



Introduction of Innovative Conductor

June, 2018@ACEF

TOKYO ROPE INTERNATIONAL INC.





Company Profile

• Established : 1887

• Number of Employees : 1,800

• Sales : US\$ 650 million

Products : - Steel Wire Rope, Synthetic Fiber Rope, Carbon Fiber Cable,

- Steel Cable for bridges

- Steel Cord for tire reinforcement, Sawing Wire

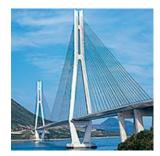
- Engineered Products for road safety devices, environment protection

- Steel Wire Products for industrial and machinery applications

- Die, Tool for wire products and forging











Company Profile

TOKYO ROPE'S STRENGTH



Stranding Specialist







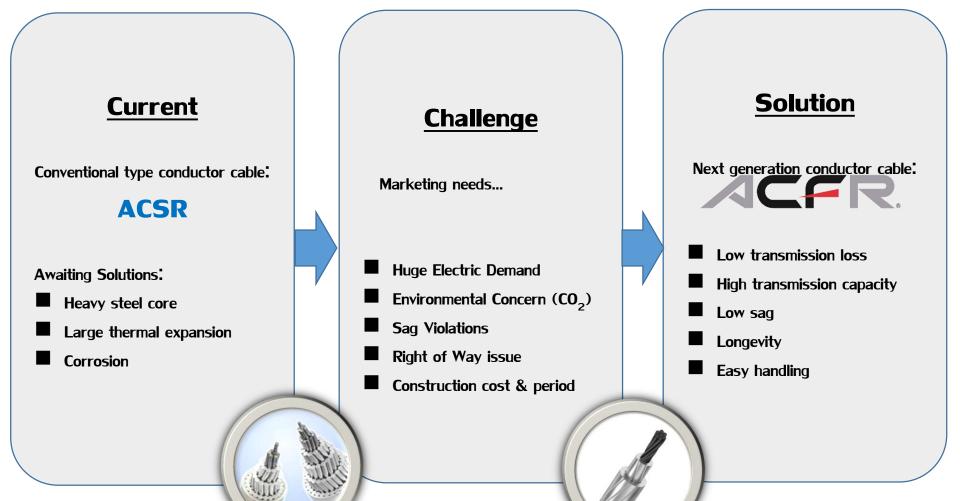
Globally the first company to strand the carbon composite material







