

## 1. Purpose

Defines steps to be followed during the mounting of the transformers

## 2. Application

Valid for low voltage transformers

## 3. Define

### 3.1 Accesories of Transformers



12 pieces PT4 Screws  
and Plastic Taps

2 pieces Mounting Legs

2 pieces Bus Bar  
Mounting Metal Parts

Bu dokümanın her hakkı ALCE Elektrik A.Ş.'ne ait olup, saklıdır. Dokümanın yayınlanmasından sonra izinsiz çoğaltılması yasaktır. Bu doküman üzerinde Gerekliğinde ilgili kişi tarafından değişiklik yapılabilir.

Revizyon Ay/Yıl	İlk Yayın Tarihi <DOC_HAZ_TAR>	Revizyon Tarihi <REV_TARIHI>	Revizyon Nedeni : <REV_NEDEN>
	<b>HAZIRLAYAN</b> Aydın TOSUN	<b>KONTROL EDEN</b> Serkan VATANSEVER	<b>ONAY</b> Bora ÖZYILMAZ

Rev <REV\_NO>

Alce 749 R01

## 4. Method

### 4.1 Mounting of transformers to the busbar

Alce PT4 screw should be used for mounting . PT4 screws make a threads during tightening process. We advice an adjustable torque screwdriver for tightening the screws ( Picture 1).

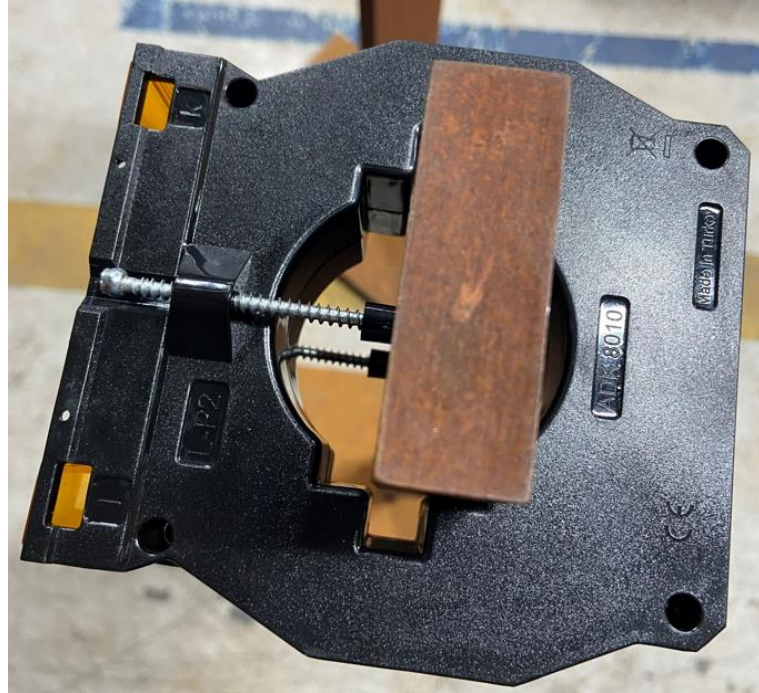
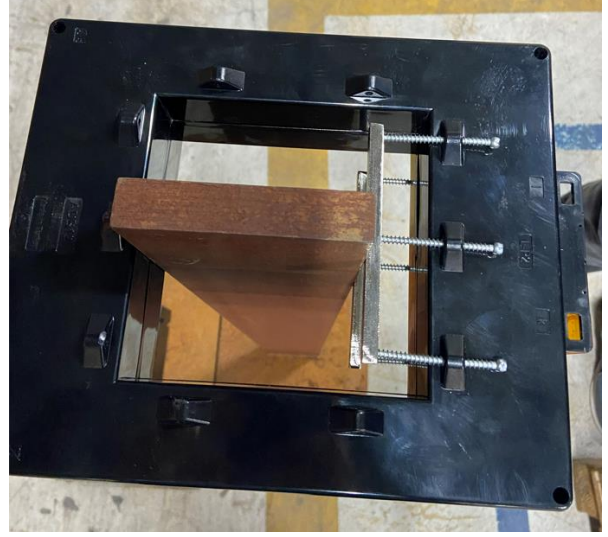


