

**TECHNICAL SPECIFICATION FOR COMPOSITE PIN INSULATORS
FOR USE IN 33 KV SYSTEM****1.0 SCOPE::**

This specification covers design, manufacture, testing and supply of composite Insulators for use in the 33 KV overhead transmission lines and substations. The composite Insulators shall be of the following type:

2.0 APPLICABLE STANDARDS::**2.1 Standards:-**

Following Indian/International Standards, which shall mean latest revision, with amendments/changes adopted and published, unless specifically stated otherwise in the Specification, shall be referred while accessing conformity of Insulators with these specifications.

2.1.1 In the event of supply of Insulators conforming to standards other than specified, the Bidders shall confirm in his bid that these standards are equivalent or better to those specified. In case of award, salient features of comparison between the standards proposed by the Bidder and those specified in this document will be provided by the Supplier to establish equivalence.

SNo.	Indian Standard Standard	Title	International Standard
1		Definition, test methods and acceptance criteria for composite Insulators for A.C. overhead lines above 1000V.	IEC:61109
2	IS:2071	Methods of High Voltage Testing.	IEC:60060-1
3	IS:2486	Specification for Insulator fittings for overhead power lines with a nominal voltage greater than 1000V General Requirements and Tests Dimensional Requirements locking devices.	IEC:60120 IEC:60374
4		Thermal Mechanical performance test and mechanical performance test on string Insulators units	IEC:60575
5		Characteristics of string Insulator unit of the long rod type.	IEC:60433
6		Hydrophobicity Clarification Guide.	STR I guide 1.92/1
7		Radio interference characteristics of overhead power lines and high voltage equipment.	CISPR118-2 Part 2
8	IS:8263	Methods of RITest of HV Insulators	IEC:60437
9		Standard for Insulators-Composite-Distribution Dead-end type.	ANSI-C29.132- 2000
10	IS:4759	Hot dip zinc coatings on structural steel & other allied products.	ISO:1459
11	IS:2629	Recommended practice for Hot Dip galvanization for iron and steel	ISO:1461(E)
12	IS:6745	Determination of weight of zinc coating on zinc coated Iron and steel articles.	ISO:1460
13	IS:3203	Methods of testing of local thickness of electroplated coatings.	ISO:2178
14	IS:2633	Testing of Uniformity of coating of zinc coated articles.	
15		Standard specification for glass fiber standards.	ASTM D 578-05
16		Standard specification for compositional analysis by Thermogravimetry.	ASTM D 578-05

17	IS:4699	Specification for refined secondary zinc	
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3.0 TECHNICAL DESCRIPTION OF COMPOSITE INSULATORS::

3.1 Composite Pin Insulators long rod type to support conductor for 33 KV overhead power lines :-

- 3.1.1 The Insulators shall be suitable for 3 Φ , 50 Hz, effectively earthed 33 KVO/H distribution system in a moderately polluted atmosphere.
- 3.1.2 Bidder must be an indigenous manufacturer and supplier of composite Insulators of rating 33kV or above OR must have developed proven in-house technology and manufacturing process for composite Insulators of above rating OR possess technical collaboration/association with a manufacturer of composite Insulators of rating 33kV or above. The Bidder shall furnish necessary evidence in support of the above along with the bid, which can be in the form of certification from the utilities concerned, or any other documents to the satisfaction of the owner.
- 3.1.3 Insulators shall have sheds with good self-cleaning properties. Insulator shed profile, spacing, projection etc, and selection in respect of polluted conditions shall be generally in accordance with the recommendation of IEC-60815/IS:13134.
- 3.1.4 The size of Composite insulator, minimum creepage distance and mechanical strength along with hardware fittings shall be as follows:

SN	Type of composite Insulator	Nominal system voltage kV(rms)	Highest system voltage kV (rms)	Visible discharge test voltage kV(rms)	Wet power frequency withstand voltage kV(rms)	Impulse withstand voltage kV(peak)	Minimum creepage distance (mm)	Min. failing load KN
1	33KV Pin Insulator	33	36	27	75	170	980	10

3.3 Dimensional Tolerance of Composite Insulators :-

The tolerances on all dimensions e.g. diameter, length and creepage distances shall be allowed as follows in line with IEC 61109:

$\pm \{0,04d + 1.5\}$ mm when $d < 300$ mm,

$\pm \{0.025d + 6\}$ mm when $d > 300$ mm.

