

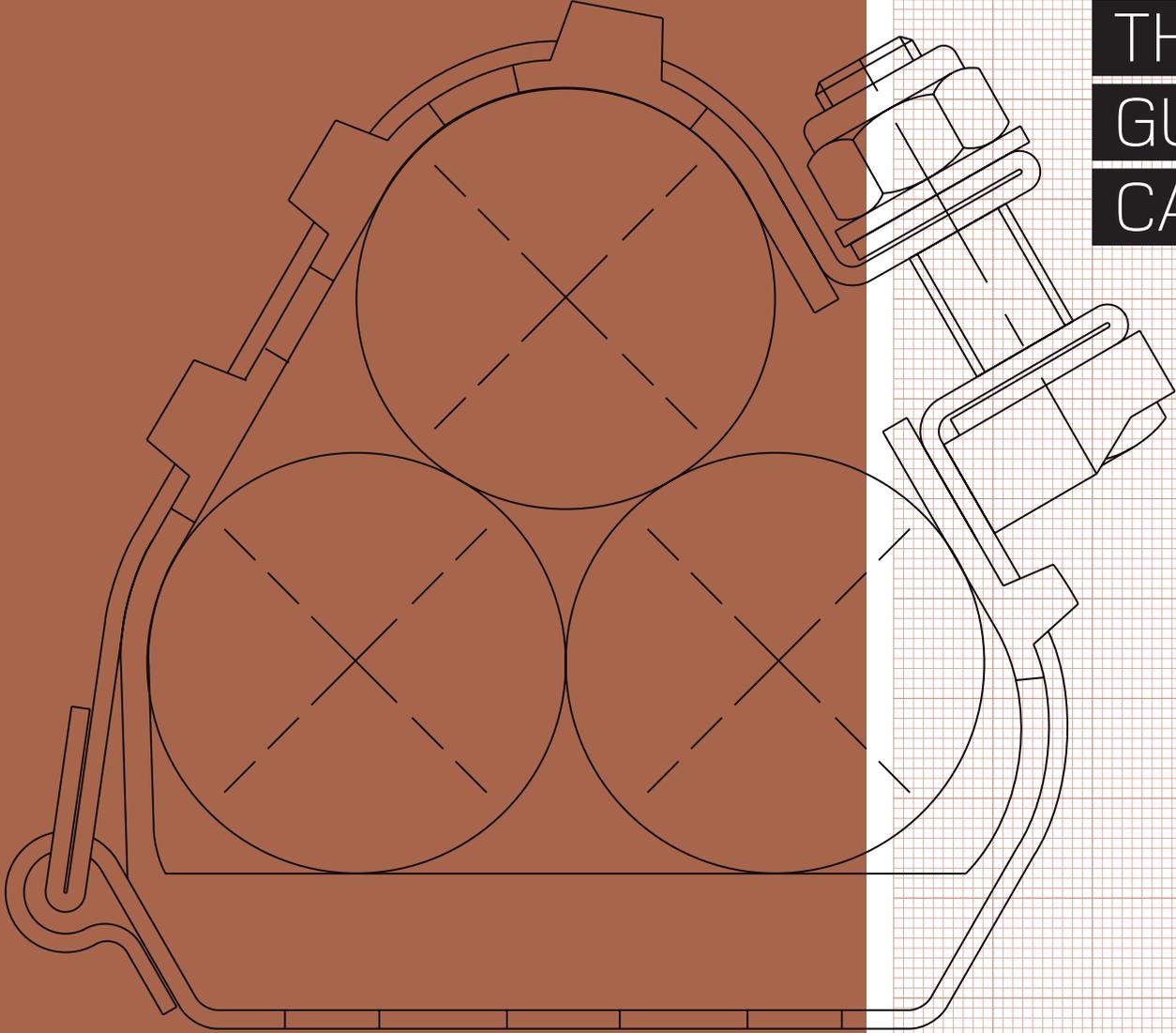
ELLIS

Holding Power

BLACK

BOOK

FIRST EDITION



THE ELLIS GUIDE TO CABLE CLEATS

What are cable cleats and why are they necessary?	4
The international standard	6
The mechanical strength of cable cleats	7
Short-circuit testing	8
Calculation of cleat spacing and selection of cleat type	12
Matters of corrosion	16
Cable cleats and... Operating temperatures Eddy currents Multi-core cables Fire UV Resistance	24
Cable system design	30
Frequently asked questions	32
Type approvals	34
Business management	36
References	38

WHAT ARE CABLE CLEATS AND WHY ARE THEY NECESSARY?

A CABLE CLEAT IS A DEVICE DESIGNED TO PROVIDE SECURING OF CABLES WHEN INSTALLED AT INTERVALS ALONG THE LENGTH OF THE CABLES

IEC 61914 Cable Cleats for Electrical Installations

“Every conductor or cable shall have adequate strength, and be so installed as to withstand the electromagnetic forces that may be caused by any current, including fault current.”

IET Wiring Regulations 17th Edition BS7671:2008 (2011)

“Cable restraints should:

- Prevent excessive cable movement due to fault-current magnetic forces
- Be rated for specific cable size and available current”

The fifth edition of API Recommended Practice 14F (Design, Installation and Maintenance of Electrical Systems for Fixed and Floating Offshore Petroleum Facilities)

“Single core electric cables are to be firmly fixed, using supports of strength adequate to withstand forces corresponding to the values of the peak prospective short-circuit current.”

Lloyds Register: Rules and Regulations for the Classification of Ships, Part 6, Control, Electrical, Refrigeration and Fire

“Cables are to be installed and supported in ways to avoid chafing and undue stress in the cable.”