Picture 1

### 4.2 Torque value Table According Weight of Transformers and Number of Mounting

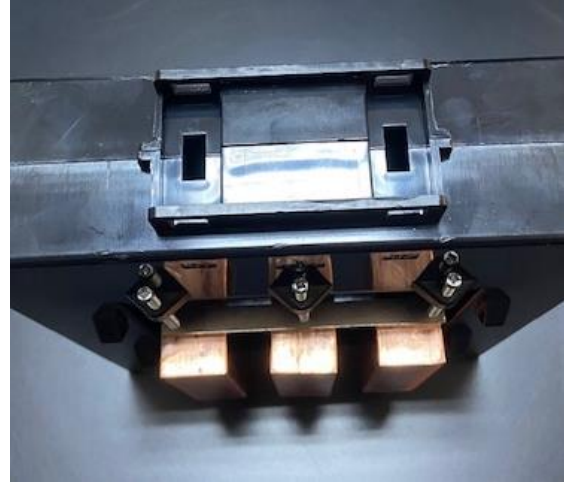
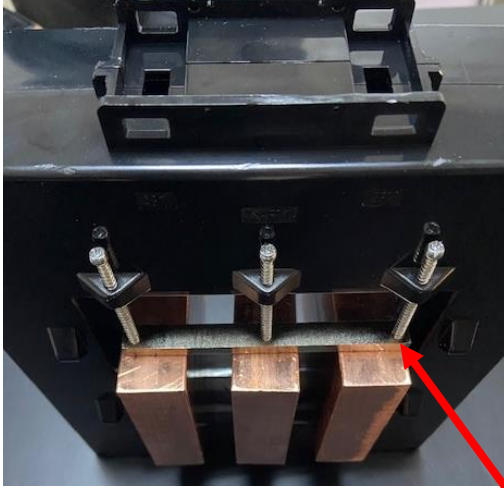
You can find recommended torque value for different kind of structure. This torque have to be maximum 1 Nm.

Weight Of Transformers	Number of Screw using for Mounting	Torque Value
Up to 2 kg	2	0,5 Nm
2 - 5 kg	4	0,5 Nm
More than 5 kg	4	0,7 Nm
	6	0,5 Nm



### 4.2 Mounting with metal parts

6 pieces PT4 Screws are mounted to the plastic. Metal parts put between busbar and PT4 screws. Tighting operations have to be in a certain order.



With these kind of mounting you should not use plastic Taps

First metal part



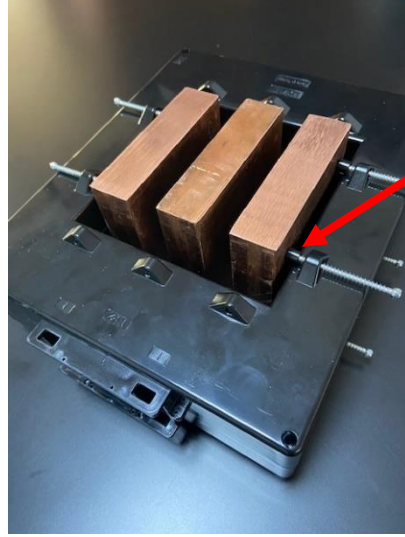
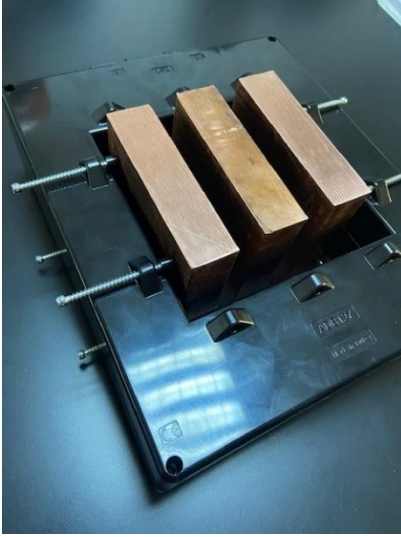
Second metal part



These blind holes for housing screws

### 4.3 Mounting without metal parts

8 pieces PT4 Screws are mounted to the plastic. After that plastic taps are fixed to the end point of PT4 Screws turned by hand 1-2 turns . Tighting operations have to be in a certain order.



