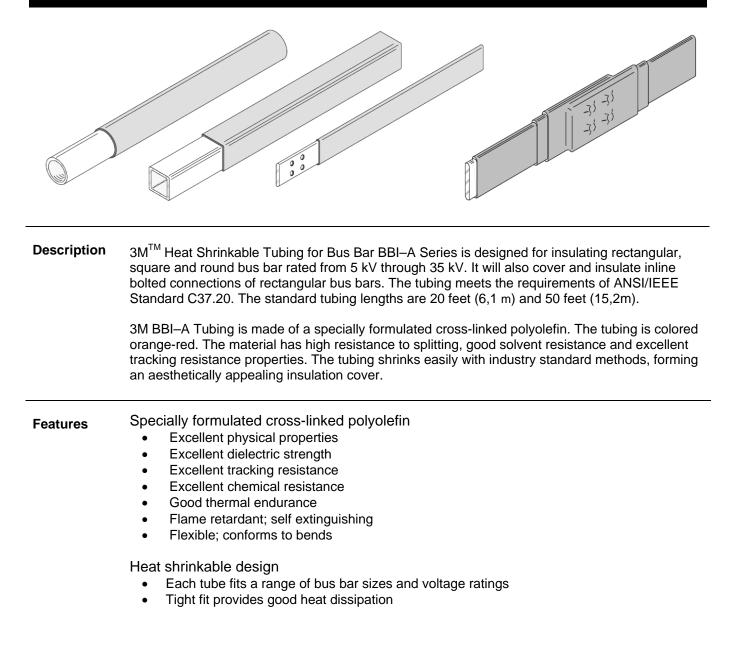
3M[™] Shrinkable Tubing for Bus Bar BBI-A Series 5-35kV

Data Sheet

September 2013



Applications	 For insulating electrical bus bars per ANSI/IEEE Standard C37.20: For 5, 8, 15, 25 and 35 kV voltage ratings For rectangular, square and round bus bars For inline bolted connections of rectangular bus bars For copper or aluminum bus bars For use in metal-clad switchgear For use on metal-enclosed bus bar For use with substation switchgear
Engineering/ Architectural Specifications	All straight sections of bus bar, and inline connections of rectangular bus bars, shall be insulated in accordance with the instructions included with the 3M Heat Shrinkable Tubing for Bus Bar BBI–A Series. This coverage shall include all copper and aluminum, rectangular, square and round bus bar's rated at 5, 8, 15, 25 and 35 kV.
Product Specifications	All straight sections of bus bar shall be insulated with 110°C (230°F) rated heat shrink tubing which meets the requirements of ANSI/IEEE C37.20. The tubing shall be made of specially formulated, cross-linked polyolefin, orange-red in color. The tubing shall be rated for the same voltage-rating as the bus bar, up to 35 kV. The insulation shall be designed for use on rectangular, square and round bus bars, and it must be designed to cover and insulate inline bolted connections of rectangular bus bars. The product must be packaged with complete installation instructions.
Performance Tests	 Dielectric Withstand Tests (ANSI/IEEE C37.20): Tests were performed on BBI Series Tubing installed on rectangular bus bar, on both straight sections and inline bolted connections. The 2 and 3 in. (51 and 76 mm) bars were 10 ft. (3,05 m) long, and all other bars were 12 ft. (3,66 m). Power Frequency and Impulse Withstand Tests: The samples were inserted through a grounded 3 ft. (0.9 m) long duct and positioned to required air gap clearance from one duct wall. Test for Bus Bar Insulation: The samples were wrapped with a half-lapped layer of 3M Scotch_ 24 Electrical Shielding Tape to establish a ground plane in contact with the BBI insulation. Corona Tests (ANSI/IEEE 454): Corona (partial discharge) testing was performed on BBI insulated bus bar which was inserted through a grounded 31t. (0.9 m) long duct. The bar was positioned to the required air gap clearance from one duct wall. The test results suggest that the air gap between the bar and duct is so large in relationship to the air gap between the bar and insulation, that no corona condition exits in the normal testing range up to 38 kV.

