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		d) Elongation at break	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		e) Torsion test for round wire	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		f) Wrapping test	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		g) Mass of zinc coating	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		h) Uniformity of zinc coating	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		i) Adhesion test	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		j) Resistivity test	Major	Electrical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
7	Water Swellable	a) Dimensions	Minor	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	

BSES

QUALITY ASSURANCE PLAN (QAP)
FOR 66 kV EHV CABLES

S. NO.	COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			Remark
									SV	MFR	BSES	
1	2	3	4	5	6	7	8	9	10	11	12	13
	Legend : SV : Sub-Vendor of Cable Manufacturer, MFR : Cable Manufacturer, MPS : Material Purchase Specification,											
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	tape	b) Swelling height	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		c) Resistivity	Major	Electrical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
		d) Weight	Major	Physical	Sample	MPS	MPS	Reg./Sheet	P	P/V	V	
8	Steel Drum	a) Dimension	Major	Meas.	1 sample per size	IS 10418 / Purchase order		-	P	P	-	
		b) Finish & workman ship	Minor	Visual	1 sample per size	Compliance to standard Engineering norms & free from surface defects		-	P	P	-	
9	Binder tape	a) Dimensions & material	Minor	Physical	Sample	MPS	MPS	-	P	P	-	
10	Polypropylene filler	a) Size	Minor	Physical	Sample	Purchase order	Purchase order	-	P	P	-	
11	Heat shrinkable end cap	a) Bore diameter	Major	Physical	1 sample per size	--	--	-	-	P	-	
		b) Length of end cap	Minor	Physical	1 sample per size	--	--	-	-	P	-	
B	**PROCESS INSPECTION**											
1	Wire Drawing	a) Diameter	Major	Physical	Sample			Reg./Sheet	-	P	V	
		b) Surface finish	Major	Visual	100 %	Smooth & free from defects		--	-	P	-	
		c) Tensile test (for Al)	Major	Physical	Sample	IS: 8130/84	IS: 8130/84	Reg./Sheet	-	P	V	
		d) Elongation test (for Cu)	Major	Physical	Sample	IS: 8130/84	IS: 8130/84	Reg./Sheet	-	-	V	
		e) Wrapping test (for Al)	Major	Physical	Sample	IS: 8130/84	IS: 8130/84	Reg./Sheet	-	P	V	
2	Stranding	a) No. of wires/strands	Major	Physical	At the time of m/c setting			Reg./Sheet	-	P	V	
		b) Lay length & Lay direction	Major	Physical	-do-			-	-	P	V	
		c) Dia of conductor	Major	Physical	During setting & once in each shift			Reg./Sheet	-	P	V	
		d) Surface finish	Major	Visual	100 %	No surface defects and free from sharp edges, scratches, grease, oil etc.		-	-	P	-	
3	Core extrusion (Conductor screen, Insulation & insulation screen)	a) Compound Make/Grade	Major	Visual	During m/c setting			-	-	P	-	Insulation screen shall be freely strippable, without application of heat.
		b) Thickness of insulation & extruded S.C. layers	Major	Physical	During m/c setting after stabilisation	Tech. Data Sheet / IS 7098/III	Tech. Data Sheet / IS 7098/III	Reg./Sheet	-	P	V	
		c) Surface finish	Minor	Visual	100 %	Smooth & free from defects		-	-	P	-	
		d) Printing on outer semi- conducting layer	Major	Visual	100 %	"DO NOT HEAT, FREELY STRIPPABLE"		-	-	P	-	
		e) Tensile Strength	Major	Physical	Sample	IS 7098/III	IS 7098/III	Reg./Sheet	-	P	V	
		f) Elongation at break	Major	Physical	Sample	IS 7098/III	IS 7098/III	Reg./Sheet	-	P	V	
		g) Hot set test	Major	Physical	Sample	IS 7098/III	IS 7098/III	Reg./Sheet	-	P	V	
		g1) Ovality of core	Minor	Physical	Sample	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	

