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ACTION 4		DATE 12/10/2021	
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1	Approved	3	Returned with Comments. Please Resubmit.
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01	07.10.2021	SECOND SUBMISSION	UDAY	PVSB	AMAN
00	04.08.2021	FIRST SUBMISSION	UDAY	PVSB	AMAN
REV	DATE	DESCRIPTION / NOTE	PRD	CHD	APD

REVISIONS

DRAWING TITLE: PAINTING SCHEDULE OF WET BALL MILLING SYSTEM AND SILO

**OWNER/
PROJECT:**



NLC TAMILNADU POWER LIMITED (NTPL)
2X500 MW COAL FIRED UNITS AT TUTICORIN
FGD SYSTEM PACKAGE



**EPC CONTRACTOR:
BHARAT HEAVY ELECTRICALS LTD.**



**CONSULTANT:
M/s DEVELOPMENT CONSULTANTS PVT LTD**

	NAME	DATE	
PREPARED BY	UDAY		STATUS : FOR APPROVAL
CHECKED BY	PVSB		
APPROVED BY	AMAN		REV NO : 01

DRG./DOC NO. : HY-PS-NTPL-WBM-00

*Painting scheme of Wet Ball
Milling system:
Shop manufactured Items*

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Shop manufactured Items

Revision : 01 - Date : 07.10.2021

Shop manufactured Items

Shop manufactured jobs

Sl. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT External surface	Colour shade for external surface	Remarks
1	Mill Shell - Internal surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.		Not applicable (NA) since rubber lining being installed across surface of internal surface	NA	NA	
2	Mill shell - External surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
3	Support bearing housing- Internal surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.		Not applicable (NA) as surface shall be in permanent contact with oil	NA	NA	
4	Support bearing housing- External surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
5	Ball charging hopper and ball charge chute	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
6	Material inlet & outlet - Internal surface - Rubber lining	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	Not applicable since rubber lining being installed across surface of internal surface			NA	Not applicable since rubber lining being installed across surface of internal surface.

Sl. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT External surface	Colour shade for external surface	Remarks
7	Material inlet & outlet - External surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
8	Base frame of Pinion shaft assembly: Un-machined surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	All unmachined surfaces
9	All Machined surface - Ball Mill		Tectyl 506 / standard rust preventive /equivalent			NA	NA	Temporary protection for machined surface. Includes all components i.e. Pinion; Shaft; bearing shoe; drive bearing; mill web portion; girth gear and base frame etc.
10	Girth gear - Un-machined surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
11	Spherical Roller Bearing & Adapter Sleeve (for Pinion Shaft Assembly)		As per OEM Standard				NA	Final coat is not applicable as surface shall be in permanent contact with oil
12	Anti-Friction Bearing Housing (for Pinion Shaft Assembly)	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	

Sl. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT External surface	Colour shade for external surface	Remarks
13	Girth Gear guard - Internal surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyuethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
14	Girth Gear guard - External surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyuethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
15	Fastners & hardware/ foundation bolts	NA	NA	NA	NA	NA	Shall be applied with temporary oil.	

*Painting scheme of Wet Ball
Milling system:
out-sourced (BOHT) Items*

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
1	GearBox							
i.	Main Gear Box (GB)	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	
ii.	Base Frame (GB + Motor)	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
iii.	Inching Reducer	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	

iv.	Base Frame (GB + Motor + Brake)	Commercial blast Swedish Std. SA2.5	<p>One coat of two component moisture curing zinc (ethyl) silicate primer coat.</p> <p>Dry film thickness (DFT) 50 microns</p>	<p>One Coat of epoxy glass flake (high build) paint.</p> <p>Dry film thickness (DFT): 100 microns</p>	<p>Two coats of two pack aliphatic polyurethane paint</p> <p>Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)</p>	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only
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FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
2	Lubrication System - Support Bearing							
i.	Tank	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Shade: Grey White RAL 9002. Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only
ii.	Base Frame	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns.	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats).	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
3	Lubrication System - Girth Gear							
i.	Drum Cover, AMU Plate, Spary Panel Plate	All CS surfaces - Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns.	Two coats of two pack aliphatic polyurethane paint. Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only
4	Hydro-Cyclone & Slurry Pumps							
i.	Slurry Pumps	Power tool cleaning to St3(SSPC-SP3)	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
ii.	Hydro-cyclone	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only
5	Weigh Feeder							
i.	Weigh Feeder Assembly	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only
ii.	Rod Gate	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
iii.	Connecting Chute	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only
iv.	Vent Hood	SS Parts are not painted						
v.	Damper Gate	SS Parts are not painted						
vi.	Transition Chute	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	The mention DFT shall be maintain on blasted surface only

