

DATE:26/ 10/ 22

**Revised Scope of work for Abradable Coating on Balance Drum Seal**

**W.o.** 1044302700 & 1644302701

**Drg no.** 23312400275-00

**Technical data:**

1. Base material specification -HY19399
2. Coating Specification:TC72075

**Facilities required:**

1. Plasma coating machine with turn table attachment
2. 3MB or 11 MB Plasma gun
3. Surface preparation facilities and media-

**BHEL scope of work:**

1. The coating material and actual component in finished machined condition will be supplied by BHEL.
2. The material for three test coupons (Plate sample of approx. 50 x 60 x 10mm) will be supplied by BHEL.
3. Test on TWO test coupons will be done by BHEL.

**Vendor scope of work:**

1. Surface preparation and coating on three test coupons before initiating the coating process on actual part.
2. Vendor shall send two test coupons to BHEL for inspection.
3. The test on 3rd test coupons will be performed by vendor and result shall be submitted to BHEL.

4. Vendor shall proceed for the abrasible coating on actual components only after successfully acceptance of test coupons by BHEL.
5. Surface preparation and coating on the actual component as per drg & spec requirement.
6. Packing and Dispatch to BHEL.

**Inspection:**

1. On abrasible coated seal:

- a. Visual Examination as per para 7.1.1 of TC72075-00.
- b. Dimensional Inspection.

2. On test Coupon:

- a. Visual Examination as per para 7.1.1 of TC72075-00.
- b. Micrographic examination as per para 7.1.4 of TC72075-00.
- c. The test result must meet the requirement of table 1. Refer TC72075-00.

**Documentation:** Vendor shall submit the following document along with coated component

- a) Test result on the 3rd test coupon
- b) Dimensional report of the seal .

**Packing and Dispatch:** The component after coating shall be suitably packed to avoid any mechanical damages during transport.

The component shall be jointly inspected by vendor & BHEL QC before dispatch.

Note: In case of any deviation repair work has to be taken up by vendor only.

Prepared By

Shesh Kumar

Manager/ TC Technology