

1. General points related to materials

- a. All Primers will be applied on steel surfaces blast cleaned to SA 2.5.
- b. All parameters as indicated are at Room Temperature.
- c. Method of application: Brush, Air spray and Airless spray.
- d. For Primer and Intermediate Paints, the finish should be smooth matt, whereas for Finish Paints the finish should be full gloss.
- e. Paint consistency should be smooth and homogeneous.
- f. For all paints –
Test certificate and guarantee certificate to be furnished along with supply. The material shall be procured in line with paint procurement check list and quality procedure released by BHEL-BAP/Quality. Pre-despatch inspection to be offered to BHEL/BHEL authorised inspection agency.
Each container must have following information available on it.
Material name
BHEL material code
Colour
Volume of solids in %
Paint-hardener mixing proportions
Batch no.
Expiration date
BHEL order number
Test Results (Acceptable/Unacceptable)
BHEL-BAP/Ranipet use only
- g. For all thinners –
Test certificate and guarantee certificate to be furnished along with supply. The material shall be procured in line with paint procurement check list and quality procedure released by BHEL-BAP/Quality. Pre-despatch inspection to be offered to BHEL/BHEL authorised inspection agency.
Each container must have following information available on it.
Material name
BHEL material code
Colour
Batch no.
Expiration date
BHEL order number
Test Results (Acceptable/Unacceptable)
BHEL-BAP/Ranipet use only

2. Safety points

Along with each supply the supplier shall furnish Material Safety Data Sheet (MSDS) covering information relating to human safety and environmental impacts of the hazardous materials particularly during, transportation, storage, handling and disposal.
Each container shall be marked with corresponding symbol and minimum worded cautionary notice for flammable / corrosive / toxic / harmful / irritant and oxidizing etc. as applicable.

3. All suppliers shall qualify the PQR criteria.

SNO.	1
MATERIAL CODE	IM1290000100
MATERIAL DESCRIPTION	INORGANIC ZINC ETHYL SILICATE PRIMER PAINT, SV 60%, GREY, WITH TOTAL METALLIC ZINC CONTENT 75% IN DRY FILM OF DFT 75 MICRONS, MIN. ZINC DUST COMPOSTION QUALITY SHALL BE TYPE II AS PER ASTM D520-00.
MINIMUM VOLUME OF SOLIDS	60%
TOTAL METALLIC ZINC CONTENT	75%, min. by weight in non-volatile portion of the paint
DFT MICRONS PER COAT	75μ
MINIMUM OVERCOAT INTERVAL, HRS, MAX	24
MAXIMUM OVERCOAT INTERVAL	TO BE SPECIFIED BY SUPPLIER
COLOUR SHADE	GREY
PACK SYSTEM	2 PACK (HARDENER+BASE)
PACKING SIZE	20 L
APPLICABLE STANDARD	IS 14946
APPLICABLE QUALITY PLAN	MQP:IEZS:PMR REV: 01 DATE: 22.07.2020
MINIMUM SHELF LIFE IN MONTHS	6 FROM DATE OF RECEIPT AT BHEL STORES.

SNO.	2
MATERIAL CODE	IM1290006100
MATERIAL DESCRIPTION	INORGANIC ZINC ETHYL SILICATE PRIMER PAINT, SV 60%, GREY, WITH TOTAL METALLIC ZINC CONTENT 80% IN DRY FILM OF DFT 75 MICRONS, MIN. ZINC DUST COMPOSTION QUALITY SHALL BE TYPE II AS PER ASTM D520-00.
MINIMUM VOLUME OF SOLIDS %	60
DFT MICRONS PER COAT	75
MINIMUM OVERCOAT INTERVAL, HRS, MAX	24
MAXIMUM OVERCOAT INTERVAL	TO BE SPECIFIED BY SUPPLIER
COLOUR SHADE	GREY
PACK SYSTEM	2 PACK (HARDENER+BASE)
PACKING SIZE	20 L
APPLICABLE STANDARD	IS 14946
APPLICABLE QUALITY PLAN	
MINIMUM SHELF LIFE IN MONTHS	6 FROM DATE OF RECEIPT AT BHEL STORES.
SNO.	3
MATERIAL CODE	IM1200132700
MATERIAL DESCRIPTION	EPOXY BASED POLYAMIDE CURED MICACIOUS IRON OXIDE (Fe ₂ O ₃) INTERMEDIATE PAINT, SV 60%, DARK BROWN.
MINIMUM VOLUME OF SOLIDS %	60

DFT MICRONS PER COAT	80
TOUCH DRY, HRS, MAX	6
MINIMUM OVERCOAT INTERVAL, HRS, MAX	12
MAXIMUM OVERCOAT INTERVAL	TO BE SPECIFIED BY SUPPLIER
COLOUR SHADE	DARK BROWN (IS 5, 412)
PACK SYSTEM	2 PACK (HARDENER+BASE)
PACKING SIZE	20 L
Fe₂O₃ BY MASS, MIN	50%
LAMELLAR MIO IN PIGMENT, MIN	30%
POT LIFE	4-6 HRS
FLASH POINT, MIN	25 DEGREES C
APPLICABLE STANDARD	N/A
APPLICABLE QUALITY PLAN	MQP:EPX MIO REV 00 dated 18.07.2020
MINIMUM SHELF LIFE IN MONTHS	11 FROM DATE OF RECEIPT AT BHEL STORES.