ABS Steel Vessel Rules 4-8-4/21.9 Cable Support, 4-8-4/21.9.1 General and 4-8-4/21.9.3 Clips, Saddles, Straps

“In order to guard against the effects of electro dynamic forces developing on the occurrence of a short-circuit or earth fault, single core cables shall be firmly fixed, using supports of strength adequate to withstand the dynamic forces corresponding to the prospective fault current at that point of the installation.”

DNV Rules for Ships / High Speed Light Craft and Naval Surface Craft, Pt. 4 Ch. 8 Sec.10 – page 68, C50

ALWAYS REMEMBER:

Any power cable system designer or installer has an obligation to consider the method of securing cables in order to restrain their movement whether caused by an electrical fault or any other reason.

Other regulations outlining the whats and whys of cable cleats include NFPA-70 (US National Electrical Code) and C22.1 (Canadian Electrical Code).

THE INTERNATIONAL STANDARD

IEC 61914 *Cable cleats for electrical installations* outlines a series of tests that can be used to assess the performance of a cleat's design.

Although the standard does not define pass or fail levels, it allows manufacturers to define the performance characteristics of their products, and specifiers to compare products from different manufacturers.

The aspects of construction and performance covered by the standard include:

- Material type – i.e. metallic, non-metallic or composite
- Minimum and maximum declared service temperatures
- Resistance to impact at the minimum declared operating temperature
- The ability of the cleat to withstand axial slippage forces
- Resistance to electro-mechanical forces – i.e. the ability of the cleat to withstand the forces between the cables in the event of a short-circuit
- Resistance to UV and corrosion
- Flame propagation

THE MECHANICAL STRENGTH OF CABLE CLEATS

The international standard IEC 61914 includes a formula in Annex B that enables a designer to calculate the force between two conductors during a fault.

If the strength of a particular cleat is also known, then the optimum spacing of the cleat along the cable in order to restrain the force created by the fault can be calculated.

The strength of a cable cleat is often determined using a mechanical tensile test. However, the results may be misleading because the force is applied in a slow and controlled manner, which does not replicate fault conditions.

In a short-circuit fault the forces are applied almost instantaneously and oscillate in every direction. Experience shows that a cleat that survives a mechanical tensile test at a given force will not necessarily survive a short-circuit test, even if forces are the same.

Consider the properties of glass, immensely strong under tension but subject to brittle failure when impacted.

SHORT-CIRCUIT TESTING

Conducting a short-circuit test is the only reliable way of proving that a cable cleat is capable of withstanding a specific set of fault conditions.

We always recommend that any claims of cleat strength should be supported by a short-circuit test carried out in an independent and accredited laboratory and appropriately certified.

Specifiers, consultants and engineers should also request, as standard, a complete test report that includes before and after photographs, and a table of results and conclusions.

This practice is becoming commonplace, but prior to the publication of the international standard IEC 61914 many cable cleats were not tested, and those that were had no standardised testing method by which to gauge success or failure. As a result, test results were open to a wide range of differing interpretations.

IEC 61914 has provided a standardised method for conducting a short-circuit test and a definition of the criteria for a pass. It does though allow for a significant degree of latitude and so caution must be employed when interpreting results. Note should also be taken of the full report as opposed to just its headline page.

EXAMPLE: COMPARING TEST RESULTS

Two manufacturers have tested cleats to the international standard IEC 61914 and both claim their cleat is capable of withstanding a peak short-circuit current of 140kA.

- Manufacturer 'A' conducted a test using a 35mm cable cleated at 600mm centres
- Manufacturer 'B' conducted a test using a 45mm cable cleated at 300mm centres
- Your system peak fault level is 60kA, you are using a 30mm diameter cable and you wish to cleat at 1200mm centres.

Are both cleats suitable?

The answer? No.

Using the formula from The international standard IEC 61914 (provided and explained in the following section) the force each cleat was subjected to was:

Manufacturer 'A'	57kN
Manufacturer 'B'	22kN
You require	24kN (min)

Manufacturer B's product does not meet the requirement.

This example reinforces the importance of protecting a specification throughout the procurement process. An engineer can diligently calculate the forces and optimise the whole job cost through careful choice of cleat and cleat spacing. Yet when the project reaches the buyers they may see a requirement for 20,000 cleats, which they view as commodity products and so specify and install a cheaper option. The risks of under specification, given the dangers involved, are obvious.

ALWAYS REMEMBER:

Ellis will always specify a cleat capable of meeting the requirement.

SHORT-CIRCUIT TESTING

TEST DURATION

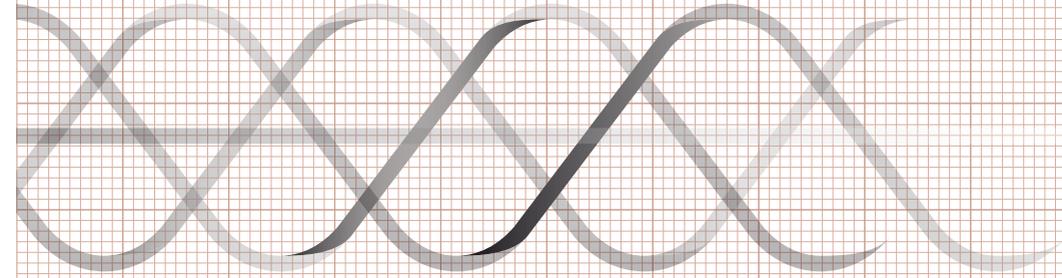
There is a major difference between the short-circuit withstand requirements of a cable and the short-circuit withstand of a cable cleat.

The former is concerned with cable degradation as a result of temperature rise (thermal stress heating), while the latter is concerned with cable retention as a result of electromechanical forces.

