

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

FOUNDRY DIVISION

DS NO : FYM/026

DEPARTMENT PURCHASING SPECIFICATION

REV. NO : 01

PAGE : 1 OF 2

THINNER (FOUNDRY GRADE) FOR MOULD PAINT

(1) GENERAL :

The specification governs the technical requirements of thinner base solvent to be used with mould paint to maintain the baume of mould paint.

(2) APPLICATION :

The thinner (Foundry Grade) shall be mixed with condensed form of graphite or zircon base mould paint to bring the paint dilution to desired baume before start of applying the paint.

(3) COMPLIANCE WITH NATIONAL STANDARD :

The material is particularly based on IS 2631 / 75.

(4) SHAPE AND SIZE :

The solvent should be on liquid form.

(5) PROPERTIES :

- | | | | |
|-----|--|---|-----------------------|
| 5.1 | Appearance | : | Colourless Liquid |
| 5.2 | Specific Gravity | : | 0.77 g/cc to 0.8 g/cc |
| 5.3 | Water content | : | 0.5% max |
| 5.4 | Boiling point | : | 62 - 70 °C |
| 5.5 | When the solvent is used for preparation of mould paint; | | |
| | a) | On lightening the solvent should burn with blue flame without creating any black smoke. | |
| | b) | No black residue and patch shall remain in mould interface after the paint is lighted. | |
| | c) | The solvent should not have any chemical reaction with the paint material. | |

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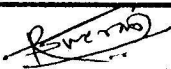
(6) ACCEPTANCE :

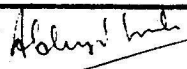
The material shall be accepted on the basis of properties as per Cl. No. 5.

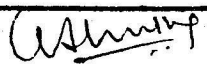
(7) PACKING :

The material shall be supplied in sealed metal or poly-carboy container, capacity 10 / 50 / 200 litres which bear the following information :

- Supplier's Name / Trade Mark, if any
- Name of product
- Date of manufacture
- Net weight & gross weight

PREPARED BY	
SIGN.	
DATE	22/02/06

CHECKED BY	
SIGN.	
DATE	22/2/06

APPROVED BY	
SIGN.	
DATE	23/2