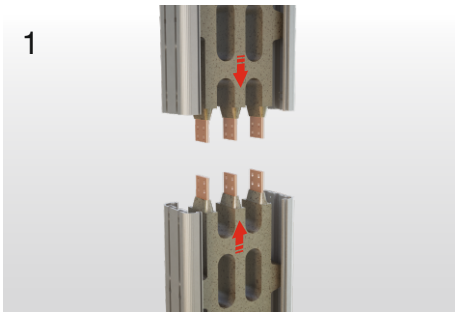


E-LINE MV Mounting Instructions - 24 kV

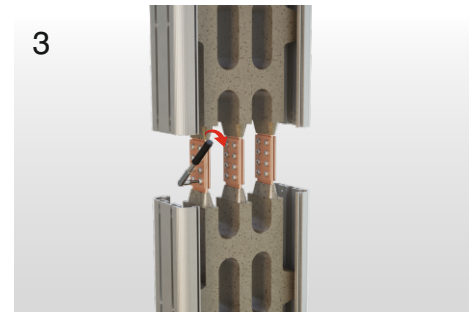
Vertical Application



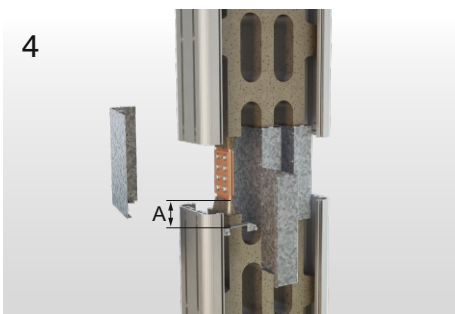
1 The ends of the conductors of the busbars are cleaned with a clean dry cloth. The busbars have to be fixed in the same axis, with a max. distance of 10 mm between the two conductors.



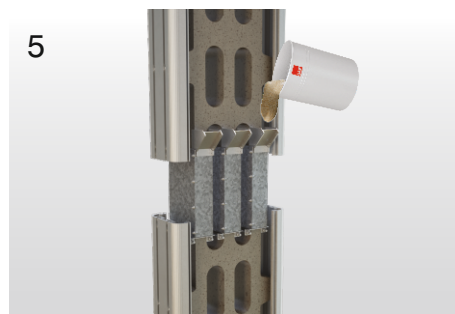
2 As shown on the figure, junction plates shall be fixed as the bolts face the same direction at all times.



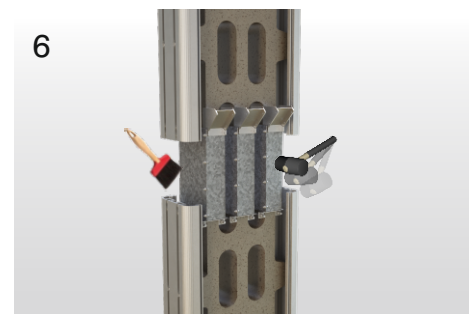
3 All bolts must be tightened to 72 Nm with torque wrench.



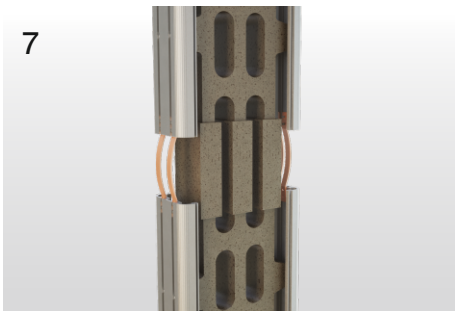
4 Support sheets are secured on the lower part of the juncture area by stem bar. A min. 50-60 mm. The joint moulds are affixed on the support sheet by cleaning with a dry and clean piece of cloth.



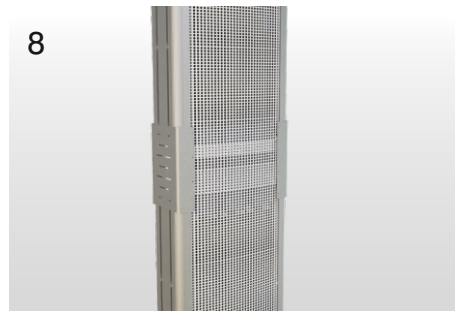
5 The prepared for casting should be cast from the same spot at all times.