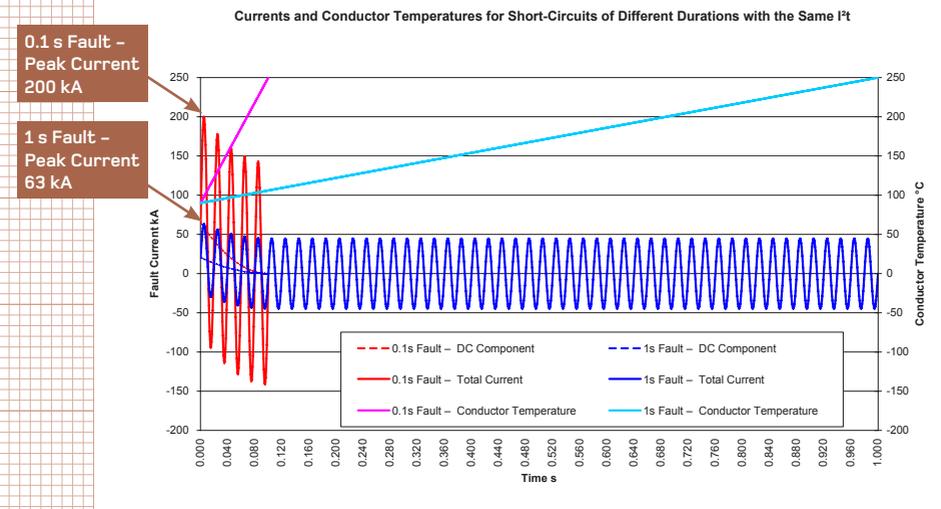
Typical installation specifications that have been derived from the thermal withstand of the cable would require a short-circuit withstand of 63kA for 1 second or 40kA for 3 seconds.

A short-circuit test for a cable cleat does not consider this heating effect, and instead concentrates entirely on the destructive electro-mechanical forces at peak, followed by a short term decaying RMS.

The international standard IEC 61914 requires a short-circuit test duration of just 0.1 second. This equates to five complete cycles, by which time the true strength of a cable cleat will be known.



DYNAMIC VS THERMAL



The conductor temperature will continue to rise until the fault condition ends. At this point the conductor temperature will begin to fall as heat dissipates through the rest of the cable structure. The thermal withstand of a cable is its ability to withstand this process.

Maximum cleat stress and the most likely point of cleat failure occurs at Peak Current (where indicated) after about 0.01s of commencement of the fault.

CALCULATION OF CLEAT SPACING AND SELECTION OF CLEAT TYPE

Where the system peak fault current and the cable diameter are known, the following formula, taken from The international standard IEC 61914, can be used to calculate the forces between two conductors in the event of a three phase fault:

$$F_t = \frac{0.17 \times i_p^2}{S}$$

Where:

F_t = force in Newton/metre (N/m)

i_p = peak short-circuit current in kiloamp (kA)

S = distance between the centrelines of the conductors in metres (m)

Once F_t in N/m has been determined then the force for each potential cleat can be calculated.

Metric ladder typically has rungs at 300mm intervals, so cleat spacing is usually a multiple of this distance. So, $F_t \times 0.3$ gives the force a cleat will see if spaced at 300mm, $F_t \times 0.6$ for 600mm etc.

$F_t \times$ cleat spacing can then be compared to the maximum recommended mechanical loop strength of the cleat and then the cleat type and spacing can be selected.

$$F_t = \frac{0.17 \times i_p^2}{S}$$

LOOP STRENGTH OF ELLIS CABLE CLEATS

CLEAT TYPE	LOOP STRENGTH (LS)
Alpha	15,000 N
Vulcan+, Protect and Standard Duty Flexi-strap	36,000 N
Emperor, Colossus and Heavy Duty Flexi-strap	63,000 N
Centaur Saddle and Clamps	85,000 N

ALWAYS REMEMBER:

Whole job cost should always be considered as costs can often be reduced by using a stronger, more expensive cleat at a wider spacing than a cheaper option at more regular intervals.

The formula uses peak current, however this is often unavailable with a Root Mean Square (RMS) value given instead. To calculate the peak current from the RMS, IEC 61439-1 Low voltage switchgear and controlgear assemblies is commonly referred to, which uses the following multiples:

10 - 20kA	= 2
21 - 50kA	= 2.1
51kA	= 2.2

CALCULATION OF CLEAT SPACING AND SELECTION OF CLEAT TYPE

EXAMPLE 1

Peak fault: 110kA

Installation: Ladder

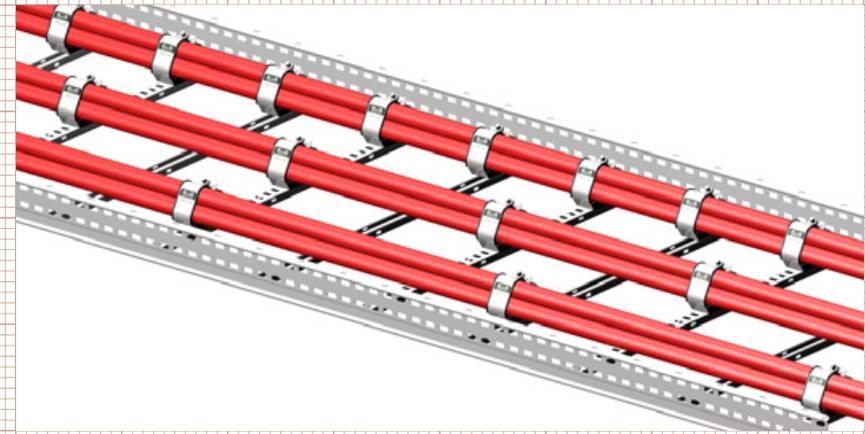
Cables in trefoil with an outside diameter of 38mm

$$F_t = \frac{0.17 \times 110^2}{0.038} = 54,132 \text{ N/m}$$

$F_t \times$ CLEAT SPACING	REQUIRED LOOP STRENGTH
0.3 for 300mm	16,240 N per cleat
0.6 for 600mm	32,480 N per cleat
0.9 for 900mm	48,718 N per cleat
1.2 for 1200mm	64,958 N per cleat

This force per distance can then be compared to different cleat loop strengths to ascertain the appropriate cleat and spacing requirements for specification.

