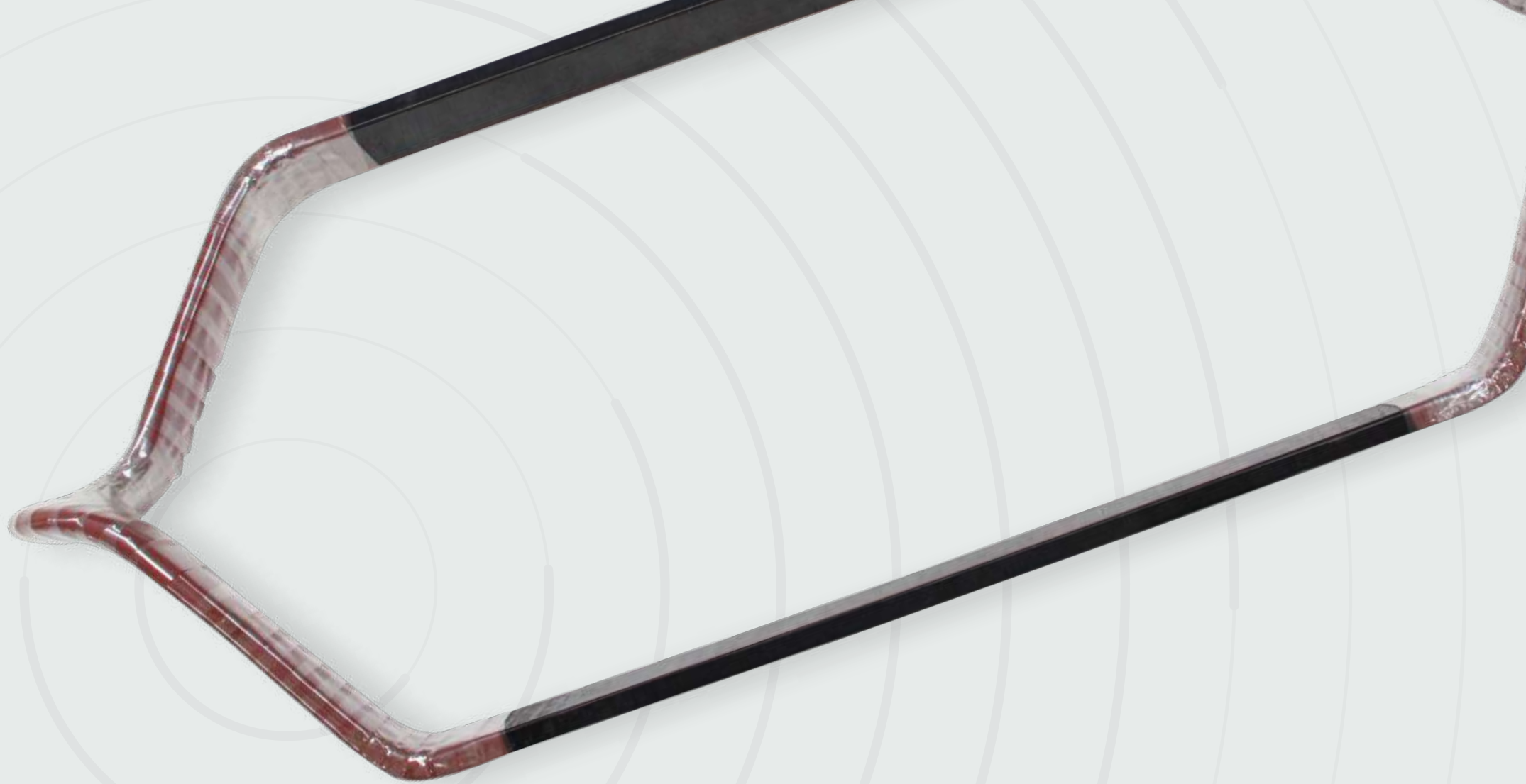




Project Overview & Specs

COUNTRY	MAKE	KW	VOLTS	AMPS	HZ	POLES	RPM	INS. CL
COSTA RICA	IMPSA	7185	13,800	280	60	14	514	F

Scope of Work

Manufacture and supply of 132 RR insulation coils with winding kits, all using Class F materials for 13.8kV operation.