3M[™] Heat Shrinkable Tubing for Bus Bar BBI-A Series 5-35 kV

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Typical Physical and Electrical Propert * All values are averages, based on several determinati	
and are not intended for specification purposes	015,
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Electrical Properties	
Test Method	Typical Value*
Dielectric Constant	3.5
(ASTM D-150)	550 \//mil
Dielectric Strength (70 mils) (ASTM D-149)	550 V/mil (22 MV/m)
Volume Resistivity	(22 101 V/111)
(ASTM D–257)	1.4×10^{3}
(MIL–I–23053/15A)	
Track Resistance (7 hrs.)	
(ASTM D-2303)	1 in. @ 2.5 kV
ANSI/IEEE C37.20)	(25mm @ 2.5 kV)
Physical Properties	
Test Method	Typical Value*
Tensile Strength	2200 psi
(ASTM D-257)	(15 MPa)
(MIL-I-23053/15A)	
Ultimate Elongation (ASTM D–638)	575%
(MIL–I–23053/15A)	51578
Water Absorption	
7 days @ 23°C (73°F)	0.3%
(MIL–I–23053/15A)	
Corrosion (Copper)	
16 hrs. @ 120°C (248°F)	Pass
(MIL–I–23053/15A)	
Fluid Resistance	Tensile = 810–2400 psi (5.6–16.5 MPa)
24 hrs. immersed	
(MIL–I–23053/15A)	Dielectric Str. = 287–451 V/mil (11.3–17.8 MV/m)
Thermal Properties	
Test Method	Typical Value*
Flammability	
(ANSI/EEE C37.20)	Pass
Thermal Endurance	
(ANSI/EEE 1) (IEC 216)	110° C (230° F)
Accelerated Aging	Tensile = 1430 psi (10 MPa)
7 days @ 175° C (347° F)	
(MIL–I–23053/15A)	Elongation = 400%
Heat Shock	
4 hrs @ 225° C (437° F)	Pass
(MIL–I–23053/15A) Low Temperature Flexiblity	
4 hrs @ -55° C (-67° F)	Pass
(MIL–I–23053/15A)	F doo

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Fluid Resistance (MIL-I-23053/15A) Immersion at 23° C (73° F) for 24 hours

	<u>.5 C (75 T) 10</u> Typica		operties after Im	nersion	
Fluid	Fluid Absorption (% by wt.)	Tensile Strength (ps) (MPa)	Elongation at Break (%)	Dielectric Strength (V/mil @ 0.150 in.) (MV/m)	Results
Specification		>750		>200	
Requirement Deicing fluid		(> 5,2) 2330		(>7,9) 333	
(Mil-A-8243)	0.0	(16,1)	600	(13,1)	Pass
Hydraulic fluid (Mil-H-5606)	2.8	1920 (13,2)	550	392 (15,4)	Pass
Lube oil (Mil-L-7808)	0.8	2330 (16,1)	515	404 (15,90	Pass
Lubricating oil (Mil-T-5624)	0.3	2365 (16,3)	515	451 (17,8)	Pass
Jet fuel, JP-4 (Mil-T-5624)	7.4	1380 (9,5)	515	349 (13,7)	Pass
5% Salt water	0.1	2400 (16,5)	525	436 (17,2)	Pass
30% Ammonia solution	0.4	2175 (15,0)	600	403 (15,9)	Pass
Noalox Joint Compound	0.4	2180 (15,0)	515	439 (17,3)	Pass
Contact cleaner (3M #1607)	42.0	830 (5,70	385	287 (11,03)	Pass
Black enamel Paint	23.1	810 (5,6)	350	366 (14,4)	Pass
Acetone	4.2	1550 (10,7)	510	339 (13,3)	Pass
Methylene Chloride	37.9	900 (6,2)	340	313 (12,3)	Pass