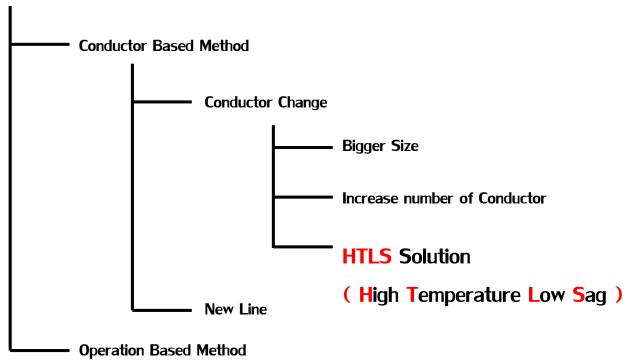
Overhead Conductor Market





Transmission Capacity Increasing Method

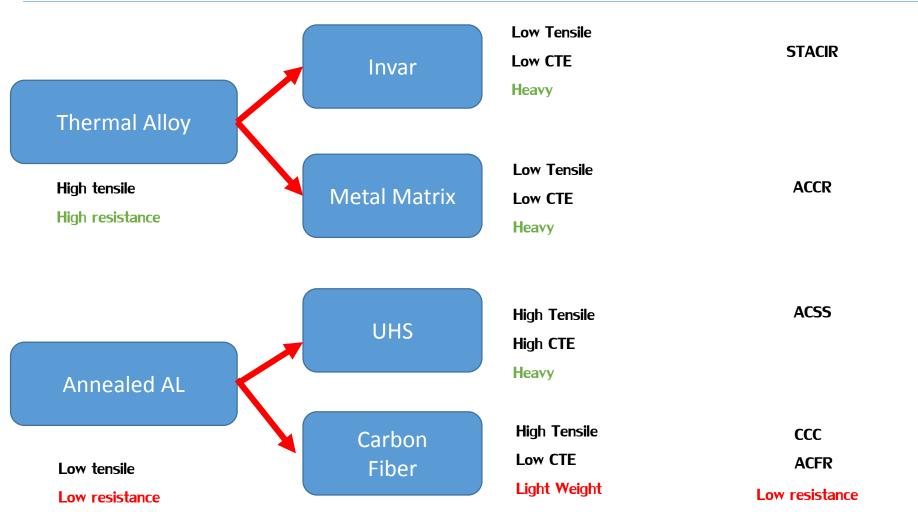
1, Ampacity Based Solution



2, Voltage Based Solution



HTLS Technology



Carbon Fiber Conductor is the best option for low loss



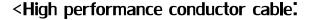


What is



- <Conventional overhead conductor cable: ACSR >
- "Aluminum Conductor Steel Reinforced"
- ightharpoonup Steel wire core ightharpoonup Heavy weight / Large thermal expansion
- ightharpoonup Round shaped aluminum wire ightharpoonup Small cross sectional area

VS.

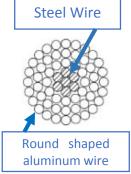


> ACFR

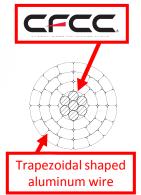
"Aluminum Conductor Fiber Reinforced"

- ► **CFCC** re Light weight / Small thermal expansion
- ightharpoonup Trapezoidal aluminum wire ightharpoonup Large cross sectional area











Aluminum for





Application

Conductive Outer Layer

Low Resistance

Better sag

1350-0 temper

China Malaysia

Market

Indonesia

Easy Installation and Handling like ACS



AT-1 (TAL)



Japan Taiwan Brazil

		Hard-drawn A1350-H19	Annealed A1350-O	Thermal- resistant TAI (AT1)
Conductivity	[%IAC S]	61.2	63.0	60.0
	[%]	100	103	98
Maximum operating temperature	[°C]	90	250	150
Tensile Strength	[MPa]	162-172	55-96	165-186

^{*} See Annex 2-1 for examples of ACFR specification.









Core Material – Different Technology

Cond	luctor	ACSR	ACSS	STAC R	Solid CCC	ACFR
Strength	Мра	1,300	1,381	1,275	2,158	2,158
M odulus	G pa	200	200	152	117	130
CTE	x10-6/°C	11.5	11.5	3.7	1.6	1.0
W eight	kg/km	1.3	1.3	1.3	1.1	0.9

High Strength Low expansion Lesser Weight









"Carbon Fiber Composite Cable"

Stranded CFRP developed by TOKYO ROPE





Low Linear Expansion: About 1/10 of Steel

High Strength: 30-40% more than Steel for conductor core

Non-magnetic: No Iron Loss

High Flexibility: High bending angle, smaller diameter of stringing sheave

High Corrosion resistance: Against acid, alkali, water and UV

High Tensile Fatigue: Able to withstand wind vibration

Low Creep Elongation: Similar to Steel

High Modulus: Equal to Steel













Ingredient of "Torayca®", Carbon fiber made by TORAY

Torayca® is applied to state of the art aircraft such as Boeing 787

The Wing of Boeing 787

Black bones are made of Torayca®

Source: Bloomberg ©









 $\tilde{\ }$ History of CFCC and ACFR $\tilde{\ }$

1980s	Started development of CFCC
1986	Supplied for PC Bridge Project in Japan
2001	Supplied for PC Bridge project in Michigan/USA
2002	Supplied for ACFR project in Japan
2011	Estimated Gamagori CFCC Plant in Japan
	(First full-scale integrated CFCC factory)
2012	Supplied for ACFR project in China
2015	Supplied for ACFR project in Indonesia
2016	Estimated Michigan CFCC Plant in USA
	(First overseas CFCC production facility)

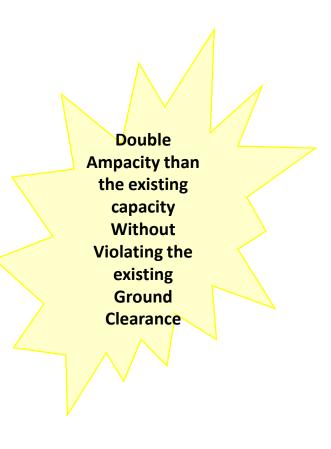


Michigan Plant (U.S.A.)



