



PLANT STANDARD

HPBP TIRUCHIRAPALLI

BPS: 017510

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- 3.3 Finish: Arrow and border shall be raised and bright nickel plated, followed by chromium plating according to IS: 4827. The thickness of nickel plating shall be 20 microns minimum and the chromium plating 0.3 microns minimum.

4 TEST REQUIREMENTS

- 4.1 Before finalising the purchase order the samples of the plate shall be procured and humidity test, resistant to salt spray test conducted according to corporate standard AA 040 12 02.

4.2 Accelerated weather proof test

- 4.2.1 The paint should not show any sign of deterioration when subjected to accelerated weathering test of 21 days in accordance with clause A4 of IS: 2932.

5 FIXING HOLES AND SCREWS

- 5.1 Dimensions of fixing holes, size etc shall be as shown in Figure. Screw size shall be as shown in Table 1.

6 MARKING AND PACKING

- 6.1 BPS code 017510 2075 and material code (22 074 128) shall be painted at the back of each direction plate.
- 6.2 Each direction plate should be suitably packed in polythene cover (500 microns thickness) so as to avoid any damage to the finish during transit/storing.

7 NOTE

- 7.1 The background of arrow shall be etched and finished black. The depth of etching shall be 100 to 500 microns.
- 7.2 Weight is calculated on the basis that brass weighs 8.6 kg/dm^3 .
- 7.3 Sharp edges shall be rounded off and burrs removed.

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