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		h) Eccentricity of insulation	Minor	Physical	Sample	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	
		i) Core diameter	Minor	Physical	Sample	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	
		j) Void & contamination test for insulation (Silicon Oil test)	Major	Physical	Sample			-	-	P	V	
		k) Wafer boil test for extruded semi-conducting layers	Major	Physical	1 sample/lot	BIS draft Specn	BIS draft Specn	Reg./Sheet	-	P	V	
4	Taping - water Swellable semi-conducting	a) Dimensions	Minor	Physical	Sample	Tech. Data Sheet	Tech. Data Sheet	-	-	P	-	
		b) Tape Application (Overlap)	Minor	Visual	During m/c setting	Suitable overlap	Suitable overlap	-	-	P	-	
5	Taping - Copper tape	a) Width & Thickness of tape	Major	Physical	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	
		b) Number of tapes	Major	Visual	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	
		c) Tape application (Overlap)	Minor	Visual	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	-	-	P	-	
6	Laying up	a) Identification of cores	Major	Visual	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	-	-	P	-	Cores shall be laidup with PP fillers & suitable tape binder shall be provided over laid up assembly
		b) Direction of lay, core Sequence & Lay length	Major	Visual	During m/c setting	IS 7098/III, PIL- W-02	IS 7098/III, PIL- W-02	-	-	P	-	
		c) Application of binder tape	Minor	Visual	During m/c setting	Tech. Data Sheet		-	-	P	-	
		d) Shape of laid up assembly	Minor	Visual	100%	Reasonably circular	Reasonably circular	-	-	P	-	
7	Inner sheath	a) Material & type	Major	Visual	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	-	-	P	-	
		b) Thickness	Major	Physical	During m/c setting & drum change	Tech. Data Sheet & IS 7098/III	ech. Data Sheet & IS 7098/III	Reg./Sheet	-	P	V	
		c) Surface finish	Minor	Visual	100 %	Surface shall be smooth & free from defects		-	-	P	-	
		d) Colour of inner sheath	Major	Visual	100 %	Tech. Data Sheet	Tech. Data Sheet	-	-	P	-	
8	Armouring	a) Dimension of armour wires/strips	Major	Physical	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	No negative tol. on strip thickness/wire diameter
		b) No. of armour strip/wire	Major	Counting	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	
		c) Armour coverage	Minor	Visual	During m/c setting	IS 7098/III	IS 7098/III	-	-	P	-	
		d) Direction of lay	Major	Visual	During m/c setting	IS 7098/III	IS 7098/III	-	-	P	-	
		e) Lay length/Gear setting	Minor	Visual	During m/c setting			-	-	P	-	
		f) Surface finish	Major	Visual	100 %	No cross over/over riding of wire/strip		-	-	P		
9	Outer sheath/Rewinding	a) Material & type	Major	Visual	During m/c setting	Tech. Data Sheet	Tech. Data Sheet	-	-	P	-	
		b) Anti rodent & termite additives	Major	Visual	Each loading			Reg./Sheet	-	P	V	

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		b) Thickness	Major	Physical	Each length	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	
		c) Overall diameter	Major	Physical	Each length	Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	V	
		d) Surface finish & colour of sheath	Major	Visual	100 %	Surface smooth & free from defects. Colour as per Tech. Data Sheet		-	-	P	-	
		e) Cable length verification	Major	Visual	Each length	Manufacturing Plan	Manufacturing Plan	-	-	P	-	
		f) Marking	Major	Visual	Each length	As per approved GTP/cross sectiona drawing		Reg./Sheet	-	P	V	
C	**FINAL INSPECTION**											
1	Routine tests	a) High Voltage	Critical	Electrical	100 %	IS 7098/III	IS 7098/III	Test Report	-	P	V	
		b) Conductor Resistance	Critical	Electrical	100 %	IS 8130/84	IS 8130/84	Test Report	-	P	V	
		c) Partial Discharge	Critical	Electrical	100 %	IS 7098/III	IS 7098/III	Test Report	-	P	V	
		d) Impulse	Critical	Electrical	One sample per lot			Test Report		P	V	
		e) Armour Coverage	Critical	Physical	One sample per lot			Test Report		P	V	
		f) Physiacal Dimensions	Critical	Physical	One sample per lot			Test Report		P	V	
		g) Freely Strippable insulation screen (Strippability Test)	Major	Physical	One sample per lot	Factory Standard	Factory Standard	Test Report	-	P	V	
2	Stage Inspection	Wire Drawing	Major	Visual	100 %	Tech. Data Sheet	IS/IEC	Test Report	-	P	W	Stage Inspection shall be conducted subject to BSES requirement
		Extrusion process	Major	Visual	100 %	Tech. Data Sheet	IS/IEC	Test Report	-	P	W	
		Raw maerial inspection at factory	Major	Physical	100 %	Tech. Data Sheet	IS/IEC	Test Report	-	P	W	
		Wrapping of Aluminium	Major	Physical	100 %	Tech. Data Sheet	IS/IEC	Test Report	-	P	W	
		Tensile test for Aluminium	Major	Physical	100 %	Tech. Data Sheet	IS/IEC	Test Report	-	P	W	
		a) Annealing test for copper	Major	Physical	Appendix A to IS 7098/III, each lot sample basis	IS 8130/84	IS 8130/84	-	-	P	V	Verification of process records.
		b) Tensile test for aluminium	Major	Physical		IS 8130/84	IS 8130/84	-	-	P	V	
		c) Wrapping test for aluminium	Major	Physical		IS 8130/84	IS 8130/84	-	-	P	V	Tests N/A on finished conductor.
		d) Conductor resistance test	Major	Electrical	Appendix A to IS 7098/III, each lot sample basis	IS 8130/84	IS 8130/84	Test Report	-	P	W	
		e) Test for thickness of insulation & sheath	Major	Physical		IS 7098/III & Tech. Data sheet	IS 7098/III & Tech. Data sheet	Test Report	-	P	W	
		f) Hot set test for insulation	Major	Physical		IS 7098/III	IS 7098/III	Test Report	-	P	W	

