



SCOPE

1.00 These specifications cover the general material, and fabrication standards employed by Kencoil in the manufacture of ac stator coils operating at voltage ratings up to and including 7200 volts.

STANDARDS

2.00 All coils manufactured under these specifications are done so in accordance with the latest published IEEE and NEMA Standards unless otherwise specified.

MATERIALS

3.00 All materials are compatible and unless otherwise specified will be compatible with standard materials used in the industry. Materials meet or exceed class "F" temperature ratings.

4.00 Conductors used are high conductivity 100% virgin copper.

5.00 Conductor strand insulation shall be heavy or quad film covered wire with a polyester basecoat and a polyamideimide topcoat or fused single or double glass served over a heavy or quad film covered wire. Other supplemental turn insulation (if required), will consist of taped mica or polyimide film turn insulation.

5.01 Strand insulation choice is determined from any of the following factors:

- A. RMS volts between turns
- B. Available slot space
- C. Machine application

6.00 The end turn insulation shall consist of at least .0045" thick mica tape, typically ¾ lapped, with the minimum servings as indicated below:

| Voltage | No. of Servings |
|----------|-----------------|
| Thru 600 | 1 |
| 2300 | 1 |
| 4160 | 2 |
| 7200 | 4 |

7.00 The ground wall insulation shall be a mica tape or mica wrapper type insulation, or a combination of both, typically ½ lapped if taped and typically applied to the thickness between conductor and core as indicated below:

| Voltage | Thickness |
|----------|-----------|
| Thru 600 | .009" |
| 2300 | .027" |
| 4160 | .036" |
| 7200 | .054" |

8.00 The lead insulation for various voltages shall be as indicated below:

| Voltage | Type |
|-----------|---|
| Thru 4160 | Fiberglass braid over acrylic |
| 7200 | No less than 2 servings of ½ laps, .0045" mica, or .001" polyimide film under fiberglass braid over acrylic |

9.00 The outer protective armor tape consists of one serving, .005" thick polyester Dacron. Conductive paint is used for corona protection on the straight sections of stator coils operating above 5000 volts.

CONSTRUCTION

10.00 Coils are shuttle wound, hydraulically press molded to assure conductor alignment and varnish submerged, and oven cured.

11.00 The loops have the lead insulation wiped clean to bare copper; are spread to proper shape, and checked for uniformity.

12.00 Leads are taped and/or sleeved. The prescribed servings of ground-wall mica tape are applied by machine. If prescribed a single continuous sheet of mica material is wrapped around the full straight length of the slot sections.

13.00 A final armor tape is machine applied. The coils are totally submerged in varnish, lead end up, to a point just covering the insulation. Coils are fully baked in the oven to assure thorough drying of the varnish, yet maintain a degree of flexibility for ease of insertion. The straight sections of stator coils operating above 5000 volts are painted with anti-corona, conductive paint intended to equalize voltage stress between the core slot side and the coil thus preventing corona discharges from occurring.

TESTING

14.00 Prior to shipment a sample of coils must pass a dc ground test of twice normal operating voltage, plus 1000, times 1.7, for one minute. Coils must pass a ten second surge test (high frequency turn to turn insulation test) as follows:

| Strand Ins. | Applied Voltage |
|----------------------|-------------------------------------|
| Heavy Film | Turns per coil x 500 = test voltage |
| Quad Film | Turns per coil x 850 = test voltage |
| [Single glass over | add 200 volts/turn] |
| [Double glass over | add 400 volts/turn] |
| [Polyimide film over | add 300 volts/turn] |
| [Mica over | add 1,300 volts/turn] |

GUARANTEE

13.00 Kencoil, Inc. guarantees its manufactured products to be free of defective materials and workmanship. It further guarantees the coils will pass the standard hi-pot and surge tests after complete insertion and proper connections are made. This guarantee remains in effect for one year from date of our invoice. Exceptions will be taken should the end user, through neglect or abuse, allow the machine to become victim of faulty electrical, mechanical, or environmental circumstances.