In this example, the Ellis recommendation was for Vulcan+ cleats (LS: 36,000) spaced every 600mm, or Emperor cleats (LS: 63,000) every 900mm.



EXAMPLE 2

RMS fault: 30kA

Installation: Ladder

Cables in trefoil with an outside diameter of 33mm

Firstly multiply the RMS by 2.1 (or other system specific factor) to give 63kA peak. Then:

$$F_t = \frac{0.17 \times 63^2}{0.033} = 20,446 \text{ N/m}$$

$F_t \times$ CLEAT SPACING	REQUIRED LOOP STRENGTH
0.3 for 300mm	6,134 N per cleat
0.6 for 600mm	12,268 N per cleat
0.9 for 900mm	18,401 N per cleat
1.2 for 1200mm	24,535 N per cleat

As with example 1, force per distance can be compared to the cleat loop strengths and the appropriate cleat and spacing specified.

In this example, Alpha cleats (LS: 15,000) spaced every 600mm are the best option.

Before a cleat and spacing are finalised, two other factors should be considered irrespective of the short-circuit level.

1) It is strongly recommended that a system employs a fault rated cleat or restraint at a maximum spacing of 1500mm.

2) On bends and risers it is recommended that the maximum cleat spacing is 300mm.

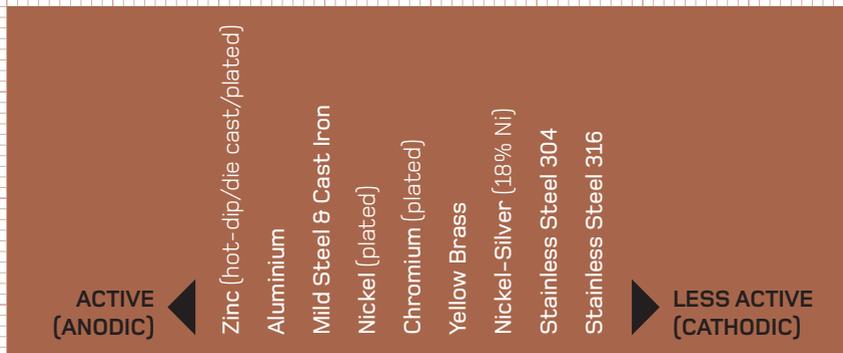
MATTERS OF CORROSION

One of the most important issues to consider when specifying cable cleats is the risk of material corrosion – not just as a result of the installation environment, but also from other metals which the cleat is in contact with.

GALVANIC CORROSION

Galvanic corrosion occurs when dissimilar metals are placed in contact with each other in the presence of an electrolyte.

There are two factors that affect the rate of galvanic corrosion, the first is the distance between the two metals in the galvanic series.



Galvanic Series



The further apart the two metals are in the series, the greater the risk of galvanic corrosion – with the metal higher up the list (more anodic) being the one whose rate of corrosion is accelerated.

The second factor to consider is the relative surface areas of the different metals.

If the more anodic (higher up the list) metal has a smaller surface area than the metal it is in contact with, the difference in surface area causes the rate of corrosion of the anodic metal to increase.

Conversely, if the more anodic metal has a much larger surface area than the cathodic metal, it may be sufficient for the effects of galvanic corrosion to be discounted.

In terms of cleat selection, the surface area of the cleat is generally significantly smaller than the structure it is mounted on.

Therefore, if it is made from a metal that is more anodic than its support structure it will be susceptible to galvanic corrosion.

Conversely, if the cleat is more cathodic than its support structure, there is little risk of galvanic corrosion.

Using this criteria, if galvanised ladder is the support structure, and there are no other significant factors, it is safe to use stainless steel or aluminium cleats. However, if the support structure is stainless steel, separation should be provided if aluminium or galvanised cleats are used.

MATTERS OF CORROSION

Galvanic corrosion is not easily predictable and can be influenced by the type of electrolytes present such as salt water or fresh water containing impurities.

In general terms when guarding against galvanic corrosion, the safest course of action is to separate dissimilar metals with polymer separation washers.

This separation should be carried out between the cleat and its mounting surface and the cleat's mounting fixing.

All Ellis products constructed from dissimilar metal are designed in a way that completely avoids bimetallic contact. As a result of this you can be confident that cable cleats will have a service life measured in decades.

STAINLESS STEEL

In general, cable cleats are manufactured from austenitic stainless steel due to its non-magnetic and corrosion resistant properties – the former ensuring the cleat won't induce eddy currents or localised heating of the cable.

Austenitic stainless steel does become a little magnetic as a result of work hardening when processed. This magnetism can barely be detected with a magnet and so is not significant from an eddy current perspective.

There are many different types of stainless steel, but there are two principal variants when it comes to cable cleats.

304 austenitic stainless steel, often referred to as A2, is one of the most commonly used stainless steels. It has excellent corrosion resistant properties in most circumstances, although is susceptible in atmospheres where chlorides are present, making it unsuitable for use in coastal or marine environments.

316 austenitic stainless steel, often referred to as A4, contains Molybdenum, which provides resistance against chlorides. 316 is often referred to as marine grade stainless steel due to its suitability for use in coastal and offshore applications.