SNO.	4
MATERIAL CODE	IM1200132900
MATERIAL DESCRIPTION	EPOXY BASED POLYAMIDE CURED MICACIOUS IRON OXIDE (Fe ₂ O ₃) INTERMEDIATE PAINT, SV 80%, DARK BROWN.
MINIMUM VOLUME OF SOLIDS %	80
DFT MICRONS PER COAT	100
TOUCH DRY, HRS, MAX	6
MINIMUM OVERCOAT INTERVAL, HRS, MAX	12
MAXIMUM OVERCOAT INTERVAL	TO BE SPECIFIED BY SUPPLIER
COLOUR SHADE	DARK BROWN (IS 5, 412)
PACK SYSTEM	2 PACK (HARDENER+BASE)
PACKING SIZE	20 L
Fe₂O₃ BY MASS, MIN	50%
LAMELLAR MIO IN PIGMENT, MIN	30%
POT LIFE	4-6 HRS
FLASH POINT, MIN	25 DEGREES C
APPLICABLE STANDARD	N/A
APPLICABLE QUALITY PLAN	MQP:EPX MIO REV 00 dated 18.07.2020
MINIMUM SHELF LIFE IN MONTHS	11 FROM DATE OF RECEIPT AT BHEL STORES.

SNO.	5
MATERIAL CODE	IM1200300300
MATERIAL DESCRIPTION	EPOXY BASED POLYAMIDE CURED FINISH PAINT, SV 40%, SMOKE GREY.
MINIMUM VOLUME OF SOLIDS %	40
DFT MICRONS PER COAT	35μ
MINIMUM OVERCOAT INTERVAL, HRS, MAX	24
MAXIMUM OVERCOAT INTERVAL	TO BE SPECIFIED BY SUPPLIER
COLOUR SHADE	SMOKE GREY (IS5, 692)
PACK SYSTEM	2 PACK (HARDENER+BASE)
PACKING SIZE	20 L
APPLICABLE STANDARD	IS 14209

APPLICABLE QUALITY PLAN	MQP:EPX:ENA REV:01 DATE: 18.07.2020
MINIMUM SHELF LIFE IN MONTHS	11 FROM DATE OF RECEIPT AT BHEL STORES.

SNO.	6
MATERIAL CODE	IM1200642000
MATERIAL DESCRIPTION	ALIPHATIC ISOCYANATE CURED ACRYLIC POLYURETHANE FINISH PAINT, SV 60%, GREY WHITE, with gloss retention (SSPC paint spec no.36, ASTM D4587, D2244, D523 of level 2 after min.1000 hours of exposure. Gloss loss less than 30 and colour change less than 2.0ΔE)
MINIMUM VOLUME OF SOLIDS %	60
DFT MICRONS PER COAT	40
MINIMUM OVERCOAT INTERVAL, HRS, MAX	8
MAXIMUM OVERCOAT INTERVAL	TO BE SPECIFIED BY SUPPLIER
COLOUR SHADE	GREY WHITE (RAL 9002)
PACK SYSTEM	2 PACK (HARDENER+BASE)
PACKING SIZE	20 L
APPLICABLE STANDARD	IS 13213
APPLICABLE QUALITY PLAN	MQP NO AAC PLU REV 01 DATED 21.07.2020
MINIMUM SHELF LIFE IN MONTHS	11 FROM DATE OF RECEIPT AT BHEL STORES.

SNO.	7
MATERIAL CODE	IM1299900100
MATERIAL DESCRIPTION	THINNER FOR INORGANIC ZINC ETHYL SILICATE PRIMER PAINT, CLEAR.
FLASH POINT NOT LESS THAN	20 DEGREES C
SPECIFIC GRAVITY	0.8 (APPROX.)
COLOUR SHADE	CLEAR
PACK SYSTEM	1 PACK
PACKING SIZE	20 L
APPLICABLE STANDARD	N/A
APPLICABLE QUALITY PLAN	MQP No: TNR:GP Rev No: 00 Dt: 28/07/2020
MINIMUM SHELF LIFE IN MONTHS	11 FROM DATE OF RECEIPT AT BHEL STORES.

SNO.	8
MATERIAL CODE	IM1200300900
MATERIAL DESCRIPTION	THINNER FOR EPOXY BASED POLYAMIDE CURED INTERMEDIATE (MIO) AND FINISH PAINT, CLEAR.
FLASH POINT NOT LESS THAN	20 DEGREE C
SPECIFIC GRAVITY	0.8 (APPROX.)
COLOUR SHADE	CLEAR
PACK SYSTEM	1 PACK
PACKING SIZE	20 L
APPLICABLE STANDARD	N/A
APPLICABLE QUALITY PLAN	MQP No: TNR:GP Rev No: 00 Dt: 28/07/2020

MINIMUM SHELF LIFE IN MONTHS	11 FROM DATE OF RECEIPT AT BHEL STORES.
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SNO.	9
MATERIAL CODE	IM1200650000
MATERIAL DESCRIPTION	THINNER FOR ALIPHATIC ISOCYNATE CURED ACRYLIC POLYURETHANE FINISH PAINT, CLEAR.
FLASH POINT NOT LESS THAN	20 DEGREE C
SPECIFIC GRAVITY	0.8 (APPROX.)
COLOUR SHADE	CLEAR
PACK SYSTEM	1 PACK
PACKING SIZE	20 L
APPLICABLE STANDARD	N/A
APPLICABLE QUALITY PLAN	MQP No: TNR:GP Rev No: 00 Dt: 28/07/2020
MINIMUM SHELF LIFE IN MONTHS	11 FROM DATE OF RECEIPT AT BHEL STORES.