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
vii.	Stool	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	
6	Pneumatic Diverter Gate							
i.	Valve	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
ii.	Actuator	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	
7	Motorized Slide Gate							
i.	Motorized Slide Gate	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
8	Agitator							
	Agitator	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	
9	Mill Circuit Tank (including Agitator Support)							
	Mill Circuit Tank (including Agitator Support)	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
10	Slurry Pipe & Fittings (Temp < 90°C)							
	Slurry Pipe & Fittings (Temp < 90°C)	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns.	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	
	Slurry Pipe & Fittings (Temp < 90°C)	For FRP Pipes & Fittings- painting is not applicable						
11	Process Water & Cooling Water - Pipe & Fittings (Temp < 90°C)							
	Process Water & Cooling water Pipe & fittings (Temp < 90°C) (For External surface only)	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns.	Two coats of two pack aliphatic polyurethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Shade: Grey White RAL 9002	

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
12	Instrument Air Pipe & Fittings (Temp < 90°C)							
	Instrument Air Pipe & Fittings (Temp < 90°C)	GI Pipes & Fittings will be used for Slurry application. Hence, painting is not applicable						
13	All Valves (Temp < 95°C)							
	All Valves (Temp < 95°C) (For External surface only)	Commercial blast Swedish Std. SA2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyurethane paint Shade: Grey White RAL 9002. Dry film thickness (DFT) 70 microns (35 micron X 2 Coats).	220	Shade: Grey White RAL 9002	

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Wet Ball Milling system Outsourced (BOHT) Items

Revision : 1 - Date : 07.10.2021

Outsourced (BOHT) Items

S. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT - External surface	Colour shade for external surface	Remarks
14	All Electrical & Instrumentation Items (applicable for Wet Ball Mill FGD Package)							
	All Electrical & Instrumentation Items (applicable for Wet Ball Mill FGD Package)	Standard Bought out (BOHT) item. Color shade & DFT shall be maintained as per manufacturer standard. 1. Color of Panel, if any, shall be Interior : Glossy white with fire resistant paint and External : Light grey RAL 7032. 2. For Surface Preparation and Painting clause 4.01.00 and 4.02.00 of Vol. II-E/Section-III shall be followed. 3. Color of JB, if any, shall be Interior : Glossy white with fire resistant paint and External : Light grey RAL 7032.						
15	Rubber liners, grinding media, stainless steels, rubber parts, ERW Pipes, forging /casting							
	Rubber liners, grinding media, stainless steels, rubber parts, ERW Pipes, forging /casting	Painting not applicable.						
NOTE:								
1. The above equipment wise painting scheme given for major system covering broader level items. As regard other small components and misc. items not covered above, then painting scheme/colour shade shall be deemed to be considered as per relevant sections.								
2. No painting for FRP Pipes, FRP pipe fittings, SS, Aluminium, non-ferrous, stainless steel and galvanized items.								

***Painting scheme of Silo,
Passenger cum bucket elevator
for silo, Air canons and Dust
extraction System items.***

FGD_NLC TAMILNADU POWER LTD 2X500MW, TUTICORIN

Painting Scheme : Silo, Passenger cum goods elevator for silo structure, air cannons and Bag filter

Revision : 01 - Date : 07.10.2021

Silo Items

Sl. No.	Description	Surface Preparation	Primer Coat	Intermediate Coat	Finished Coat	Total DFT External surface	Colour shade for external surface	Remarks
1	Limestone Silo - Internal surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns.	NA	NA	NA	NA	
2	Limestone Silo - External surface	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyuethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
3	Passenger cum goods elevator and accessories	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyuethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
4	Bag filter	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyuethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	
5	Air Canons	Commercial blast Swedish Std SA 2.5	One coat of two component moisture curing zinc (ethyl) silicate primer coat. Dry film thickness (DFT) 50 microns	One Coat of epoxy glass flake (high build) paint. Dry film thickness (DFT): 100 microns	Two coats of two pack aliphatic polyuethane paint Dry film thickness (DFT) 70 microns (35 micron X 2 Coats)	220	Grey White RAL 9002	