Where, d being the dimensions in millimeters for diameter, length or creepage distance as the case may be,

However, no negative tolerances shall be applicable to creepage distance.

3.4 Interchangeably:-

The composite Insulators including the end fitting connections shall be of standard designs suitable for use with the hardware fittings of any make conforming to relevant IEC/IS standards.

3.5 Corona and RI Performance:-

All surfaces shall be clean, smooth, without cuts, abrasions or projections. No part shall be subjected to excessive localized pressure. The insulator and metal parts shall be so designed and manufactured that it shall avoid local corona formation and not generate any radio interference beyond specified limit under the operating conditions.

3.6 Maintenance:-

- 3.6.1 The composite Insulators offered shall be suitable for use of hot line maintenance techniques so that usual hot line operation can be carried out with ease, speed and safety.

4. BASIC FEATURES::

4.1 Design and construction:-

The composite Pin insulators shall have a core, housing & weather shed of insulating material and steel/aluminum alloy hardware components for attaching it to the support/conductor.

4.1.1 Core:-

It shall be a glass-fiber reinforced epoxy resin rod of high strength (FRP rod). Glass fibers and resin shall be optimized in the FRP rod. Glass fibers shall be Boron free electrically corrosion resistant (ECR) glass fiber or Boron free E-Glass and shall exhibit both high electrical integrity and high resistance to acid corrosion. The matrix of the FRP rod shall be Hydrolysis resistant. The FRP rod shall be manufactured through Pultrusion process. The FRP rod shall be void free. For 33 KV Insulator diameter of the FRP rod should be minimum **33.5 mm**.

4.1.2 **Housing (Sheath):-**

The FRP rod shall be covered by a seamless sheath of a silicone electrometric compound or silicone alloy compound of a thickness of 3mm minimum. It should protect the FRP rod against environmental influences, external pollution and humidity. It shall be extruded or directly molded on the core and shall have chemical bonding with the FRP rod. The strength of the bond shall be greater than the tearing strength of the polymer. Sheath material in the bulk as well as in the sealing/bonding shall be free from voids.

4.1.3 **Weathersheds:-**

The composite polymer weathersheds made of silicone electrometric compound or silicon alloy shall be firmly bonded to the sheath, vulcanized to the sheath or molded as part of the sheath and shall be free from imperfections. The weathershed should have silicon content of minimum 30% by weight. The strength of the weathershed to sheath interfaces shall be greater than the tearing strength of the polymer. The interface, if any, between sheds and sheath (housing) shall be free from voids.

4.1.4 **End Fittings:-**

End fittings transmit the mechanical load to the core. They shall be made of spheroidal graphite cast Iron, malleable cast iron or forged steel or aluminum alloy. They shall be connected to the rod by means of a controlled compression technique. The gap between fitting and sheath shall be sealed by a flexible silicone electrometric compound or silicone alloy compound sealant. System of attachment of end fitting to the rod shall provide superior sealing performance between housing, i.e. seamless sheath and metal connection. The sealing must be moisture proof. The details of end fittings for fixing the same with V cross arms and top clamps are given below:-

S. N.	Item	Length of Stud	Minimum threaded portion of Stud	Dia of Stud
1	33KV	150mm	100mm	24mm

Upper end fittings shall be suitable to hold Conductor for 33 KV. The size of the fittings shall be in such a way that conductor could be bound firmly so that it may not slip from the groove while in service even under the adverse condition.

5.0 WORKMANSHIP:

5.1 All the materials shall be of latest design and conform to the best engineering practices adopted in the high voltage field. Bidders shall offer only such Insulators as are guaranteed by them to be satisfactory and suitable for continued good service in power transmission lines.

5.2 The design, manufacturing process and material control at various stages shall be such as to give maximum working load, highest mobility, best resistance to corrosion, good finish and elimination of sharp edges and corners.

5.3 The design of the Insulators shall be such that stresses due to expansion and contraction in any part of the insulator shall not lead to deterioration.

5.4 The cores shall be sound and free of cracks and voids that may adversely affect the Insulators.

5.5 Weathersheds shall be uniform in quality. They shall be clean, sound, smooth and shall be free from defects and excessive flashing at parting lines.