Case Study 400 KV - CTU & STU

Description	ACSR Moose	Need
Voltage (kV)	400	400
Tension 32 deg. Full wind (122 Kg/sq.m)	6740	6740
Tension @ 5 deg. 36 % of Full wind (44 Kg/Sq.m)	4712	4712
Sag at 85 deg.c – 400 Span	13.26	13.26
Ampacity @ 85 deg.c	800	1500





Case Study 400 KV - Different Technology

Description	ACSR Moose	Requirement	ACSS	STACIR	CCC	ACFR
Diameter (mm)	31.77	≤ 31.77	30.19	28.95	31.77	31.77
Weight (Kg/Km)	2004	≤ 2004	1993	2001	1988	1968
Voltage (kV)	400	400	400	400	400	400
Tension 32 deg. Full wind (122 Kg/sq.m)(Kg)	6740	6740	6648	6566	6569	6540
Tension @ 5 deg 36 % of Full wind (44 Kg/Sq.m) (Kg)	4712	4712	4712	4712	4712	4712
Sag at below Amps (Meters)	13.26	13.26	13.97	13.26	12.39	12.36
Ampacity & OT (Amps) & (Deg.c)	800 (85)	1500	1500 (182)	1500 (175)	1500 (133)	1500 (131)

✓ ☐ ☐ Lesser Sag and Low Operating Temperature than any other technology



Case Study 220 KV - South India STU

Description	Exiting ACSR Zebra Conductor	Need of STU	More than Double Ampacity than
Voltage (Kv)	220	220	the existing capacity
Ampacity @ 75 deg.c	550	1200	Without Violating the
Tension 32 deg. Full wind (83 Kg/sq.m)	4981	4981	existing Ground Clearance
Sag at 75 deg.c – 350 Span	9.24	9.24	



Case Study 220 KV - Different Technology

Description	ACSR Zebra	Requirement	STACIR	CCC	ACFR
Diameter (mm)	28.62	≤ 28.62	25.5	28.14	28.62
Weight (Kg/Km)	1621	≤ 1621	1600	1565	1590
Voltage (kV)	220	220	220	220	220
Tension 32 deg. Full wind (83 Kg/sq.m) (Kg)	4981	6489	4981	4981	4981
Sag at below Amps (Meters) – 350 span	9.24	9.236	9.236	8.43	8.40
Ampacity & OT (Amps) & (Deg.c)	550 (75)	1200	1100 (138)	1200 (122.5)	1200 (118.4)





Case Study 132 KV - North India STU

Description	Exiting ACSR Panther Conductor	Need of STU	More than Double Ampacity than
Voltage (Kv)	132	132	the existing capacity
Ampacity @ 75 deg.c	379	1000	Without Violating the
Tension 32 deg. Full wind (45 Kg/sq.m)	2840	2840	existing Ground Clearance
Sag at 75 deg.c – 365 Span	8.83	8.83	



Case Study 132 KV - Different Technology

Description	ACSR Panther	Need	ACSS	STACIR	CCC	ACFR
Diameter (mm)	21	≤ 21	19.66	19.6	20.5	20.75
Weight (Kg/Km)	974	≤ 974	968	850	835	819
Voltage (kV)	132	132	132	132	132	132
Tension 32 deg. Full wind (45 Kg/sq.m) (Kg)	2840	2840	2840	2712	2724	2840
Sag at below Amps (Meters) – 365 Span	8.83	8.83	10.65	11.7	7.81	7.79
Ampacity & OT (Amps) & (Deg.c)	378 (75)	1000	1000 (210)	1000 (250)	1000 (166.6)	1000 (163.8)

Lesser Sag and Low Operating Temperature than any other technology

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Tension Hardware



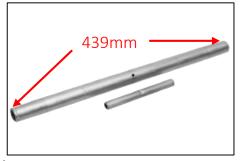
Similar design and installation equipment to ACSR's.