If unsure a simple chemical test can determine whether Molybdenum is present and so differentiate between 304 and 316.

ALWAYS REMEMBER:

All Ellis stainless steel cable cleats are produced from 316L austenitic stainless steel.

304 and 316 stainless steel are available in low carbon variants, namely 304L and 316L. These variants are immune to sensitisation (grain boundary carbide precipitation).

Any cleat which is manufactured from stainless steel and includes welding in the manufacturing process should be made in a low carbon (L) variant.

MATTERS OF CORROSION

COATINGS

The corrosion resistance properties of stainless steel are a result of chromium, which reacts with oxygen and forms a self-healing impervious layer of chromium oxide on the surface of the steel.

In most circumstances the chromium oxide layer is extremely durable and helps in resisting galvanic corrosion. However, in certain installation locations, such as railway tunnels, the oxide layer can be continuously penetrated. This occurs due to trains frequently applying their brakes, which releases mild steel dust into the atmosphere that then settles on the stainless steel. If moisture is present, then corrosion occurs at an exaggerated rate.

In such circumstances, if regular washing is not feasible, use of

aluminium as an alternative to stainless steel products and/or coating processes are strongly recommended.

Ellis offers special coatings to suit specific environments – e.g. our London Underground Approved electrostatic plastic coatings.

FIXINGS

Closure fixings on cable cleats are fundamental to the loop strength of the cleat and its short-circuit withstand capability.

All Ellis 316L stainless steel cleats use 316 fixings, which are manufactured to a precise and specific tensile strength. Fixings are sourced directly from approved manufacturers and any fixing on any cleat is directly traceable back to the batch quality records at that manufacturer.

GALVANISED STEEL

Contracts often require a guarantee regarding the life expectancy of a cleat.

If the installation is designed correctly and all other corrosion issues have been considered this is a relatively simple exercise for stainless steel products.

With galvanized steel, life expectancy is determined by the thickness of the zinc coating.

The resistance of galvanizing to atmospheric corrosion depends on a protective film that forms on the surface of the zinc.

When the newly coated steel is withdrawn from the galvanizing bath, the zinc has a clean, bright, shiny surface. With time a corrosion process occurs which produces a dull grey patina as the surface

reacts with oxygen, water and carbon dioxide in the atmosphere. This leads to the formation of a tough, stable, protective layer, which is tightly adherent to the zinc.

As the corrosion process is continuous, the thickness of the zinc layer reduces over time and it is the speed of this reduction that is used to accurately predict the life span of the cleat.

MATTERS OF CORROSION

CORROSION RATES FOR THE UK

Permission to use the information relating to galvanising was granted by the Galvanizers Association for galvanized steel.

If a galvanized steel cleat is specified for use in a zone 3 area then the corrosion rate is 1.5 microns (μm) per year.

If the contract for this specification states a required life expectancy of 40 years, then the initial galvanising thickness will need to be a minimum of 60 μm in order to meet the required longevity.

Zinc corrosion rates are represented by five categories indicated by the colour codes shown below.

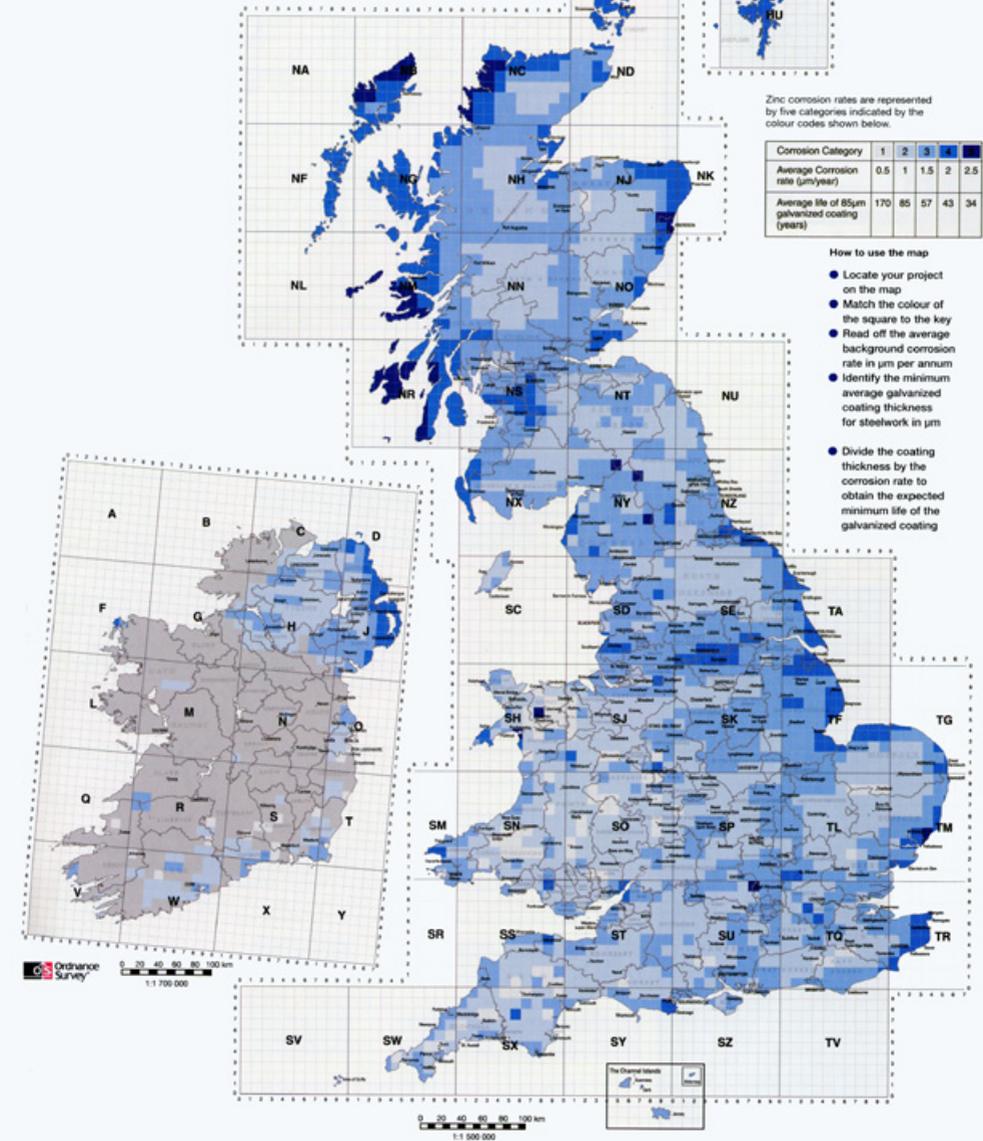
Corrosion Category	1	2	3	4	5
Average Corrosion rate ($\mu\text{m}/\text{year}$)	0.5	1	1.5	2	2.5
Average life of 85 μm galvanized coating (years)	170	85	57	43	34