3M[™] Heat Shrinkable Tubing for Bus Bar BBI-A Series 5-35 kV

Test Description	Rated Maximum Voltage (kV)	ANSI/IEEE C37.20 REQURIEMENT (Kv)	Typical Maximum results (kV)
Power Frequency	8.25	26	> 50 (@ 2.5")
1 Minute Withstanding	15.50	50	> 50 (@ 2.5")
(Duct application)	25.80	60	> 60 (@ 3.5")
(Duct application)	38.00	80	> 80 (@ 5.5")
Bus Bar Insulation 1 Minute Withstand (shielding tape application)	8.25 15.50 25.80 38.00	8.25 15.50 25.80 38.00	20 20 35 50
Impulse Withstord	8.25	75	±125 (@ 2.5")
Impulse Withstand	15.50	110	±125 (@ 2.5")
(1.2 x 50 us wave)	25.80	125	±130 (@ 3.5")
	38.00	150	±165 (@ 5.5")

	Typical Corona Values					
Rated Maximum Voltage kV	Air Gap (to duct) (in.)	Typical Corona Starting Voltage (CSV) (kV @ > 3pc)	Typical Corona Extinction Voltage (CSV) (kV @ > 3pc)			
8.2	2.5	40	38			
15.50	2.5	40	38			
25.80	3.5	45	42			
38.00	5.5	45	42			

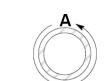
3MTM Heat Shrinkable Tubing for Bus Bar BBI-A Series 5-35 kV

3M[™] Heat Shrinkable Tubing for Bus Bar BBI–A can be used on bus bar rated up to 110°C(230°F), for 5, 8, 15, 25 and 35 kV voltage classes.

Selection Charts for Straight Bus Bar Standard lengths = 20ft. (6.1mm) and 50ft. (15.2mm)







