33 kV GAS INSULATED SWITCHGEAR
PANEL COUPLING PROCEDURE
Order of Installation
1. Draw cubicle reference line on the foundation frame. These reference lines will serve a guide for more accurate alignment of the cubicle.
2. Remove the transportation bolt on the top of the cubicle.
3. Locate the first panel onto the center position with the aid of a preferable hydraulic jack, making sure that its front base channel is aligned to the reference line. If the alignment is good, the four foundation bolts can be quite easily inserted into the framework holes.

Figure 1.1 - Connecting the Adjacent Panel

5. Apply Lubricant for Electrical Contacts (Preferred HBK 83-102) to the contact spring as shown in figure 1.1 A

6. Fix the Copper Rod into bushing as shown in figure 1.2 B

7. Now apply Silicone grease (FOMBLINGRM60) to silicone plug arrangement from inside as shown in figure 1.3 C

8. Fix the Silicone Plug to Bushing as shown in figure 1.4 D

9. Connect the Earthing Cord of bushiong as shown in figure 1.5 E
10. Place the 2nd panel at a distance of 150-170mm as shown in figure 1.6 F

11. Insert lead screw from front and rear side of panel as shown in figure 1.7 G
12. After Mounting lead screw, Use M18/M19 Ratchet spanner for operation of the lead screw simultaneously at front and rear end.

13. During coupling ensure that guiding pin, Bushings and Copper Busbar are engaging properly. Please refer figure 1.8 H – Top, Front and Bottom View for the same.

**Top view**

![Top view images]

**Front view**

![Front view images]

**Bottom view**

![Bottom view images]

*Figure 1.8 H*
14. Next using the interpanel coupling bolts, fasten the lowermost jointing portions. After arranging all cubicles in this way, fasten the remaining coupling bolts (with a fastening torque of 75 NM). Fasten the cubicle body to the bases.

15. Fix the 2 adjacent Panels from Top with Guiding Bush & End plate (supplied in loose) as shown in figure 1.9 I Coupling holes after assembly.

16. Tighten the M12 foundation bolts to the appropriate torque or tag welding should be done to base frame.

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