

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

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| FOUNDRY DIVISION | DS NO : FYM/035 |
| DEPARTMENT PURCHASING SPECIFICATION | REV. NO : 01 |
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ALCOHOL BASE GRAPHITE PAINT

(I) GENERAL :

These specification governs the requirement of Alcohol base Graphite paint (Ready to use) equivalent to IVALITE GA-6 of IVP for use in sand moulds and dies for Cast Iron and Non-Ferrous alloys castings.

(II) APPLICATION :

The material shall be used in liquid form for spray coating over Die-tool surfaces and green sand moulds and hand application with brush over CO₂ sand / No-bake sand moulds for CI and NF alloy castings.

(III) COMPLIANCE WITH NATIONAL STANDARD :

The specification is based on the IS 10033, Gr. GA - ready to use alcohol base graphite wash.

(IV) SHAPE / SIZE / CONDITION OF MATERIAL :

The material shall be of uniform nature free from lumps and the liquid form shall have graphite and other ingredients thoroughly mixed with alcohol. Fixed carbon in graphite shall be 94% minimum.

(V) TESTING AND APPROVAL :

a) Settling tendency - The material shall not settle at all when left undisturbed for 1 hour after adjusted to specified baume (about $55 \pm 2^\circ$).

b) Coating Quantity - (i) The wash shall give uniform coating free from cracks after painting with flame.

(ii) The coated surface after ignition shall be free from wet patches on the surface of moulds or Die-tools.

(iii) The coating shall not peel off by gentle rubbing.

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(VI) PACKING :


Standard packing in 25 - 50 Kg. Polycarboy or plastic containers shall be done with the opening thoroughly sealed. Care shall be taken to avoid damage, during transits. Each drum shall bear the following -

- Supplies name and trade mark, if any
- Name of product
- Date of manufacturing
- Net weight
- Date of expiry, if there

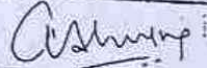
PREPARED BY

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YMRK/35-SPEC GRAPHITE PAINT