5, 8 and	15 kV Bus Bar	Size Ranges		
Product Number	Bar Circumference (A)	Rectangular*	Square*	Round
BBI-3A	3.28 – 5.57 in.	1 1/2 x 1/4 – 2 1/2 x 1/2 in.	1 x 1 – 1 1/2 x 1 1/2 in.	1 1/8 – 1 3/4 in.
	(83 – 141 mm)	(38 x 6 – 64 x13 mm)	(25 x 25 – 38 x 38 mm)	(25 – 44 mm)
BBI-4A	5.43 – 8.86 in.	2 1/2 x 3/8 – 4 x 3/4 in.	2 x 2 in.	1 3/4 – 2 3/4 in.
	(138 – 225 mm)	(64 x 10 – 102 x19 mm)	(51 – 51 mm)	(44 – 70 mm)
BBI-5A	6.67 – 10.86 in.	3 x 5/8 – 5 x 3/4 in.	2 x 2 – 2 1/2 x 2 1/2 in.	2 1/8 – 3 3/8 in.
	(169 – 276 mm)	(76 x 16 – 127 x19 mm)	(51 x 51 – 64 x 64 mm)	(54 – 86 mm)
BBI-6A	7.57 – 12.86 in.	3 1/2 x 1/2 – 6 x 3/4 in.	2 1/2 x 2 1/2 – 3 x 3 in.	2 1/2 – 4 in.
	(192 – 327 mm)	(89 x 13 – 152 x19 mm)	(64 x 64 – 76 x 76 mm)	(64 – 102 mm)
BBI-7A	8.28 – 13.00 in.	4 x 1/4 – 6 x 3/4 in.	2 1/2 x 2 1/2 – 3 x 3 in.	2 3/4 – 4 1/8 in.
	(210 – 330 mm)	(102 x 6 – 152 x19 mm)	(64 x 64 – 76 x 76 mm)	(70 – 105 mm)
BBI-8A	10.29 – 16.43 in.	5 x 1/4 – 8 x 3/8 in.	3 x 3 – 4 x 4 in.	3 3/8 – 5 1/8 in.
	(261 – 417 mm)	(127 x 6 – 203 x 10 mm)	(76 x 76 – 102 x 102 mm)	(86 – 130 mm)
BBI-9A	12.29 – 19.23 in.	6 x 1/4 – 9 x 3/4 in.	3 1/2 x 3 1/2 – 5 x 5 in.	4 – 6 1/8 in.
	(312 – 488 mm)	(152 x 6 – 229 x 19 mm)	(89 x 89 – 127 x 127 mm)	(102 – 156 mm)
BBI-10A	15.43 – 24.14 in.	8 x 1/4 – 10 x 3/4 in.	5 x 5 – 6 x 6 in.	5 – 7 5/8 in.
	(392 – 613 mm)	(203 x 6 – 254 x 19 mm)	(127 x 127 – 152 x 152 mm)	(127 – 194 mm)
25 kV B	us Bar Size Ran		· · ·	· · · · · · · · · · · · · · · · · · ·
BBI-3A	3.28 – 3.56 in.	1 1/2 x 1/4 – 1 1/2 x 3/8 in.	MEASURE	1 1/8 in.
	(83 – 90 mm)	(38 x 6 – 38 x10 mm)	CIRCUMFERENCE	(29 mm)
BBI-4A	5.43 – 5.80 in. (138 – 147 mm)	2 1/2 x 3/8 – 2 1/2 x 5/8 in. (64 x 10 – 64 x16 mm)	MEASURE	1 ¾ in. (44 mm)
BBI-5A	6.67 – 7.18 in.	3 x 5/8 – 3 x 3/4 in.	MEASURE	2 1/8 – 2 1/4 in.
	(169 – 182 mm)	(76 x 16 – 76 x19 mm)	CIRCUMFERENCE	(54 – 57 mm)
BBI-6A	7.57 – 8.43 in.	3 1/2 x 1/2 – 4 x 1/4 in.	MEASURE	2 1/2 – 2 5/8 in.
	(192 – 214 mm)	(89 x 13 – 102 x 6 mm)	CIRCUMFERENCE	(64 – 67 mm)
BBI-7A	8.28 – 10.44 in.	4 x 1/4 – 5 x 3/8 in.	2 1/2 x 2 1/2 in.	2 3/4 – 3 1/4 in.
	(210 – 265 mm)	(102 x 6 – 127 x10 mm)	(64 x 64 mm)	(70 – 83 mm)
BBI-8A	10.29 – 12.88 in.	5 x 1/4 – 6 x 3/4 in.	3 x 3 in.	3 3/8 – 4 in.
	(261 – 327 mm)	(127 x 6 – 152 x 19 mm)	(76 x 76 mm)	(86 – 102 mm)
BBI-9A	12.29 – 15.31 in.	6 x 1/4 – 7 x 3/4 in.	3 1/2 x 3 1/2 – 4 x 4 in.	4 – 4 7/8 in.
	(312 – 389 mm)	(152 x 6 – 178 x 19 mm)	(89 x 89 – 102 x 102 mm)	(102 – 124 mm)
BBI-10A	15.43 – 19.79 in.	8 x 1/4 – 9 x 3/4 in.	5 x 5 in.	5 – 6 1/4 in.
	(392 – 5.03 mm)	(203 x 6 – 229 x 19 mm)	(127 x 127 mm)	(127 – 194 mm)
35 kV B	us Bar Size Ran			
BBI-7A	8.28 – 8.86 in.	4 x 1/4 – 4 x 3/4 in.	MEASURE	2 3/4 in.
	(210 – 225 mm)	(102 x 6 – 102 x19 mm)	CIRCUMFERENCE	(70 mm)
BBI-8A	10.29 – 10.94 in.	5 x 1/4 – 5 x 3/4 in.	MEASURE	3 3/8 in.
	(261 – 278 mm)	(127 x 6 – 127 x 19 mm)	CIRCUMFERENCE	(86 mm)
BBI-9A	12.29 – 13.00 in. (312 – 330 mm)	6 x 1/4 – 6 x 3/4 in. (152 x 6 – 152 x 19 mm)	MEASURE	4 – 4 1/8 in. (102 – 105 mm)
BBI-10A	15.43 – 16.86 in.	8 x 1/4 – 8 x 3/4 in.	MEASURE	5 – 5 1/4 in.
	(392 – 428 mm)	(203 x 6 – 203 x 19 mm)	CIRCUMFERENCE	(127 – 133 mm)

NOTE:* Rectangular and square bar sizes are based on bars having radiused edges and corners.

NOTE: BBI-A tubing sizing is based on straight sections of bar. For bolted connections consult bolted connection chart on page 3.