6 The material should be 'vibrated' with the help of a plastic hammer to remove the air in the material. Then the air bubbles on the surface have to be brushed.



7 After the curing of the cast material is complete the sheet metal moulds can be removed. (Reaction is completed within 8 - 24 hours based on the air temperature.) The flexibles are fitted to the profiles grooves for earth continuity.



8 Joint protection pieces of perforated aluminium should be fitted.

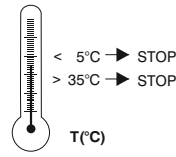
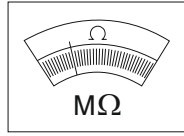
E-LINE MV Mounting Instructions - 24 kV

Resin Application

Megger test is definitely required to be conducted prior to the casting process.

Resin (A), Hardener (B) and fillers; must be stored at least one day over ($> 20^{\circ}\text{C}$).

Ambient temperature of job side must be $5^{\circ}\text{C} < T_{\text{amb}} < 40^{\circ}\text{C}$



Preparation of Cast Resin Mixture

Total mixture weight of 1 Bucket is 15 kg



1 Filler removed from the plastic bucket.

2 Resin and hardener are mixed in plastic bucket.

3 Resin and hardener are mixed in plastic bucket.

4 Mix resin and hardener thoroughly with stirrer at least 30-60 seconds.

5 Add fillers and mix until homogeneous; at least 2-3 minutes. Then application must be done within 15 minutes.

FILLER 350 mm

RESIN (A) 150 mm

HARDENER (B) 100 mm

15kg

When determining the material to be consumed for joint point, the installation of joint point weighing 15 kg and its multiples should be included in the work plan for the same day. Otherwise, since the remaining material will happen a curing reaction, it cannot be used in another day's work plan and will be scrapped. Material planning should be done taking this detail into consideration.

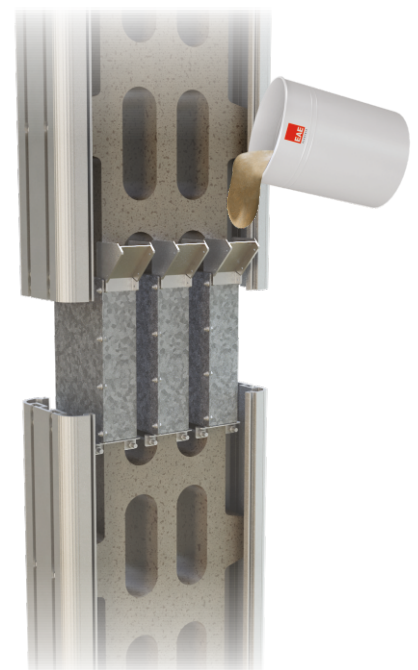
Resin Application

After the entire adjustments are made, megger test and dielectric test shall be conducted on the busbar system coupled and absence of any stray voltage shall be ensured accordingly. Material prepared in buckets shall be casted on juncture area. Material casting shall be ensured not to have any clearance at all. After the completion of casting process, the material shall be ensured to be placed tightly by slightly hammering the block joint moulds.

- After the block joint mould is filled up to the upper level, the surface is required to be levelled out with a brush.
- For the purpose of expediting the air outlet after the completion of the casting process, vibration rendering process shall be applied on the mold for 8-10 minutes by a plastic hammer.
- Casting surface shall be brushed once in every 10-15 minutes and air bubbles forming shall be removed and the surface shall be smoothed accordingly.

- To remove the block joint mould, it shall be waited for curing process of 8-24 hours and the complete stiffening to be completed.

In case of a requirement of more than 1 dose of application in the application of the juncture resin, it shall be performed successively without waiting for the application of the 2nd and the 3rd doses.



Note: Material for each joint shall be prepared separately and this prepared material shall be poured within 15 minutes.