ALWAYS REMEMBER:

The corrosion rate for zinc is generally linear for a given environment.

The Zinc Millennium Map

Annual Average Atmospheric Corrosion of Zinc, UK and Republic of Ireland, 1998-2000



CABLE CLEATS AND...

OPERATING TEMPERATURES

Our standard ranges of cleats are designed for use in ambient temperatures ranging from -50°C to $+60^{\circ}\text{C}$ and with cable conductor temperatures up to 90°C .

EDDY CURRENTS

Ferro-magnetic materials that completely surround single conductors in AC circuits are susceptible to heating from eddy currents.

Generally, eddy current generation at mains frequencies requires a complete electrical and ferro-magnetic circuit around each conductor. But in installations where all three phases are contained within the same cleat e.g. three cables in a trefoil cleat, the magnetic fields of

the phases cancel each other out, which in turn negates the eddy currents and the heating effect.

Despite this, it is preferable to use cleats manufactured from non-magnetic materials such as aluminium, injection moulded polymers or stainless steel, which has only very slight magnetic properties.

ALWAYS REMEMBER:

When using single cable cleats manufactured from ferro-magnetic materials care should be taken to avoid forming a complete iron loop around the cable.

MULTI-CORE CABLES

There is a commonly held belief within the electrical industry that multi-core cables will protect themselves in the event of a short-circuit, meaning their installation does not require fault rated cable cleats.

However, research shows that the forces between the conductors of a multi-core cable in the event of a fault are similar to those between three separate single core cables laid in a trefoil arrangement.

Therefore, when specifying multi-core cables it is advisable that cable manufacturer should be contacted to ascertain the ability of its specific cable to withstand these forces.

It is worth noting that whatever the withstand quoted, in the event of a significant fault an unrestrained multi-core cable will move.

Furthermore, the requirements of most wiring regulations are clear and typically state that:

“EVERY CONDUCTOR OR CABLE SHALL HAVE ADEQUATE STRENGTH, AND BE SO INSTALLED AS TO WITHSTAND THE ELECTROMAGNETIC FORCES THAT MAY BE CAUSED BY ANY CURRENT, INCLUDING FAULT CURRENT”

CABLE CLEATS AND...

FIRE

There are currently no European or IEC standards for fire rated cable clamps, although there are requirements within other standards that can be followed to prevent unsuitable products being specified.

The international standard IEC 61914 requires non-metallic and composite cleats to have adequate resistance to flame propagation.

UL94, the standard for Safety of Flammability of Plastic Materials for Parts in Devices and Appliances, is a plastics flammability standard that classifies plastics according to how they burn in various orientations and thicknesses. Adherence to its V-0 rating for polymers should be demanded by specifiers.

FOR INFORMATION:

UL94's V-0 rating means that burning stops within 10 seconds on a vertical specimen; drips of particles allowed as long as they are not inflamed.

The use of the description LSF (low smoke and fume) is common terminology with regard to polymers, but is misleading as it doesn't relate to any published standard and so can be interpreted in a wide variety of ways.

To ensure complete assurance of performance in a fire, all Ellis plastic products have undergone testing at the Building Research Establishment



Ellis Phoenix clamp undergoing independent fire rating testing

(BRE) in line with the London Underground 1-085 specification with regard to:

- Smoke emission
- Limited oxygen index
- Toxicity of fumes

The appropriate products are listed in the London Underground Approved Products register. Identification numbers are 360, 361, 362, 363, 364, 365 and 1661.

A great deal of focus is placed on fire rated (FP) cables and their performance in fire, but very little attention is given to the cable fixings used to secure these cables. Given that FP cable is typically rated for operation in temperatures ranging from 850°C to 950°C then the use of plastic cleats or clamps is clearly inappropriate.

Even aluminium only has a melting point of 660°C, which means it would fail to support FP cables in a fire.

To counteract this shortcoming, Ellis manufactures the Phoenix range of clamps for use with FP cables. Independently tested by Exova Warrington fire and BRE, all products in the range are proven to perform to the same level as the FP cables ensuring continuous operation in the event of fire.

CABLE CLEATS AND...

UV RESISTANCE

While wholly metal cleats are impervious to UV attack, composite and polymer cleats can be at risk.

Ellis composite cleats such as Emperor, Vulcan and Atlas all have polymer liners, but are designed to be impervious to UV attack because the polymer is shielded by either the cleat's body or the installed cables.

