



### Angle Ring & Cap Rings

S.No.	Dimension	Standard
1	THICKNESS 'T'	2.0 – 5.0 mm
2	HEIGHT 'H'	Up to 200 mm
3	FLANGE 'F'	Up to 250mm
4	RADIUS 'R'	5 -25 mm
5	DIAMETER 'D'	500 – 3000 mm Shall be supplied in sectors
6	SCARFING	Up to 150 mm

1. Scarfing shall be done on each sector for thickness > 2.50mm
2. Larger dimensions can be supplied on specific request
3. For details about the number of sectors, scarfing length and tolerance please refer to tolerance sheet for moulded components.

### PROPERTIES OF PRESSBOARD MOULDINGS

Reference Grade & Standard	SIGMAMOULD 4.1 IEC 60641-3-1, B 4.1	SIGMAMOULD 5.1 IEC 60641-3-1, B 5.1
Color	Natural Light Brown	Natural Light Brown
<b>Physical Properties</b>		
Density, g/cc, range	0.85 – 1.05	0.75 – 0.90
Moisture content, %, max	8.0	8.0
Shrinkage MD, %, max	1.00	0.80
Shrinkage CD, %, max	1.40	1.20
Shrinkage PD, %, max	6.0	6.0
<b>Chemical Properties</b>		
Conductivity of aqueous extract, mS/m, max	8.0	7.0
pH of. Aqueous extract, range	6.0 - 9.0	6.0 - 9.0
Oil absorption, %, min	20.0	35.0
Ash content, %, max	1.0	0.50
<b>Electric Properties</b>		
Electric Strength Oil (kV/mm), min	20	20



## Standard Range of Moulded Components

<b>ANGLE RINGS</b>						
<b>NUMBER OF SECTORS</b>						
<b>FLANGE</b>						
Diameter (ID)	1-50 A	51 – 100 B	101 – 150 C	151 – 200 D	201 – 250 E	Height (Max)
250 < 350	4	4	4	4	4	60
351 < 450	4	4	4	4	4	100
451 < 700	4	4	4	4	4	150
701 < 900	4	4	4	4	4	200
901 < 1100	5	5	5	6	6	200
1101 < 1200	5	5	5	6	6	200
1201 < 1500	6	6	6	6	6	200
1501 < 1800	6	6	6	8	8	200
1801 < 2000	8	8	8	8	8	200
2001 < 2400	10	10	10	10	10	200

Diameters above 2400mm can be manufactured on request

<b>ANGLE CAP RING</b>	
<b>DIAMETER (OD)</b>	<b>SECTORS</b>
401 ≤ 1000	5
1001 ≤ 1450	6
1451 ≤ 1800	8
1801 ≤ 2400	10

Note: All dimensions in mm



## MOULDED COMPONENTS TOLERANCE SHEET

### ANGLE RING & CAP RING

S.No.	Dimension	Standard	Tolerance
1	RADIUS 'R'	5 mm	± 1.0 mm
		5 – 10 mm	± 2.0 mm
		10 – 15 mm	± 3.0 mm
		> 15 mm	± 4.0 mm
2	DIAMETER 'D'	250 – 800 mm	± 5.0 mm
		800 – 1200 mm	± 10.0 mm
		1200 - 2400	± 15.0 mm
3	THICKNESS 'T'	2.0 mm	± 0.50 mm
		3.0 – 5.0 mm	± 1.0 mm
4	HEIGHT 'H'	Up to 150mm, Above 150mm	± 3.0 mm ± 5.0 mm
5	FLANGE 'F'	Up to 150mm	± 3.0 mm
		Above 150mm	± 5.0 mm

For Angle Rings consider ID & for Angle Caps consider OD.

### SNOUTS

S.No.	Dimension	Standard	Tolerance
1	RADIUS 'R'	Standard tolerance	± 5.0 mm
		Special tolerance	± 2.0 mm
2	RING DIAMETER 'D'	250 – 800 mm	± 5.0 mm
		800 – 1200 mm	
		1200 - 2400	
3	THICKNESS 'T'	2.0 – 4.0 mm	± 1.0 mm
		5.0mm	± 1.50 mm
4	SNOUT TUBE	< 100 mm	± 2.0 mm
		> 100 mm	± 3.0 mm
5	WIDTH 'W'		± 3.0 mm
6	SNOUT ANGLE		± 3 Deg
7	TUBE HEIGHT 'H'		± 3.0 mm
8	HEIGHT 'H'	Up to 150mm	± 3.0 mm
9	FLANGE 'F'	Up to 150mm	± 3.0 mm



## DISC ANGLE AND CAP RINGS

S.No.	Dimension	Standard
1	THICKNESS 'T'	1.50 – 3.0 mm
2	HEIGHT 'H'	Up to 20 mm
3	FLANGE 'F'	Up to 35 mm
4	RADIUS 'R'	1.5 mm, max
5	DIAMETER 'D'	450 – 3000 mm Shall be supplied in sectors

## DISC ANGLE RING AND DISC ANGLE CAP TOLERANCES

S.No.	Dimension	Standard	Tolerance
1	THICKNESS 'T'	1.0 – 3.0 mm	± 10.0 %
2	HEIGHT 'H'	Up to 20 mm	± 3.0 mm
3	FLANGE 'F'	Up to 35 mm	+ 0, -10.0%
4	RADIUS 'R'	1.5 max.	
5	DIAMETER 'D'	450 – 3000 mm Shall be supplied in sectors	≤ 1000 mm - ±1.0 %
			> 1000 mm - ± 1.50 %
6	Std. Scarfing Length	45mm	± 10 mm