

Bharat Heavy Electricals Limited
FSIP Jagdishpur

Specification no: FSIP/Engg/01/2020

Date: 29/09/2020

Subject: Specification of silicon adhesive

1. APPLICATIONS

For Bonding of Ceramic tiles with MS or SS plate.

2. PROPERTIES:

- | | |
|-------------------------------------|--|
| a) Specific gravity | : 1.03 minimum |
| b) Take free time | : 10 to 15 minutes |
| c) Cure time(3mm thickness) | : 24 hours (at 25 degree Celsius and 50% RH) |
| d) Hardness(Shore "A" Paint) | : 25 to 30 |
| e) Tensile strength | : 20 Kg/cm ² Min |
| f) Coefficient of thermal expansion | : 1.12×10^{-3} |
| g) Resistance to temperature | : 175 degree Celsius |
| h) Shelf life | : Two year minimum |

3. TESTING METHODS:

Material to be tested for above properties to the relevant ASTM/DIN Standards.

5. TEST SAMPLES:

The supplier shall take appropriate quantity of sample and get the corresponding test as mentioned in Clause-2 done in an independent laboratory and produce the test certificate along with every supply.

6. TEST CERTIFICATE:

Material accompanied by test certificate should include following :

- (i) Batch no and date of manufacture.
- (ii) Actual test values and reference of the testing standard.

7. MATERIAL ACCEPTANCE :

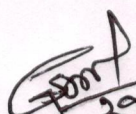
Material to be accepted based on test certificate issued as evidence of satisfactory compliance to requirement stated above.

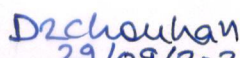
8. PACKING :

To be packed in the 300-310 ml cartridge packed in card board box to be identified with supplier name, quantity, date of expiry to be printed on cartridge.

9. REJECTION AND REPLACEMENT:

Material not conforming to the requirement shall be rejected. Supplier shall undertake to replace the material free of cost without any delay and arrange to take back the material at his own cost.


29/09/2020
Prepared By
FC (Engineering)


29/09/2020
Approved By
Head (Engineering)