Timeline: 50 days

Warranty: 12 Months



Testing & Process Precision

Final Testing on Individual Coil

- Dimensional Checking
- Inter-Element Test (220 V)
- Coil Resistance Measurement
- IR Value at 5000 V (before & after HV test – IEEE 43:2000)



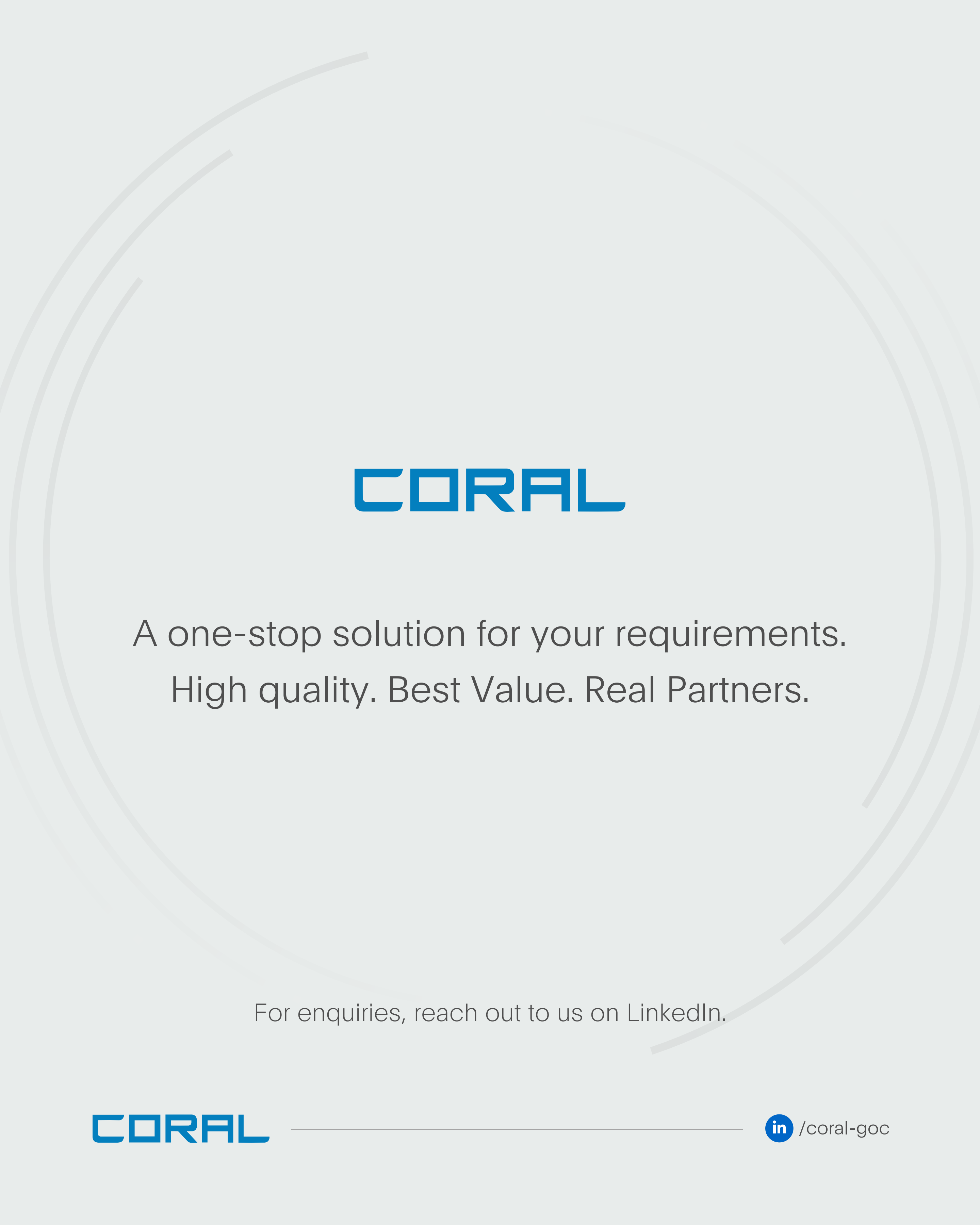
- AC HV Test at 35 kV for 1 min – IS 4722:1992 & IEC 60034-1:2009
- Surge Comparison Test at 21 kV – IEEE 522:2004
- HV/HF Interturn Test at 21 kV
- Tan Delta & Capacitance Measurement at 1.2× Rated Voltage (17kV)
- PD Test for 15% of coils at Phase Voltage



Critical Processes & Production Status

Process Criticality

- Turn insulation is applied to each of the five individual turns before combining them.
- Main-wall insulation is added only after full turn completion.
- Scrap joint observed in OH portion - hence, curing continued after the first bend to ensure quality integrity.



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