Plastic Taps

### 4.4 Transformers mounting legs

If you can assembly transformers to the cabinet panel , you use plastic or metal legs accesories. We recommend to use these legs especially types heavier than 3 kg.



Şekil 3



Şekil 4

### 4.5 Acceptance Criteria

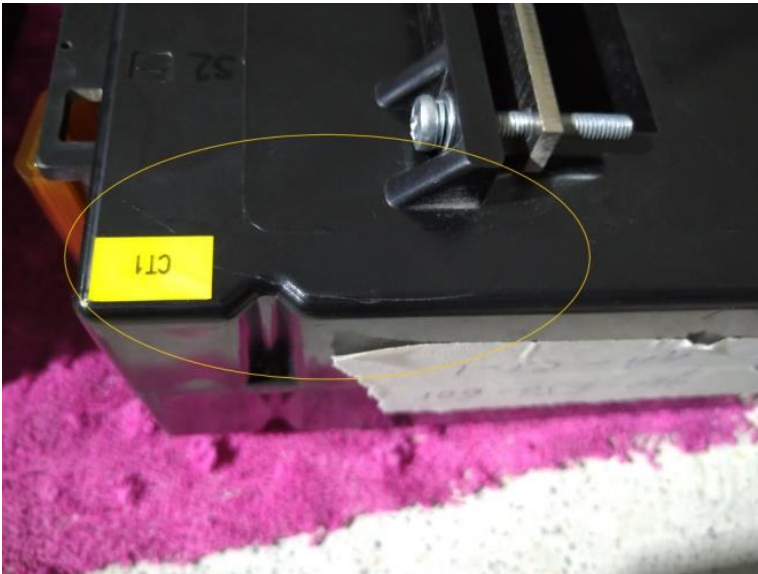
#### 4.5.1 Electrical Acceptance Criteria

All electrical tests according to IEC 61869-1-2-3 are performed by ALCE without any sampling with %100 pieces.

#### 4.5.1 Visual Acceptance Criteria

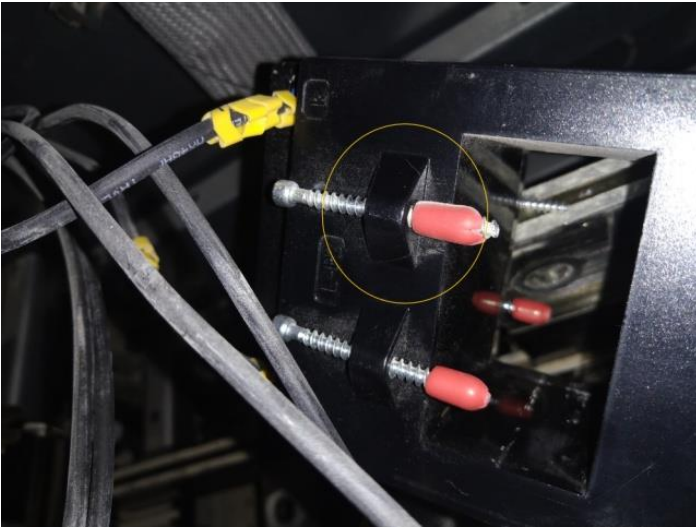
Visual controls are also performed by ALCE. In terms of missing control or physical damage during transportation, customer can focus below nonformities **before assembly**.

**Must not be accepted.**





**Must be accepted.**





### Technical explanation of this kind of traces:

- During filling of the mold with raw material, there must be some connection point of raw material (can be called by degassing points). These traces are not crack or scratches.
- Minor scratches must be also acceptable.