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3	Acceptance tests	g) Tensile strength & Elongation at break of insulation & outer sheath	Major	Physical	Each Lot Sample Basis	IS 7098/III & IS 5831/84	IS 7098/III & IS 5831/84	Test Report	-	P	W	
		h) Partial discharge test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		i) High voltage test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		j) Insulation resistance (Volume resistivity) test	Major	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		k) Tests for dimension of armour wires/strips	Major	Physical		IS 3975, IS 10810 Pt. 36 & Tech. Data sheet		Test Report	-	P	W	
		l) Test for anti termite & anti rodent property of outer sheath	Major	Physical		Tech. Data Sheet	Tech. Data Sheet	Reg./Sheet	-	P	W	
		m) Rewinding of cable on drum	Major	Visual		To check cable appearance, drum appearance, cable winding, packing, embossing/printing/sequential marking		Reg./Sheet	-	P	W	
		n) Void & contamination test for insulation (Silicon Oil test)	Major	Physical				Reg./Sheet	-	P	W	
		o) Wafer boil test for extruded semi-conducting layers	Major	Physical				Reg./Sheet	-	P	W	
		p) Freely Strippable insulation screen	Major	Physical		Factory Standard	Factory Standard	Test Report	-	P	W	
		q) Water Penetration test (WPT) on core (i.e.Logitudinal Water Blocking Test)	Major	Physical		IEC:60502	IEC:60502	Test Report	-	P	W	**Test shall be conducted for leakage of water through conductor.**
		r) Armour coverage	Major	Physical		As per data sheet & FS	As per data sheet & FS	Test Report	-	P	W	
		s) Ovality	Major	Physical		As per data sheet	As per data sheet	Test Report	-	P	W	
		t) Eccentricity	Major	Physical		As per data sheet	As per data sheet	Test Report	-	P	W	
		u) Mass & uniformity & zinc coating on armour	Major	Physical		As per data sheet & FS	As per data sheet & FS	Test Report	-	P	W	
		v) Resistivity of Strip armour	Major	Electrical		As per data sheet & FS	As per data sheet & FS	Test Report	-	P	W	
		w) Swelling height of water swellable tape	Major	Physical		As per data sheet & FS	As per data sheet & FS	Test Report	-	P	W	
		x) Flammability test	Major	Physical		As per IS-78098/II/2011	As per IS-78098/II/2011	Test Report	-	P	W	
		y)Impulse withstand test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	

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									SV	MFR	BSES	
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		z) Ageing & Water absorption test(Gravimetric) on Insulation & Outer sheath	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	
		z1) Heating Cycle with Potential	Critical	Electrical	sample basis, once per PO			Test Report	-	P	W	
		z2) Raw Material Verification in all aspects	Major	Physical	Each Lot					P	W	
4	Type tests at vendor's works	a) Tests on conductor										
		i) Annealing test for copper	Major	Physical		IS 8130/84	IS 8130/84	-	-	P	V	Verification of process records. Tests N/A on finished conductor.
		ii) Tensile test for aluminium	Major	Physical		IS 8130/84	IS 8130/84	-	-	P	V	
		iii) Wrapping test for aluminium	Major	Physical		IS 8130/84	IS 8130/84	-	-	P	V	
		iv) Conductor resistance test	Major	Electrical		IS 8130/84	IS 8130/84	Test Report	-	P	V	
		b) Tests for armouring wires/strips										
		i) Dimensions of wire/strip	Major	Physical		IS 3975, IS 10810 Pt. 36 & Tech. Data sheet		Test Report	-	P	W	
		ii) Tensile strength & Elongation at break	Major	Physical		IS 3975	IS 3975	Test Report	-	P	W	Only for Steel wires/strips
		iii) Torsion test for wire	Major	Physical		IS 3975	IS 3975	Test Report	-	P	W	
		iv) Winding test for strip	Major	Physical		IS 3975	IS 3975	Test Report	-	P	W	
		v) Uniformity of zinc coating	Major	Chemical		IS 3975	IS 3975	Test Report	-	P	W	
		vi) Mass of zinc coating	Major	Chemical		IS 3975	IS 3975	Test Report	-	P	W	
		vii) Resistivity of wire/strip	Major	Electrical		IS 3975	IS 3975	Test Report	-	P	W	
		c) Test for thickness of insulation & sheath	Major	Physical		IS 7098/III & Tech. Data sheet	IS 7098/III & Tech. Data sheet	Test Report	-	P	W	
		d) Physical tests for insulation									W	
		i) Tensile strength & Elongation test	Major	Physical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		ii) Ageing in air oven	Major	Physical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		iii) Hot set test	Major	Physical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		iv) Shrinkage test	Major	Physical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		v) Water absorption (gravimetric)	Major	Physical	One sample per Tender	IS 7098/III	IS 7098/III	Test Report	-	P	W	
		e) Physical tests for outer sheath									W	
		i) Tensile strength & Elongation test at break	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	
		ii) Ageing in air oven	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	
		iii) Shrinkage test	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	

