		Document identity	Revision	
SPANDANA COPPER CONDUCTORS PVT. LTD.,		QSP/PQA/01	00	
Owner organization	SCCPL Article identity	Date of revision	Status	Page(s)
SCCPL		01.04.2009	Valid	1(3)
Department	Prepared by	Approved by	Security level	Language
PQA	Shekhar.S	Prashant.Y	External	English

METHOD OF LAPPING:

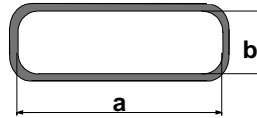
Specifications and standards

Dimensions, shape, electrical resistance, elongation at fracture	
Material designation	SCCPL/CU NOMEX

Description

Rectangular annealed copper wire. Wire dimensions must remain constant clean. Specification for copper. Wire is insulated with Nomex tape (SCCPL), or with POLYESTER-film and Mica/Nomex tape.

Figure 1: Dimension of conductor



Insulated copper conductors must be reeled on a suitable reel according to copper thickness. The standard reels are shown below. If the supplier wishes to use another type of reel, it has to be discussed and agreed with SCCPL..

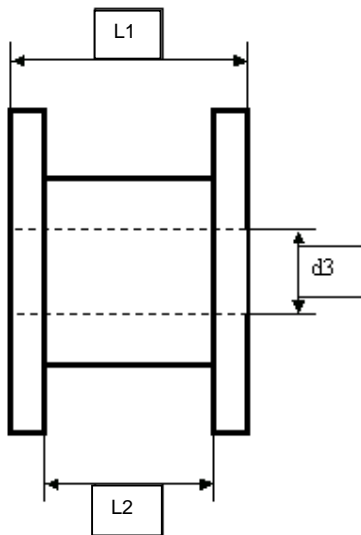


Figure 2: Reel from front

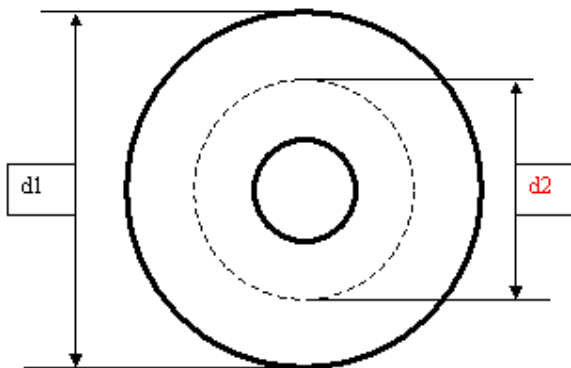


Figure 3: Reel from side


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Table 1: Requirements for insulation.

Designation	Number of insulation tape layers	% of Lapping		
		10%	30%	50%
SCCSP axb	1 x POLY/NOMEX (I) 1 x NOMEX (I)	0.20 +/-0.02	0.33+/- 0.02	0.40 +/-0.02
SCCDP axb	2 x NOMEX (I)	0.20 +/-0.02	0.33+/-0.02	0.40.+/-0.02
SCCTP axb	3 x NOMEX(I)	0.33 +/-0.03	0.40+/-0.03	0.40+/-0.03
SCCMP axb	4 x NOMEX(I)	0.40 +/-0.05	0.60 +/-0.05	0.80+/-0.05

Fig. 1
SCCSP.

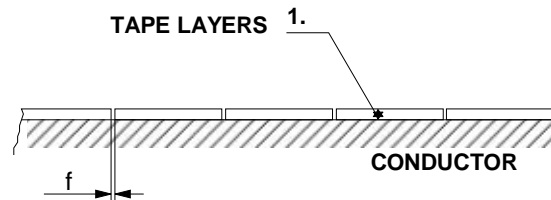


Fig. 2
SCCDP.

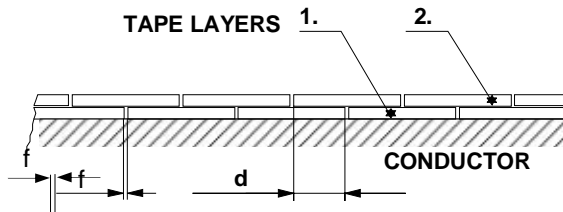
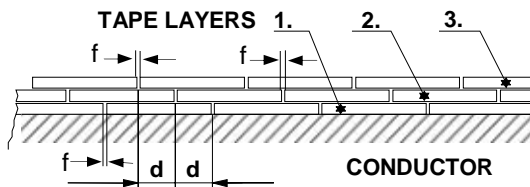

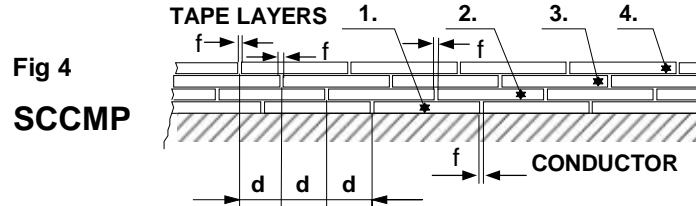


Fig 3
SCCTP



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Other quality requirements

- Splicing of copper wires is strictly forbidden.
- Taping should be tight, but should be done without stretching the film or damaging the mica layer.
- Taping must be wrinkle-free.

Splicing of insulation tape:

- Work must be done with clean hands.
- Tape ends are overlapped about 10 mm, the joint can be fixed using adhesive polyester tape with acrylic adhesive (e.g. Permacel P280, H-old P.34 or PPI 1042).
- The maximum width of the adhesive polyester tape is same as the width of the Nomex tape.
- The length of the adhesive polyester tape is about 30 ... 50 mm.
- The taping angle of the adhesive polyester tape is same as the taping angle of the mica tape.
- Splicing positions of the different mica tape layers should not be on top of each others to avoid thickening of the insulation.
- The result must be wrinkle-free.