<u>ACSR</u>

Dead End Clamp (example - Linnet size)



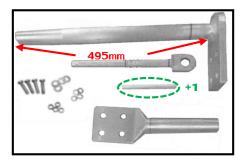
Mid Span Joint (example - Linnet size)

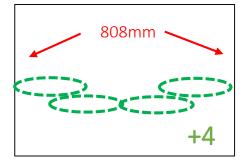


Equipment

Compression Machine Die x 2 set

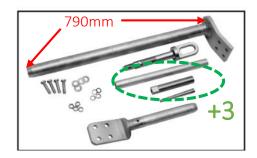
ACFR

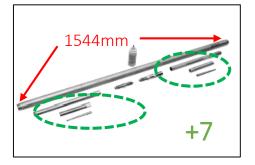






CCC





Compression Machine
Die x 1 set
Torque Wrench for Collet
Mesh Sanding Paper



Installation of Hardware



Easy installation of fitting process.



Dead end clamp for ACFR Finish time is 5 minutes 35 seconds



Dead end clamp for ACSR Finish time is 5 minutes 20 seconds



Key Stringing Criteria Comparison



Similar installation requirements to ACSR's.

Conductor Type	AC	CFR	ACCC	TACSR	ACSS	ACCR
Aluminum	Annealed (1350-O)	Thermal Resistant (TA1)	Annealed (1350-O)	Thermal Resistant (TA1)	Annealed (1350-O)	Thermal Resistant (TA1)
Bull Wheels	40 x diameter		40 x diameter	40 x diameter	40 x diameter	1828mm Minimum
Sheaves Wheels	20 x diameter		25-35 x diameter	20 x diameter	20 x diameter	711mm Minimum
Grips (Pulling)	Kellums		Kellums	Kellums	Kellums	Special Crip
Grips (Sagging)	Chi	cago	Chicago	Chicago	Pocketbooks Chicago	Special Grip
Recommended Pulling Angles	45 degrees	60 degrees	30 degrees	60 degrees	45 degrees	40 degrees
Dead End Installation Time	15 mi	nutes	30 minutes	15 minutes	15 minutes	15 minutes
Mid Span Joint Installation Time	30 mi	nutes	60 minutes	30 minutes	30 minutes	30 minutes

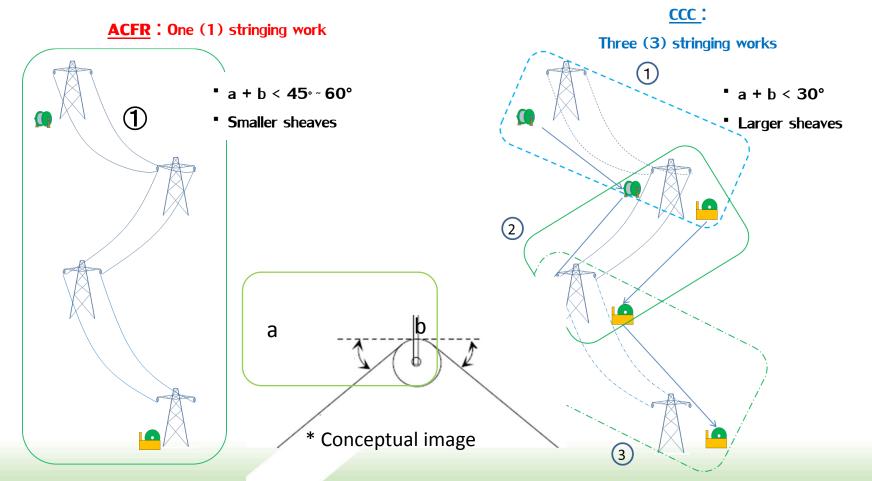
[✓] In general, the conductors with carbon fiber core shall be handled with care (no drag/scratch, no over twist, no over bend) during installation work. Initial on-site training is available.