NOTE: Contact your 3M sales rep for recommendation on the use of BBI–A on 1/8" thick bus bar.

3M [™] Heat Shri	3M [™] Heat Shrinkable Tubing for Bus Bar BBI–A Coverage for Inline Bolted							
Connections (F	Connections (Rectangular Bus Bar)							
Note: First slect BB			charts for	Straight Bus	s Bar			
5, 8 & 15kV: Inline	Bolted Cor	nnections						
Rectangular Bar Width	BBI-3A	BBI-4A	BBI-5A	BBI-6A	BBI-7A	BBI-8A	BBI-9A	BBI-10A
1.5 in. (38 mm)	1 Layer							
2.0 in. (51 mm)	2 Layer							
2.5 in. (64 mm)		1 Layer						
3.0 in. (76 mm)		2 Layer						
3.5 in. (102 mm)		2 Layer	1 Layer					
4.0 in. (127 mm)		2 Layer	2 Layer	1 Layer	1 Layer			
5.0 in. 152 mm)			2 Layer	2 Layer	1 Layer	1 Layer		
6.0 in. (178 mm)				2 Layer	2 Layer	1 Layer	1 Layer	
7.0 in. (203 mm)						2 Layer	1 Layer	
8.0 in. (229 mm)						2 Layer	2 Layer	1 Layer
9.0 in. (254 mm)							2 Layer	1 Layer
10.0 in. (254 mm)								2 Layer

25 & 35 kV: Inline Bolted Connections USE 2 LAYERS OF BBI-A TUBING FOR ALL 25 & 35 kV Inline Bolted Connections

Typical Dimensions					
Product Number	Length	Minimum Expanded Tubing I. D.	Expanded Wall Thickness	Max. Recovered Tubing I. D.	Recovered Wall Thickness
BBI-3A	20 & 50 ft	2.38 in.	0.049 in.	1.01 in.	0.113 in.
	(6.1 & 15.2 mm)	(60 mm)	(1,24 mm)	(26 mm)	(2,87 mm)
BBI-4A	20 & 50 ft	4.35 in.	0.043 in.	1.67 in.	0.113 in.
	(6.1 & 15.2 mm)	(110 mm)	(1,09 mm)	(42 mm)	(2,87 mm)
BBI-5A	20 & 50 ft	5.30 in.	0.043 in.	2.04 in.	0.114 in.
	(6.1 & 15.2 mm)	(135 mm)	(1,09 mm)	(52 mm)	(2,90 mm)
BBI-6A	20 & 50 ft	5.90 in.	0.046 in.	2.33 in.	0.117 in.
	(6.1 & 15.2 mm)	(150 mm)	(1,17 mm)	(59 mm)	(2,97 mm)
BBI-7A	20 & 50 ft	6.78 in.	0.048 in.	2.55 in.	0.130 in.
	(6.1 & 15.2 mm)	(172 mm)	(1,22 mm)	(65 mm)	(3,30 mm)
BBI-8A	20 & 50 ft	8.25 in.	0.049 in.	3.18 in.	0.128 in.
	(6.1 & 15.2 mm)	(210mm)	(1,24 mm)	(81 mm)	(3,25 mm)
BBI-9A	20 & 50 ft	8.83 in.	0.054 in.	3.78 in.	0.127 in.
	(6.1 & 15.2 mm)	(224 mm)	(1,37 mm)	(96 mm)	(3,23 mm)
BBI-10A	20 & 50 ft	10.28 in.	0.059 in.	4.53 in.	0.138 in.
	(6.1 & 15.2 mm)	(261 mm)	(1,50 mm)	(115 mm)	(3,51 mm)

c b b c c	

Typical Clearances for Rectangular and Square Bus Bars

Voltage Rating	BIL		BBI-A Insulated (Indoor Clearance)		lated learance)
(kV)	(Kv)	Dimension	Dimension	Dimension b	Dimension c
15 & Below	110	2.7 in. (69 mm)	3.0 in. (76 mm)	7.5 in. (191 mm)	5.0 in. (127 mm)
25	125	3.0 in. (76 mm)	3.5 in. (89 mm)	10.5 in. (267 mm)	7.5 in. (191 mm)
35	150	4.5 in. (114 mm)	5.5 in. (140 mm)	12.5 in. (318 mm)	9.5 in. (241 mm)