Polymer cleats that are likely to be exposed to UV should be supplied in materials containing carbon black or other UV stabilised material.

ALWAYS REMEMBER:

All cleats supplied by Ellis for applications involving UV are provided in UV resistant materials.



CABLE SYSTEM DESIGN

As a cable cleat manufacturer, we do not offer advice on the design principles and choices between different types of cable installation. We will however provide expert advice on the suitability of particular cleats within any type of installation.

FLEXIBLE AND RIGID CABLE INSTALLATIONS

On most projects a major consideration is the constant movement of the cable due to thermo-mechanical effect. To accommodate this two principal types of installation design exist:

FLEXIBLE SYSTEMS where the cables are "snaked" either vertically or horizontally. The cable can expand and contract freely between fixing points.

RIGID SYSTEMS where the cables are rigidly fixed. The longitudinal thermo-mechanical force is withstood by the combination of the stiffness of the cable, the cleat reaction force and the rigidity of the support structure.

Cable cleats are designed to withstand the forces exerted by the cable in the 'axial' direction, this is relevant to both flexible and rigid systems. It is also important when the cables are installed vertically.

RECOMMENDED READING:

CIGRE Technical Brochure
TB194

FLAT, TREFOIL AND QUADRAFOIL INSTALLATIONS

Cable arrangements for three phase installations utilising single conductor cables are typically flat spaced, flat touching or trefoil.

The 17th Edition Wiring Regulations (BS7671) provides current ratings and voltage drop values for all these arrangements. It also contains information on grouping factors and spacing between circuits to achieve thermal independence.

Additionally, IET Guidance Note No. 6 delivers valuable advice on installation arrangements where there are multiple cables per phase.

An additional method for installing single-core cables is to use quadrafoil cleats where the neutral is bundled with the three phase conductors. In this arrangement, there is no advice in BS7671 but

a report produced by ERA on behalf of Ellis delivered the following guidelines:

- Current ratings, given in BS7671, for cables in touching trefoil formation are appropriate for cables in quad bundles
- Derating factors, given in BS7671, for cables in touching trefoil formation are appropriate for cables in quad bundles
- Voltage drops for circuits in quad formation should be calculated using the values tabulated in BS7671 for cables in flat touching formation
- When considering multiple cables per phase, the advice given in Guidance Note No.6 for trefoil groups is applicable to quad bundles
- The induced voltage in the neutral conductor of a quad group is minimal and can be ignored.

FREQUENTLY ASKED QUESTIONS

HOW DO I PREVENT THREAD GALLING WHEN INSTALLING CLEATS?

Stainless steel fasteners have a propensity to “pick-up” when the two threaded surfaces slide against each other. If sufficient speed and pressure is applied to the sliding surfaces then they can weld themselves together – a phenomenon known as thread galling.

All stainless steel fixings will thread gall if there is sufficient friction.

To avoid thread galling, reduce the speed and downward pressure when closing fasteners and use lubrication where appropriate.

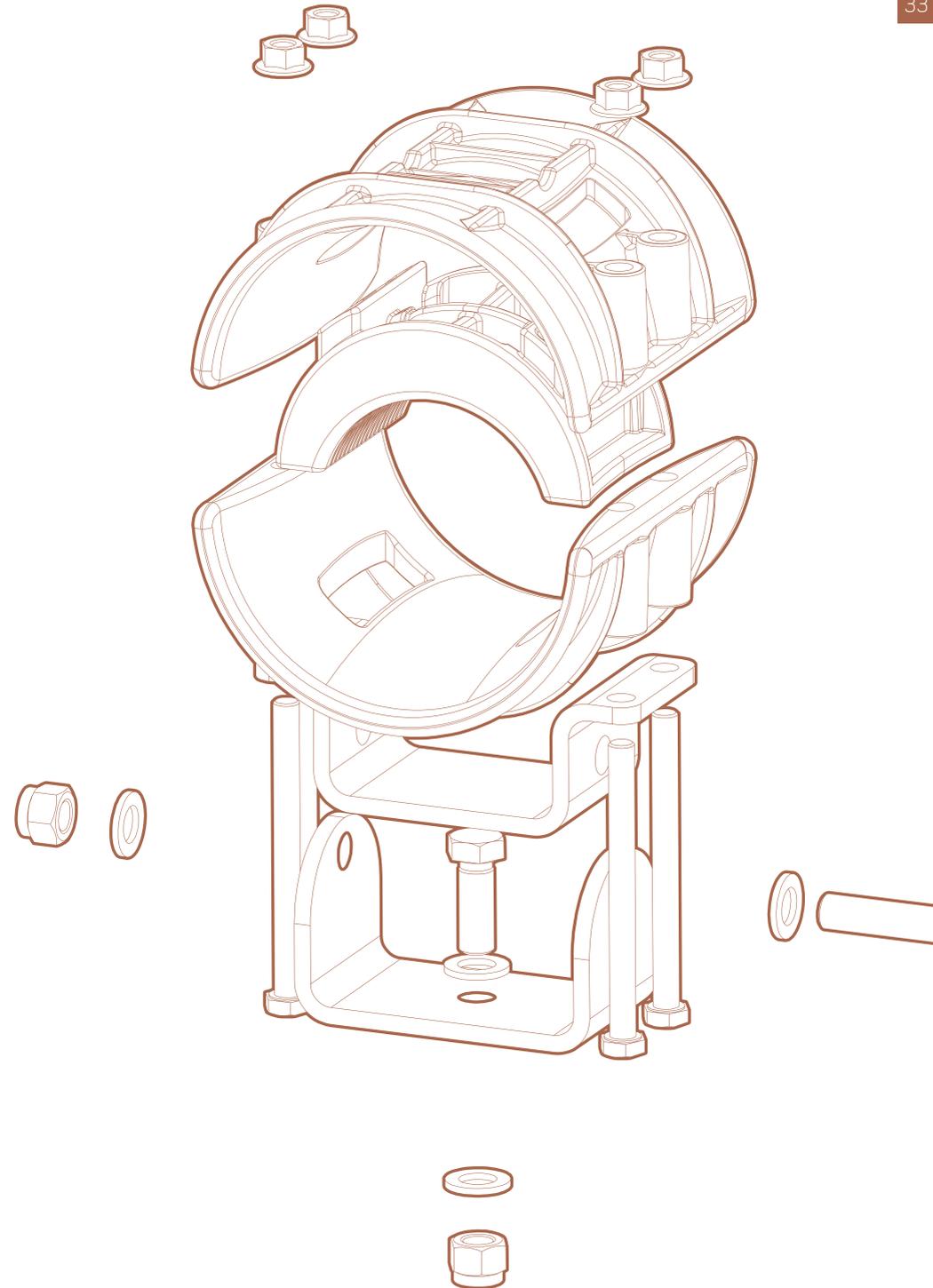
HOW TIGHT IS TOO TIGHT WHEN SECURING A CLEAT?

