

Annexure-A2
(Check List for enlistment of NON-BHEL approved blasting and painting sources)

BHARAT HEAVY ELECTRICALS LIMITED, TIRUCHIRAPALLI						
OUTSOURCING						
Facility Check List - Blast Cleaning and Painting						
Firm Name, Address and Contact No.:						
Part-A (Mandatory)						
SI No	Parameter for evaluation	Minimum Required	As given by Firm	BHEL's Observations	Remarks	Ok/Not Ok
1	Land area	1 acre (for firms applying exclusively for blasting & painting).				
2	Covered shed	1 No. L = 12 m, H x W = 6 m x 4 m with suitable exhaust arrangement (with minimum two sides covered apart from roof) (Exclusive for blasting / painting)				
3	Handling Facility	EOT / Mobile Cranes - 12 MT min / as per job requirement (Mobile crane may be owned or leased)				
4	Qualified/Certified painter	1 Person				
5	Certified personnel for surface coating inspection	1 Person				
6	Blasting facilities	a. Centrifugal * (electrically operated) or Compressor - 1 No. with Flow: minimum 250 CFM, Air outlet pressure: 7 Kg/cm ² , b. Oil separator / Water separator (inbuilt in compressor or separate unit) c. Blasting nozzles with throat size of min 7 mm (Venturi or Straight bore and 45 deg taper type along with taper gauge to check nozzle size)				

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Sl No	Parameter for evaluation	Minimum Required	As given by Firm	BHEL's Observations	Remarks	Ok/Not Ok
* - centrifugal setup must be with electrical motors & auxiliaries in an arrangement to obtain a blasting finish of SA 2.5 with profile roughness of 30-50 micron. For centrifugal setup, blasting chamber size shall be 1500 x 1500 mm ² (minimum).						
7	Abrasive media for blasting	Cu. Slag/Steel Shots/Steel grits				
8	Paint filters	80-100 micron (Nylon mesh / Muslin cloth)				
9	Blotter testing facility to check quality of compressed air	1 No. (Test kit)				
10	Airless spray equipment with suitable nozzles (eg. 2xx, 3xx, 4xx, etc)	1 Set mandatory				
11	Powered agitators (Electrical or pneumatic) for proper mixing of paints	1 No.				
12	Solvents used for degreasing	Organic solvent / Alkaline cleaner				
13	Measuring instrument for surface roughness	Surface Profile meter (0-100μ) (Elcometer)- 1 No.				
14	For measurement of temperature for dew point & Relative Humidity (RH)	Digital measurement of RH / whirl type (dry bulb, wet bulb, RH chart)				
15	For measurement of metal temperature	Thermocouple - Contact type / Laser type				
16	Coating thickness gauge	For wet film thickness - Comb gauge - 1 No. and For dry film thickness - DFT Meter - 1 No. (0-500 micron) (Elcometer/ Defelsko)				
17	Adhesion test: Cross / X-Cut test as per ASTM D3359 with pressure sensitive tape	1 set				
18	Surface cleanliness check for dust: Tape Test	1 set				
19	Surface contamination check instrument (any method to identify salt contamination)	1 set				
20	Log book	Record book				

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21	Lab / Separate room to store all analytical gauges, measuring devices and consumables.	1 No.				
22	Safety appliances / masks for spray painting and other PPEs	For all personnel engaged				
23	Availability of Pictorial Std for blasting profile and for rust grades	NACE or ISO 8501-1				
24	Shade Card	As per IS 5 (eg: Shade no: 176, 692, etc)				
NOTE_1:						
A. Items in Sl.no: 13 to 16 and 19 must have valid calibration certificate from any NABL accredited lab.						
Part-B: Final Recommendation (for BHEL use only)						
Recommendation after document verification:						
Recommendation after final assessment:						
Assessor-1 (Final assessment):			Assessor-2 (Final assessment):			
Important Notes :						
01	Part-A requirement is a must for qualifying the firm. Hence, filling up all evaluation parameters is a must and shall be available at the time of spot visit					