5.6 End fittings shall be free from cracks, seams, shrinks, air holes and rough edges. End fittings should be effectively sealed to prevent moisture ingress; effectiveness of sealing system must be supported by test documents. All surfaces of the metal parts shall be perfectly smooth

with outprojecting points or irregularities, which may cause corona.

All load bearing surfaces shall be smooth and uniform so as to distribute the loading stresses uniformly.

- 5.7 All ferrous parts shall be hot dip galvanized to give a minimum average coating of zinc equivalent to 610 gm/Sq. m, or 87 μ m thickness and shall be in accordance with the requirement of IS: 4759, The zinc used for galvanizing shall be of purity 99.5% as per IS: 4699, The zinc coatings shall be uniform, adherent, smooth, reasonably bright continuous and free from imperfections such as flux, ash, rust, stains, bulky white deposits and blisters. The galvanized metal parts shall be guaranteed to withstand at least four successive dips each lasting for one minute duration under the standard pre-cetest. The galvanizing shall be carried out only after any machining.

6. EQUIPMENT MARKING::

- 6.1 Each insulator unit shall be legibly and indelibly marked with the following details as per IEC-61109:
- (a) Month & Year of manufacture
 - (b) Min. failing load/guaranteed mechanical strength in kilo Newton followed by the word 'KN' to facilitate easy identification.
 - (c) Manufacturer's name/Trademark

7. BIDDINGS::

- 7.1 The Bidders shall furnish full description and illustration of the material offered.
- 7.2 The Bidders shall furnish along with the bid the outlined drawing (3 copies) of insulator unit including across sectional view of the long rod insulator unit. The drawing shall include but not be limited to the following information:
- (a) Long rod diameter with manufacturing tolerances
 - (b) Minimum Creepage distance with positive tolerance
 - (c) Protected creepage distance
 - (d) Eccentricity of the long rod unit
 - (i) Axial runout
 - (ii) Radial runout
 - (e) Unit mechanical and electrical characteristics
 - (f) Weight of composite long rod unit.
 - (g) Materials
 - (i) Identification mark
 - (ii) Manufacturer's catalogue number
- 7.3 At the time of placement of award the suppliers shall submit three sets of full dimension manufacturing insulators drawings containing all the details to the Chief Engineer (MM)/SE (MM), PVVNL, Meerut.
- 7.4 At the time of placement of award the Suppliers shall also submit fully dimensioned insulator crated drawing for different type of Insulators for approval of the owner.

8. TESTS AND STANDARDS::

Insulators offered shall be manufactured with the same configuration & raw materials as used in the Insulators for which design & type test reports are submitted. The manufacturers shall submit a certificate for the same. The design & type test reports submitted shall not be more than 05 years old.

8.1 Design tests:-

For polymeric insulators, it is essential to carry out design tests as per Clause 4.1 of IEC-61109/92-93 with latest amendments. The design tests are intended to verify the suitability of the design, material and method of manufacture better technology. When a composite insulator is subjected to the design test the result shall be considered valid for the whole class of insulators, which are represented by the one tested and having the following characteristics:-

- Same material for the core and sheds and same manufacturing method.
- Same material for the fittings, the same design, the same method of attachment.
- Same or greater layer thickness of the shed material over the core (including a sheath where used)
- Same or smaller ratio of the highest system voltage to insulator length.

- Same or smaller ratio of all mechanical loads to the smallest core diameter between fittings.
- Same or greater diameter of the core.
- The tested composite insulators shall be identified by a drawing giving all the dimensions with the manufacturing tolerances
- Manufacturer should submit test report for design test as per IEC-61109 (Clause-5) along with the bid. Additionally following tests shall be carried out or reports for the tests shall be submitted after award of contract:- +UV test: The tests shall be carried out in line with clause 7.2 of ANSI C29.13

8.2 Type Tests:-

The tenderers shall furnish detailed type test report of the offered composite insulators as per Clause-8.2 of the technical specification at the CPRI/ERDA/NTH lab to prove that the composite insulators offered meet the requirements of the specifications. These type tests should have been carried out within 5 years prior to the date of opening of this tender. The following type tests shall be conducted on a suitable number of individual insulator units, components, materials or complete strings and the test reports should invariably be submitted with the bid:

SN	Description of type test	Test procedure/standard
1.	Dry lightning impulse withstand voltage test	As per IEC 61109 (clause 6.1)
2.	Wet power frequency test	As per IEC 61109 (clause 6.2)
3.	Mechanical load-time test	As per IEC 61109 (clause 6.4)
4.	Radio interference test	As per IEC 61109 (clause 6.4)
5.	Recovery of Hydrophobicity test	Annexure-A This test may be repeated every 3 yrs by the
6.	Chemical composition test for silicon content	Annexure-A Or any other test method acceptable to the owner
7.	Brittle fracture resistance test	Annexure-A

NOTE:- The purchaser may like to conduct any other test(s) in addition to above at bidder's cost to establish the performance of the material as per the system requirement.

