



## CORPORATE PURCHASING SPECIFICATION

AA56112

Rev No. 02

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## HIGH BUILD INTERMEDIATE EPOXY PAINT

## 1 GENERAL

This specification governs the quality requirements of cold cured two-pack high build intermediate epoxy paint suitable for application by brushing or spraying.

## 2 APPLICATION

This material shall be used as an intermediate coat on epoxy primed surfaces to provide high build up coating thickness so as to protect the steel and other equipment's against corrosion due to humidity, saline environment and corrosive atmosphere.

## 3 COMPLIANCE WITH NATIONAL STANDARDS

There is no national standard covering this material.

## 4 COLOUR

Dark brown

## 5 FINISH

Smooth and matt.

## 6 FREEDOM FROM DEFECTS

The components of the paint shall remain free from defects like hard settling of pigments, skinning when kept in closed container and livering (excessive viscosity build up ) during its rated shelf life.

The dried surface shall be free from defects like bittyness, floating of pigments, wrinkles, orange peel, blisters , hard particles, pin holes etc.,

## 7 CHEMICAL COMPOSITION

The material shall be based on two components epoxy system and supplied as catalysed epoxy resin pigmented with MIO & TiO<sub>2</sub> and polyamide as an accelerator or hardener for cold curing. The mixing ratio of base and accelerator shall be as per supplier's recommendations. The type and content of the binding material i.e., epoxy resin, as determined by infrared spectrography or thin layer chromatography shall be strictly same as that of "Type Approved Sample".

The supplier should provide IR-Spectrograph in support of above composition.

The supplier of the material has to certify that the paint supplied is free from natural resins and free from lead or its compound to meet requirements of ISO 14001.

## 8 TEST SAMPLE

Tender sample will not be required when once the type approval is given and the supplier concerned has to declare that the material for which the tender is given is of the same quality as the type approved sample.

Representative sample of the material shall be drawn and tested as per IS 101.

## Revisions:

As per clause 44.4 a) of MOM of MRC-CPO+NM

## APPROVED:

INTERPLANT MATERIAL RATIONALISATION  
COMMITTEE – MRC(CPO+NM)

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**CORPORATE PURCHASING SPECIFICATION****9 PROPERTIES**

Unless otherwise specified, when tested in accordance with relevant parts of IS 101, the test samples shall show the following properties:

**9.1 Consistency**

Smooth and homogenous.

**9.2 Drying Time**

Touch dry : 6 hours, max.

Hard dry : 12 hours, max.

**9.3 Mass per ten litres**

12.5-13.5 kgs.

**9.4 Non-volatile matter**

48 - 52% by weight.

**9.5 Volume Solids**

55%, min.

**9.6 Resistance to salt spray**

The panels prepared from the material shall show no sign of corrosion after continuous exposure to salt spray for a period of 7 days in the salt spray cabinet.

**9.7 Flexibility & Adhesion**

The film shall show no sign of damage, detachment or cracking when tested after 7 days curing at RT or 2 hours drying at 70 - 80°C after 24 hours air drying.

**9.8 Scratch Hardness**

The film shall show no sign of scratch so as to show the bare metal at a load of 1000 grams when tested after 7 days curing at RT or 2 hours drying at 70 - 80°C after 24 hours air drying.

**9.9 Flash Point**

Not below 25°C.

**9.10 Dry film thickness**

75-100 microns per coat as per BHEL standard AA0674105.

**9.11 Pot life**

4-6 hours, when mixed.

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## 10 TEST CERTIFICATES

Unless otherwise stated, three copies of test certificates shall be supplied along with each consignments, giving the following information.

In addition, the supplier shall ensure to send one copy of the test certificates along with the despatch documents to facilitate quick clearance of the material.

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BHEL Order No.

Manufacture's/Supplier's Name and Trade mark, if any.

Batch/Lot No.

Date of manufacture and expiry

Test results of clause 7 to 9

T.C. No and date

Mixing ratio

## 11 KEEPING PROPERTY

When stored in covered dry place in the original sealed containers under normal temperature conditions, the material shall retain the properties prescribed in this specification for a period of six months after the date of manufacture which shall be subsequent to the date of placement of BHEL order.

## 12 PACKING AND MARKING

Unless otherwise stated, base & hardener shall be packed separately in steel containers of 4 litres capacity.

Each container shall bear the following information:

AA56112: HIGH BUILD INTERMEDIATE EPOXY PAINT

BHEL Order No.

Batch / Lot No.

Supplier's/ Manufacturer's Name and Trade mark, if any

Name of components

Mixing ratio

Quantity supplied

Date of manufacture and expiry

## 13 ENVIRONMENTAL REQUIREMENTS

The supplier shall furnish Material Safety Data Sheet (MSDS) covering all information relating to human safety and environmental impacts of the hazardous materials particularly during their transportation, storage, handling and disposal along with each supply.

Each container shall be marked with corresponding symbol and minimum worded cautionary notice for flammable / corrosive / toxic / harmful / irritant and oxidizing etc. as applicable.

## 14 REFERRED STANDARDS (Latest Publications Including Amendments)

- 1) IS 101
- 2) AA0674105