NOTE: b = minimum phase-to-phase dimension

c = minimum phase-to-ground dimension

The table indicates typical minimum clearance dimensions for 3M[™] Heat Shrinkable Tubing for Bus Bar BBI–A as compared to that for uninsulated bus bar. These dimensions are based on 60 Hz withstand, DC withstand (hypot) and BIL tests (Reference: ANSI/IEEE C37.20) and from partial discharge (corona) tests. Testing was performed on 12 ft. (3,7 m) lengths of copper and aluminum bus bar enclosed in a 3 ft. (0,9 m) long duct, with air spacing between the bar and grounded duct.

Application Tips

- 1. Keep Torch flame moving to prevent burning.
- 2. For rectangular bars: Shrink the edges of the BBI–A tubing first. This will achieve a more uniform insulation thickness around the bar.
- **3.** BBI–A tubing normally shrinks at approx. 250_F(120_C). (*Caution: burn damage can occur if tubing temperature exceeds approx. 600_F (315_C) for several minutes.*)
- **4.** Dimples appearing in BBI–A tubing during shrinkage are normal, and are removed with continued even heating.
- **5.** Heat application should be discontinued immediately after dimples disappear, or when tubing has shrunk smoothly onto bar.
- 6. Use proper torch which produces a blue and yellow flame.
- **7.** CAUTION: Be careful handling insulated bus bar while it is still hot. The heated tubing is soft and susceptible to physical damage.
- **8.** SAFETY: Use caution and proper safety procedures when working with open flame and high temperatures. This would include maintaining a well ventilated workplace.

Installation Techniques

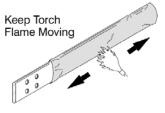
An instruction sheet is included in each package to provide the installer with the information required to properly install the 3MTM Heat Shrinkable Tubing on bus bar. A brief summary of the installation for BBI–A is outlined as follows:

Instructions for Straight Bus Bar

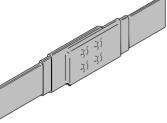
- 1. Clean bus bar and cut BBI–A Tubing to required length. Use a sharp knife or razor to ensure a clean cut with no nicks.
- 2. Preheating of bus bar is recommended.



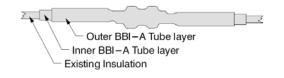
3. Slide BBI-A Tubing into position and shrink onto busbar using standard industry methods.



Instructions for Inline Bolted Connections



- 1. For 15 kV applications consult the Inline Bolted Connections chart on page 3. Determine whether one or two layers of BBI–A will be required. All 25 and 35 kV applications will require two layers of BBI–A (see Additional Instructions for 25 and 35 kVConnections on page 7).
- 2. Clean the bolted connection.
- **3.** Cut one layer of BBI–A tubing to cover at 6 inches (152 mm) of existing insulation on each side of the connection. Exercise care to ensure a clean cut.
- **4.** Cut a second (outer) layer of BBI–A tubing (if required) to a length that is 2 inches (51 mm) shorter than the first layer.
- 5. Shrink the first (inner) layer of BBI–A tubing onto the bus bar and bolted connection. If required, center the second layer of tubing over the first layer and shrink using standard industry methods.



Additional Instruction for 25 and 35 kV Connections 1. Fill in edges of existing bus bar insulation with an electrical grade filler before applying two layers of BBI-A tubing. Filler 1111 Existing Insulation Filler Maintenance 3M[™] Heat Shrinkable Tubing for Bus Bar BBI–A is not impaired by freezing or overheating due to ambient temperatures found in storage or shipping. Normal storage and stock rotation practices are recommended. This product has a 10-year shelf life from date of manufacture when stored in a Shelf Life & Storage humidity controlled storage (10°C/50°F to 27°C/80°F and <75% relative humidity). Availability Please contact your local distributor; available from 3M.com/electrical {Where to Buy} or call 1-800-245-3573.

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