8.3 It shall be the option of the owner to accept the Insulators based on type test report submitted by the manufacturer. The owner shall be free to repeat the type test & may witness the same.

Note: The owner, for the purpose of facilitating the type tests, may ask the bidders to quote test charges separately.

8.4 All the type tests given in Clause No. 8.2 in addition to routine & acceptance tests shall be carried out on insulator along with hardware fittings wherever required.

8.5 Acceptance (sample) Tests

8.5.1 For Composite Insulators

(a)	Verification of dimensions :	Clause 7.2 IEC:61109,
(b)	Verification of the locking system (if applicable) :	Clause 7.3 IEC:61109
(c)	Galvanizing test :	IS:2633/IS:6745
(d)	Verification of the specified mechanical load :	Clause 7.4 IEC:61109,
(e)	Verification of tightness of the interface between end fitting and silicon rubber.	Clause 7.4 IEC:61109, amendment 1 of 1995

8.5.2 Routine Tests:-

sn	Description	Standard
1	Identification of marking	As per IEC:61109 Clause 8.1
2	Visual Inspection	As per IEC 61109 Clause 8.2
3	Mechanical routine test	As per IEC:61109 Clause 8.3

8.6 Tests During Manufacture

Following tests shall also be carried out on all components as applicable

- Chemical analysis of zinc used for galvanizing
- Chemical analysis, mechanical, metallographic test and magnetic particle inspection for malleable castings.
- Chemical analysis, hardness tests and magnetic particle inspection for forgings.

8.6 Sample Batch for Type Testing

- 8.6.1 The bidder shall offer material for sample selection for type testing only after getting Quality Assurance Programme approved by the Owner. The bidder shall offer at least three times the quantity of materials required for conducting all the type tests for sample selection. The sample for type testing will be manufactured strictly in accordance with the Quality Assurance Programme approved by the Owner.

8.7 Additional Tests:-

- 8.7.1 The Owner reserves the right at his own expenses, for carrying out any other test(s) of reasonable nature carried out at Supplier's premises, at site, to in any other place in addition to the aforesaid type, acceptance and routine tests to satisfy himself that the material comply with the Specifications.
- 8.7.2 The Owner also reserves the right to conduct all the tests mentioned in this specification at his own expense on the samples drawn from the site at Supplier's premises or at any other test center. In case of evidence of non-compliance, it shall be binding on the part of the Supplier to prove the compliance of the item to the technical specifications by repeat tests or correction of deficiencies or replacement of defective items, all without any extra cost to the Owner.

8.8 Co-ordination for Testing:-

- 8.8.1 The Supplier shall have to co-ordinate testing of Insulators with hardware fittings to be supplied by other Supplier and shall have to guarantee overall satisfactory performance of the Insulators with the hardware fittings.

8.9 Quality assurance plan:-

- 8.9.1 The successful bidder shall submit following information to the owner:
- 8.9.1.1 Test certificates of the raw materials and bought out accessories.
- 8.9.1.2 Statement giving list of important raw materials, their grades along with names of sub-suppliers for raw materials, list of standards according to which the raw materials are tested. List of tests normally carried out on raw materials in presence of bidder's representative.
- 8.9.1.3 List of manufacturing facilities available.
- 8.9.1.4 Level of automation achieved and lists of areas where manual processing exists.
- 8.9.1.5 List of areas in manufacturing process, where stage inspections are normally carried out for quality control and details of such tests and inspections.
- 8.9.1.6 List of testing equipments available with the bidder for final testing of equipment along with valid calibration reports.
- 8.9.1.7 The manufacturer shall submit Manufacturing Quality Plan (MQP) for approval & the same shall be followed during manufacture and testing.
- 8.9.2 The successful bidder shall submit the routine test certificates of bought out raw materials / accessories and central excise passes for raw material at the time of inspection.