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Bending Angle (Flexibility)

- ✓ Less numbers of stringing works.
- ✓ Smaller diameter of sheaves.





Certification and Testing

Standards











Design Tests

- UTS of Conductor and Core
- Stress Strain Conductor and Core
- **Electrical Resistance** test
- **Creep Test**
- Thermal Expansion
- Tg Test
- Flexural Strength
- Elongation

Certification



Installation Tests

- **Sheave Test**
- **Bending Test**
- **Torsion Test**
- Radial Crush Test
- **Gripping Force**





TOKYO ROPE MFG. CO., LTD.

In-service/Operation **Performance Tests**

- Sag and Tension
- Corrosion
- Heat Exposure test for 52 weeks
- Heat Stress Test
- Temperature Cycle
- Strand Brittle Fracture test
- Fatigue Test
- High Temperature Creep
- **UV Aging Test**
 - Fire retardant test





TOKYO ROPE INTERNATIONAL

Supply Record of



Year	2002	2003	2012	2013	2015	2016
Size	160/40	160/40	315/35	320/40	315/40	315/40
Voltage	66kV	66kV	110kV	220kV	150kV	150kV
Location	Miyagi Japan	Niigata Japan	Guangdong China	Hainan China	Kalimantan Indonesia	Medan Indonesia
Owner	Tohoku Electric Power Co., Inc.	Tohoku Electric Power Co., Inc.	China Southern Power Grid	China Southern Power Grid	PLN	PLN



The very first carbon core conductor commissioned in the world.

The line is up and running ever since.



Project Profile : Lower Sagging

Project Overview

Customer Tohoku Electric Power Co

Project Kashimadai Line / Sekiya Line

Location Miyagi, Niigata / Japan

Year Installed 2002

Conductor Length 3 KM / 2KM

Voltage 66 kV

Solution

ACFR 160/40 (Round Shaped Hard Drawn AL)

Result

20% capacity increase while maintaining clearances

Used existing towers without modification

Maintained existing right of way

Saved time for installation





The oldest transmission line using carbon core in the world



TOKYO ROPE INTERNATIONAL

Operation Certification

Japanese



English

To TOKYOROPE MFG. CO.,LTD

Tohoku Electric Power. Co.,Inc.

Certification of Operation Record ACFR: Aluminum Conductor carbon Fiber Reinforced

Tohoku Electric Power. Co., Inc certify the safe operation of Aluminum Conductor Carbon fiber Reinforced without any problem from the beginning of operation until now as shown below.

Table.1 Operation record of ACFR

Record No.	1		2		
Name of Branch office	Miyagi	Miyagi Branch		Niigata Branch	
Line name/ span No.	66kV Kashi	66kV Kashimadsi line		imadai line	
	No.5 ~	No.9	No.3	~ No.5	
Route Length	1,06	3m	46	52m	
Location	Hieobuchi, Ishir	omaki, Miyagi	Koshin, Nishi	Ward, Niigata	
Conductor type	ACFR 1	G0mm ⁸	ACFR	160mm ³	
Installed in	Decemb	er 2002	Octob	er 2003	
†Corroding condition	0.25 m	g/nm²	0.50	mg/cm²	
Reason for choosing ACFR	To gain groun	id clearance	To gain grou	and clearance	
Current Carrying Capacity		90°C: 454A,	120°C: 600A		
‡Result	Conductor tempera	Conductor temperature: 90°C			
Difference in sagging between	Span length	ACSR(A)	ACFR(B)	(A)(B)	
ACSR and ACFR	S=200	5.08	3.70	1.38	
	S=250	7.27	5,66	1.61	
	S=300	9.88	8.04	1.84	
	S=350	12.91	10.88	2.08	
	S=400	16.38	14.03	2.35	
	Conductor tempera	sture: 90°C			
	Span length	ACSR(A)	ACFR(B)	(A) -(B)	
	S-200	5.76	3.73	2.03	
	8=250	8.03	5.70	2.33	
	S=300	10.70	8.09	2.61	
	S=350	13.78	10.88	2.90	
	S=400	17.29	14.00	3.20	
Line condition	No change has Maintain good o install Running withou	ondition since	Maintain good condition since installation.		

