

Schedule

1.0	Scope of Supply	Qty	Vendor Comments
1.1	ACID PICKLING BATH TANK AS PER DRG:1-7-2600-03-02191 and BILL OF MATERIAL DRG: 4-7-2600-03-02988 MATERIAL: Fe410WA IS:2062 TOTAL WEIGHT: 5636 Kg	2 Nos	
2.0	Vendor scope		Vendor Comments
2.1	<p>ACID PICKLING BATH TANK AS PER DRG:1-7-2600-03-02191 and BILL OF MATERIAL DRG: 4-7-2600-03-02988 MATERIAL: Fe410WA IS:2062 TOTAL WEIGHT: 5636 Kg</p> <p>Shot blasting to SA 2 1/2 std and then Immediately after blast cleaning of metal surface, resin primer of 300 gm/sqm to be given. Followed by 3 layers of chopped strand mat of 450 gm/sqm density to be laid while glass: resin ratio of 30:70. Final surface mat layer (30gm/sqm) to be provided with 1:10 glass resin ratio. Final resin coat to be provided. With above layers, we can get the thickness not less than 3mm</p>		
2.2	<p>RP work will be carried out as per following procedure</p> <p>Procedure of FRP lining a). Surface preparation. i) Oil, grease to be removed from the metal surface to be lined. ii) All surfaces to be lined shall be blast cleaned to Sa 2 ½ (Swedish std SIS 05 5950) iii) All dust residues and debris left on the surface after blast cleaning should be removed by brushing and vacuum cleaning. b) i) Immediately after blast cleaning of metal surface, resin primer of 300 gm/sqm to be given. ii) Followed by 3 layers of chopped strand mat of 450 gm/sqm density to be laid while glass: resin ratio of 30:70. iii) Final surface mat layer (30gm/sqm) to be provided with 1:10 glass resin ratio. iv) Final resin coat to be provided. With above layers, we can get the thickness not less than 3mm.</p>		

2.3	<p>Resin: - Isophthalic polyester resin should be used for Hcl environment.</p> <p>The contractor shall furnish documents for the material of Isophthalic resin, which will indicate the name of manufacture, batch no, and date of manufacturing etc., along with the supply.</p>	
2.4	<p>Inspection of the FRP lining will be done by BHEL official in stages, before and after FRP lining.</p> <p>Clearance to be obtained before dispatch.</p>	