



CORPORATE PURCHASING SPECIFICATION

AA 536 29

Rev. No. 01

PREFACE SHEET

THINNER BASE SOLVENT FOR MOULD PAINT

FOR INTERNAL USE ONLY
REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS

Comparable Standards:

1. INDIAN :

Suggested/Probable Suppliers and Grades:

1. Refer Plant vendor directory.

User Plants /References:

1. HEEP, HARDWAR :
2. BHOPAL :
3. HYDERABAD :

Revisions :

As per 23rd MOM of MRC-FN

APPROVED :

INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (FN)

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Dt: 06.09.2011

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JUNE 2005



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THINNER BASE SOLVENT FOR MOULD PAINT

1.0 GENERAL

This specification governs the quality requirements of thinner to be used as solvent with mould paint to maintain the baume of mould paint.

2.0 APPLICATION

The thinner shall be mixed with powder, paste or very condensed form of mould paint to bring the paint dilution to desired baume level before use.

3.0 COMPLIANCE WITH NATIONAL STANDARD (redraft)

The material is partially based on IS: 2631 - 1976 : specification for Iso-propyl alcohol.

4.0 FORM

The solvent shall be in liquid form.

5.0 PROPERTIES (Redraft)

5.1 **Appearance:** Water like transparent clear colourless liquid

5.2 **Specific Gravity:** 0.77 g/cc to 0.8 g/cc

5.3 **Water content:** 0.5% max. by mass

5.4 **Boiling point:** 62–70°C

5.5 When the solvent is used for preparation of mould paint:

- a) It should not leave any wet patch on painted surface after being lighted up.
- b) On lighting the solvent part should burn with blue flame without creating any black smoke.
- c) No black residue should be left on mould surface after the solvent has burnt off.
- d) The solvent should not have any chemical reaction with the mould material or mould paint.

6.0 ACCEPTANCE (Redraft)

The material shall be accepted on the basis of the properties as per Cl. No. 5.1, 5.2, 5.3, 5.4, 5.5

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7.0 Test Certificates

7.1 Unless otherwise specified, one original and three copies of original manufacturer’s test certificates must be supplied alongwith each consignment. In addition, the supplier shall ensure to send one copy of test certificates along with the dispatch documents to facilitate quick change of the material.
The certificates shall bear the following information:

- a. Specification No. & item description
- b. BHEL PO No. with Date
- c. Supplier reference / trade mark, if any
- d. Identification No. / Batch No.
- e. Date of manufacture
- f. Test results
- g. Any other specific information which the supplier would like to convey.

7.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer’s test certificate with linkage to supplier’s invoice stating the batch No., Lot No., etc. of the supply.

8.0 INSPECTION, DEVIATION & REPLACEMENT

8.1 BHEL reserves the right to inspect material at site before despatch. However inspection at BHEL shall be final. The supplier shall offer BHEL’s representative all reasonable test facilities, without charge to satisfy the latter that the material is being furnished in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed test elsewhere. The supplier shall notify BHEL in advance about the readiness of the material for inspection and testing.

8.2 If the material received at BHEL is not found in accordance with the requirements, it shall be rejected and the supplier will have to replace it free of cost at the earliest.

8.3 For any deviation from the specification demanded by the supplier prior approval of BHEL must be obtained in writing.

9.0 Packing and Marking

Packing shall be that of the original manufacturer. The material shall be supplied in suitable air tight container, capacity 10 to 50 litres. The material of the container should not have any reaction with the thinner. Each container shall bear the following information legibly marked or labelled.

- (a) Supplier's name and trade mark, if any.
- (b) Name of the product
- (c) Date of manufacture
- (d) Shelf life
- (e) Batch No./ Identification No.
- (f) Net Weight