'Cozzudiug condition' means assumed salt deposit density
10-icolation condition Maximum tension in use 26.5M/
10-icolation condition in the condition of the condition of

Haruji Sato Tubaka Electric Purisa Ca-Jine Electricity matellication division Electricity ayanin section (transmission) Harrii Seto Section daixf



Project Profile : Ampacity Upgrade

Project Overview

Customer China Southern Power Grid

Project Hainan Island City

Location Hainan Island / China

Year Installed 2013 (Energized)

Conductor Length 60 KM

Voltage 220 kV

Solution

ACFR 320/40 (Trapezoidal Shaped Annealed AL)

Result

Doubled capacity of line while maintaining clearances

Used existing towers without modification

Maintained existing right of way

Saved time for installation







Operation Certification from China

Chinese

"倍容导线在海南电网的研究与应用" 项目使用情况报告

2012 年海南电网海口供电局根据电网改造要求,对南网特维线路"220kV 福丰 1 线"进行了增容技术改造工程,选用的是佛冈鑫源恒业电缆科技有限公司生产和配套的绞合型碳纤维软铝导线JLRX1/JFB-320/40 及压接型金具,线路全长 18.9km,整个改造工程用绞合碳纤维芯软铝绞线 59.567km,最大耐张段长度 4682 米,最大导线单段制造长度 5018 米,导线施工周期 18 天;于 2013 年 7 月 2 日挂网运行。

整个工程安装方便,特别是压接型金具操作简单,安全,快速,整条线路使用近半年没发生一次问题,经历数次台风洗礼(包括今年历史上最大台风海燕),最大电流1040A,孤垂及导线温度参数均符合设计要求。

我公司对这种导线是第一次使用,从技术参数及安装使用情况来 说,此种导线是一种值得研究使用的新型节能导线。



English

TOKYO ROPE MFG.CO.,LTD. September, 2015 Item 4-2

(TRANSLATION - Chinese to English)

Re: Project Report for research and applications on double-carrying capacity conductor cable at Haina Power Grid Corp.

Hainan Power Grid Corp. Haikou Power Distribution Div. conducted revamping of transmission capacity enhancement on "220kV Fufeng Line 1" complying to electricity users' demand. JLRX1/JFB-320/40 type conductor cable and accessories, produced by Fogang Xinyuan Hengye Cable Technology Co.,Ltd. in Guangdong Providence, was used for this project in replacement of existing conductor cable line. JLRX1/JFB-320/40 is type of conductor cable made from soft annealed aluminum, reinforced by carbon fiber composite core, and dead-end clamp to be installed by compression. Route length is 18.9km and total length of conductor cable is 59.567km. The longest span between dead-end clamps is 4,682m. Production unit of conductor cable was 5,018m. Stringing work was done in 18days and electric current operation has started on July 2nd 2013.

It was reported that stringing work has been done smooth and easy, particularly, installation of dead-end clamp by pressing die has been done simple, quick and safe. After revamping on July2nd, 2013, although this line was hit by typhoon for many times including the strongest one ever in the history, the line has been in good and safe operation without any problem as of this date. Carrying 1,040A at maximum, sagging, temperature and other requirements have been within designed and satisfactory level.

This was the first time to make use of this conductor cable for our company, and this cable was reconfirmed to be worth while applying for actual operations as new energy-saving type cable, considering various aspects of this cable, including high standard of technology, easy and smooth handling and installation, and actual operational data.

Hainan Power Grid Corporation, Haikou Power Distribution Division Industrial Technology Department December 1st 2013



Project Profile : Ampacity Upgrade

Project Overview

Customer PLN

Project Binjai - Pangkalan Brandan

Location Medan / Indonesia

Year Installed 2015 (Energized) and 2018 (Installing)

Conductor Length 350 km for 2015 and 350 km for 2017

Voltage 150 kV

Solution

ACFR 315/40 (Trapezoidal Shaped Annealed AL)