8.10 Guarantee:-

The Supplier of Insulators shall guarantee overall satisfactory performance of the Insulators for the period of 18 months from the date of supply.

INSPECTION::

The Owner's representatives shall at all times be entitled to have access to the works and all places of manufacture, where insulator, and its component parts shall be manufactured and the representatives shall have full facilities for unrestricted inspection of the Supplier's and sub-Supplier's works, raw materials, manufacture of the material and for conducting necessary tests as detailed herein.

The material for final inspections shall be offered by the Supplier only under packed condition. The Owner shall select samples at random from the packed lot for carrying out acceptance tests. The lot offered for inspection shall be homogeneous and shall contain Insulators manufactured in 3-4 consecutive weeks.

The Suppliers shall keep the Owner informed in advance of the time of starting and the progress of manufacture of material in their various stages so that arrangements could be made for inspection.

No material shall be dispatched from its point of manufacture before it has been satisfactorily inspected and tested unless the inspection is waived off by the owner in writing. In the later case also the material shall be dispatched only after satisfactory testing specified herein has been completed.

The acceptance of any quantity of material shall in no way relieve the Supplier of his responsibility for meeting all the requirements of the specification and shall not prevent subsequent rejection, if such materials are later found to be defective.

PACKING::

All Insulators shall be packed in strong corrugated box of min, 7ply duly palletted or wooden crates. The gross weight of the crates along with the material shall not normally exceed 100 Kg to avoid handling problem. The crates shall be suitable for outdoor storage under wet climate during rainy season.

The packing shall be of sufficient strength to withstand rough handling during transit, storage at site and subsequent handling in the field.

Suitable cushioning, protective padding, or dunnage or spacers shall be provided to prevent damage or deformation during transit and handling.

All packing cases shall be marked legibly and correctly so as to ensure safe arrival at their destination and to avoid the possibility of goods being lost or wrongly dispatched on account of faulty packing and faulty or illegible markings. Each wooden case/crate/corrugated box shall have all the markings stenciled on it in indelible ink.

The bidders shall provide instructions regarding handling and storage precautions to be taken at site.

Annexure-A (Tests on insulator units)

- 1 **RIVTEST(DRY):-**The insulator string along with complete hardware fittings shall have a radiointerference voltage level below 100 microvolts at one MHz when subjected to 50 Hz AC voltage of 10 kV & 30 KV for 11 kV & 33 KV class insulators respectively under dry condition. The test procedure shall be in accordance with IS: 8263 / IEC: 60437 / CISPRI 18-2.
- 2 **BRITTLE FRACTURE RESISTANCE TEST:-**
Brittle fracture tests shall be carried out on naked rod along with end fittings by applying "1N HNO₃ acid" (63 g cone, HNO₃ added to 937 g water) to the rod. The rod should be held at 80% of SML for the duration of the test. The rod should not fail within the 96 hour test duration. Test arrangements should ensure continuous wetting of the rod with Nitric acid.
- 3 **RECOVERY OF HYDROPHOBICITY & CORONA TEST:-**
The test shall be carried out on 4 mm thick samples of 5 cm x 7 cm:-
 - i) The surface of selected samples shall be cleaned with isopropyl alcohol. Allow the surface to dry and spray with water. Record the Hydrophobicity classification in line with STRI guide for Hydrophobicity classification. Dry the sample surface.
 - ii) The sample shall be subjected to mechanical stress by bending the sample over a ground electrode. Corona is continuously generated by applying required voltage to an needle like electrode placed 1 mm above the sample surface. The test shall be done for 100 hrs.
 - iii) Immediately after the corona treatment, spray the surface with water and record the HC classification. Dry the surface and repeat the corona treatment as at clause 7 above. Note HC classification. Repeat the cycle for 1000 hrs or until an HC of 6 or 7 is obtained. Dry the sample surface.
 - iv) Allow the sample to recover and repeat hydrophobicity measurement at several time intervals. Siliconerubbers should recover to HC1-HC2 within 24 to 48 hours, depending on the material and the intensity of the corona treatment.
- 4 **CHEMICAL COMPOSITION TEST FOR SILICON CONTENT**
The content of silicon in the composite polymer shall be evaluated by EDX (Energy Dispersion X-ray) Analysis or Thermo-gravimetric analysis. The test may be carried out at CPRI or any other NABL accredited laboratory.