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		iv) Hot deformation test	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	
		v) Loss of mass in air oven	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	
		v) Heat shock test	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	
		vi) Thermal stability test	Major	Physical		IS 5831/84	IS 5831/84	Test Report	-	P	W	
		f) Electrical tests in sequence									W	
		i) Partial discharge test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		ii) Bending test	Major	Physical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		iii) Partial discharge test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		iv) Dielectric power factor as a function of voltage	Major	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		v) Dielectric power factor as a function of temperature	Major	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		vi) Heating cycle test	Major	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		vii) Dielectric power factor as a function of voltage	Major	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		viii) Partial discharge test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		ix) Impulse withstand test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		x) High voltage test	Critical	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		g) Insulation resistance (Volume resistivity test)	Major	Electrical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
		h) Flammability test	Major	Physical		IS 7098/III	IS 7098/III	Test Report	-	P	W	
D	**PACKING & MARKING**											
1	Packing & Marking	a) Cable end sealing	Major	Visual	100 %	IS 7098/III/ Agreement	IS 7098/III/ Agreement	-	-	P	W/V	BSES representative may verify these characteristics on randomly selected drums.
		b) Pulling eye at leading end- removed from vendor scope, end cap shall be provided at both the end of cable	Major	Visual	100 %	As per agreement	As per agreement	-	-	P	W/V	
		b) Stencilling/Marking on drum	Minor	Visual	100 %	IS 7098(Part 2):2011/ Agreement	IS 7098(Part 2):2011/ Agreement	-	-	P	V	

QUALITY ASSURANCE PLAN (QAP)
FOR 66 kV EHV CABLES

S. NO.	COMPONENT & OPERATION	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			Remark
									SV	MFR	BSES	
1	2	3	4	5	6	7	8	9	10	11	12	13
	Legend : SV : Sub-Vendor of Cable Manufacturer, MFR : Cable Manufacturer, MPS : Material Purchase Specification,											
	P : Perform, W : Witness, V : Verification											

Note

1. Checks specified above for Raw Material, In-Process and Final Inspection shall be as relevant to the specific cable construction.
2. Number of samples shall be selected as per Factory Standard/Agreement wherever 'sample' is indicated for extent of check.
3. Plant standards shall be followed in case Technical Data Sheet does not include requirements for characteristics to be checked.
4. BSES may witness Raw material and in process inspection in addition to Routine/Acceptance tests at any time/stage of manufacturing.
5. BSES's Inspector may randomly select a cable drum for type testing at vendor's works.
6. For each of the offered lot for inspection, BSES may randomly select one cable drum for testing of end cap "Destructive testing" to verify adhesion of sealing cap to cable outer sheath. .
7. All factory Type Tests shall be Witnessed by BSES

Annexure- G

Testing and manufacturing process requirements w. r. t. TR- XLPE insulation

All cables made with TR-XLPE Insulation should be tested and/or certified to meet the following performance parameters as per ANSI /ICEA S-94-649 after one year AWTT.

Property	Units	Requirements Values
Min. Avg. Electrical Breakdown Strength(qual. test)	kV/mm	≥ 25
Impulse Strength	kV/mm	≥ 83
Water Tree Length	Mm	0.25
Max. Bowtie Tree Density	(Number per 16.4 cu. cm)	Maximum 15 (0.12-0.25 mm range)

Manufacturing processes to produce high-quality cables with the following characteristics:

- Cure consistency with hot set/creep less than 100%
- No voids larger than 75 microns per 16.4 cubic cm
- No ambers larger than 250 microns per 16.4 cubic cm
- No contaminants larger than 125 microns and less than 5 between 50-125 microns per cubic 16.4 cubic cm tested.
- Neutral indent on cable is less than 375 microns
- Cable insulation concentricity greater than 90% tested
- No protrusions greater than 75 microns at the conductor shield and 125 microns at the insulation shield

Annexure-H: Deviation Format

Sl. No.	Document Name	Clause No.	Deviation	Reason	Merit to BSES