Result

Doubled capacity of line while maintaining clearances

Used existing towers without modification

Maintained existing right of way

Saved time for installation

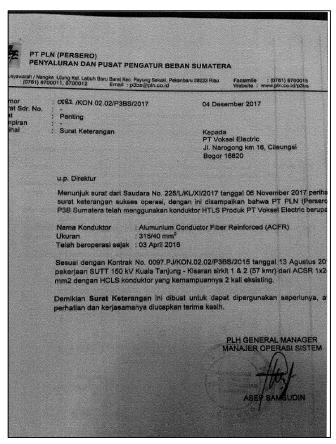






Operation Certification from PLN

Indonesian



English Translation

Number : 0582/KON.02.02/P3BS/2017 4 December 2017

Reference No :

Nature : Urgent

Regarding : Statement Letter

PT Voksel Electric

To:

Ji Narogong KM 16, Cileungsi

Bogor 16820

Attention : Director

In replying your letter No 225/L/KL/XI/2017, Date: 6 November 2017 about request of Success Operation Letter, with this PT PLN (Persero) P3B Sumatera confirmed that HTLS Conductor

Conductor Name : Aluminum Conductor Fiber Reinforced (ACFR)

Size : 315/40 mm2 Commencement Date : 3 April 2016

Contract No : 0097.PJ/KON.02.02/P3BS/2015, Date: 13 August 2015

Project Name : Reconductoring SUTT 150 kV Kualan Tanjung - Kisaran Circuit 1 & 2 (57 KMR)

from ACSR 1x240mm2 to HCLS Conductor with double the existing ampacity

Was produced by PT Voksel Electric

This letter of statement shall be used for the right purpose. Thank you for your corporation

Acting General Manager Manager of Operation & System

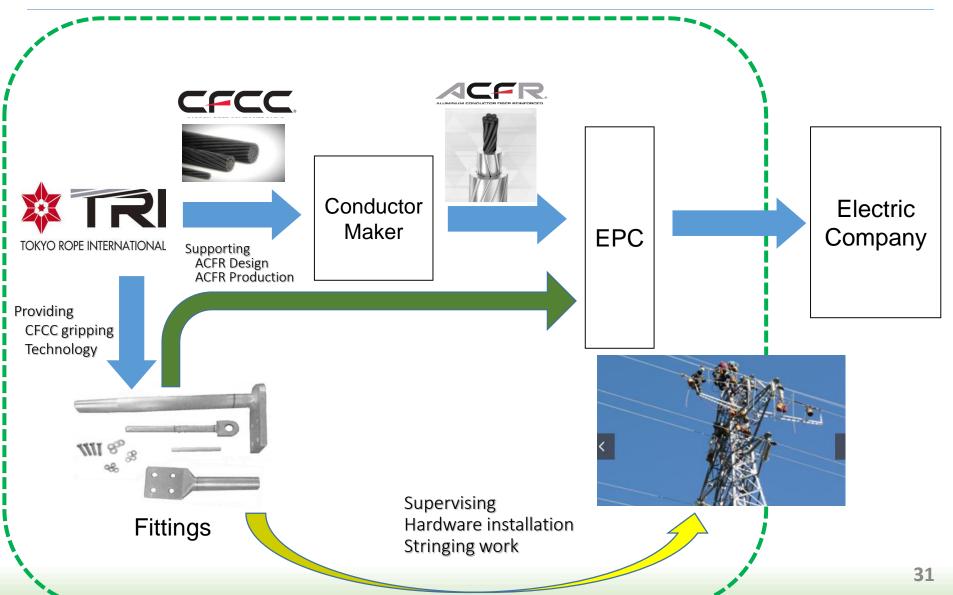
Asep Samsudin



Our Business Morel with









Stringing Support

Stringing Advisor

- Stringing Lecture
- Job Site Observation

Manual to be provided

Stringing



Hardware

Instruction Manual

COMPRESSION TYPE DEAD-END CLAMP

For ACFR 200mm²

Installation Video

Dead-End Clamp Installation for ACFR



Summary

- HTLS solution is attracting attention especially in Asia are
- ACFR is the best solution among

 HTLS conductor

■ ACFR's hardware and Installation process is close to standard ACSR



Thank you!

TOKYO ROPE INTERNATIONAL INC.