Cleats are generally fastened around the cable by a threaded bolt and nut, and the higher the torque when closing this fixing, the tighter the cleat’s grip on the cable.

A tight grip can be advantageous when considering axial slippage, but care needs to be taken as over-tightening can lead to damage to both the outer jacket and the construction of the cable.

As a rule of thumb, cleat fixings should be tightened until the cleat is tight around the cable without any gaps between the liner of the cleat and the cable, and with no visible damage or bulging to the outer jacket.

Specific torque recommendations can be provided upon request.



TYPE APPROVALS

Ellis holds Type Approval for a wide range of its products. These include:

DNV AND ABS TYPE APPROVAL

Both DNV and ABS are rigorous approval systems, which cover all sizes of cable cleat within a particular range. The approval process assesses all of the evidence offered by the manufacturer and compares it to the requirements of the international standard IEC 61914. Once full compliance is proven Type Approval is offered.

Regular external audits are carried out to ensure ongoing compliance.

LONDON UNDERGROUND (LUL) APPROVED PRODUCT REGISTER

Similar to DNV and ABS in that compliance to the IEC standard has to be proven, LUL approval also requires products to undergo a series of material performance tests relating to toxicity, smoke emissions and the Limiting Oxygen Index.

These tests are carried out in accordance to the relevant standards and once compliance is achieved the product becomes "compliant with the requirements of London Underground Standard 1-085". The product range is then allocated with a unique Product Register Number and placed on to the LUL Intranet system used by specifiers and buyers working on LUL projects.

UNDERWRITERS LABORATORIES (UL) LISTED

UL subjects products to a comprehensive set of tests to gauge compliance with its own Internal Technical Standards.

If only one size of cleat within a range has been tested then UL Listing applies only to that cleat at that size and not the entire range. It is the manufacturer's responsibility to clearly display in any technical brochures, websites or literature the specific part number that has been UL listed.

Regular external audits are carried out to ensure ongoing compliance.

ACHILLES FPAL

FPAL is a supplier management community that supports the European oil and gas industry and is used by major buying organisations in the sector.

Its Achilles proven supplier pre-qualification system enables buyers and specifiers to identify, pre-qualify and assess suppliers for tender opportunities, thus minimising risk within their supply chains.

BUSINESS MANAGEMENT

Ellis operates a full and comprehensive business management system, which covers:

QUALITY ASSURANCE

Ellis has ISO 9001 certification.



PM12199

ENVIRONMENTAL COMMITMENT

Ellis has ISO 14001 certification.



PM1506540

TRACEABILITY

Every cleat assembled by Ellis is given a unique serial number that can be used for identification and traceability.

From this top level reference number every item that goes into the manufacture of every single cleat can be traced back to source, including raw material and items such as nuts and bolts.



www.ellispatents.co.uk

Ellis Patents Ltd
Work Order Traveller
WORK ORDER ID: 46611/1

ELLIS
Holding Power

Work Order ID	Part ID	Part Description	Release Date	WantDate	Qty
46611/1	ER19-23	Emperor Rangetaker Set For 3 x 19-23mm	12/08/2014	15/08/2014	2

Customer ID: _____ Sales Order No: / _____ Customer Name: _____
Old Account: _____ PO Ref: _____ Del ID: _____

Specifications:

Shop Resources Type	Setup Hrs	Run Hrs
AS-P-GEN	0.25	0.05

Part ID/Sub ID	Part Description	Qty Req	Lot Used
0M-E29-27-4WP	Emperor+ Frame Size 27 W&P	2.00	_____
0F-M12-ANUT-4	M12 Serrated Flange Nut A4 Stainless	2.00	_____
0F-M12-050S-4	M12 x 50 Setscrew A4 70 Grade Stainless	2.00	_____
0U-EW-1=00000	Emperor Washer Size 1	2.00	_____
0U-EIS-1A=00000	Emperor Sheath Size 1 6mm Pad	2.00	_____
0U-EHR-3=00000	Emperor (+) Head Retainer No. 3	2.00	_____
0U-EBP1/074=00000	Emperor Base Pad 1 Depth 7.4mm	2.00	_____
0U-EBP1/056=00000	Emperor Base Pad 1 Depth 5.6mm	2.00	_____

First off check approved (assembly only): _____ Date: _____

Note: Serial No. on cleat matches the Work Order ID on the Work Order Traveller.
All appropriate batch numbers are entered onto the Work Order Traveller to give 100% traceability.

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