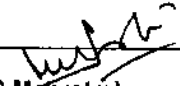
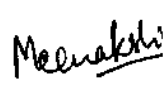


	PRODUCT STANDARD TME DIVISION, BHOPAL		TM 11487																																									
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<u>SPECIFICATION FOR "PRIMER PAINT"</u>																																												
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company	1.0 Scope : This specification covers supply of "primer" paint to be used for 3-phase traction motor type -6FRA 6068.																																											
	2.0 Technical specification :																																											
	2.1 The material shall be aqueous lead and chromate free one pack corrosion protection primer, based on vinylcopolymer resins. The product shall displays fast drying, good mechanical and corrosion protection properties.																																											
	2.2 Colour : Light Grey																																											
	2.3 Properties :-																																											
	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="text-align: center;">Sl. No.</th> <th style="text-align: center;">Properties</th> <th style="text-align: center;">Value</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">1</td> <td>Viscosity at delivery (20^o)</td> <td>2.5 - 4.5 Pa sec.</td> </tr> <tr> <td style="text-align: center;">2</td> <td>Minimum temperature for application and drying</td> <td>+ 10^oC</td> </tr> <tr> <td style="text-align: center;">3</td> <td>Maximum humidity for drying</td> <td>65% rel.h</td> </tr> <tr> <td style="text-align: center;">4</td> <td>Solid content</td> <td>Approx. 57%</td> </tr> <tr> <td style="text-align: center;">5</td> <td>Density</td> <td>Approx. 1.3Kg/l</td> </tr> <tr> <td style="text-align: center;">6</td> <td>Consumption per m² for a dry film of 40 microns (20^o)</td> <td>100g</td> </tr> <tr> <td style="text-align: center;">7</td> <td>Drying time for a dry film of 40 microns</td> <td rowspan="4">30 min. 30 min. 4 hrs. 2 hrs.</td> </tr> <tr> <td style="text-align: center;">(a)</td> <td>Dust free after</td> </tr> <tr> <td style="text-align: center;">(b)</td> <td>Touch dry after</td> </tr> <tr> <td style="text-align: center;">(c)</td> <td>Recoatible by spraying after</td> </tr> <tr> <td style="text-align: center;">(d)</td> <td>Through dry after forced drying at 40^o to 80^o C possible</td> <td>2 hrs.</td> </tr> <tr> <td style="text-align: center;">8</td> <td>Storability in sealed unopened container (20^o C)</td> <td>6 months</td> </tr> <tr> <td style="text-align: center;">9</td> <td>VOC content at delivery</td> <td>< 5%</td> </tr> </tbody> </table>					Sl. No.	Properties	Value	1	Viscosity at delivery (20 ^o)	2.5 - 4.5 Pa sec.	2	Minimum temperature for application and drying	+ 10 ^o C	3	Maximum humidity for drying	65% rel.h	4	Solid content	Approx. 57%	5	Density	Approx. 1.3Kg/l	6	Consumption per m ² for a dry film of 40 microns (20 ^o)	100g	7	Drying time for a dry film of 40 microns	30 min. 30 min. 4 hrs. 2 hrs.	(a)	Dust free after	(b)	Touch dry after	(c)	Recoatible by spraying after	(d)	Through dry after forced drying at 40 ^o to 80 ^o C possible	2 hrs.	8	Storability in sealed unopened container (20 ^o C)	6 months	9	VOC content at delivery	< 5%
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Date:	Distribution	Qty.	Prepared:	Checked:	Date:																																							
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<p>COPYRIGHT AND CONFIDENTIAL</p> <p>The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED It must not be used directly or indirectly in any way detrimental to the interest of the company</p>	<p>3.0 Packing :-</p> <p>The packing shall be metal container of 20Kg, properly coated with non reactive (with varnish) coating and secured with sealing. The packing shall be labelled with the following information:-</p> <ul style="list-style-type: none"> i) Name of Paint ii) Maker's Name iii) Batch No. & Date of manufacture iv) Shelf life v) Gross and net weight. <p>4.0 This specification is equivalent to CLW's specification no. 4TMS.096.019.</p>	