

 TSD 6206	PLANT PURCHASING SPECIFICATION BHOPAL	BP 27595 Rev. No. 03 PAGE 1 OF 3 SUPERSEDES BP 27595 Rev.02
<u>GREY INSULATING ENAMEL</u>		
1. GENERAL : This specification governs the requirement of Grey Insulating Enamel having matt finish, free from heavy settling or skinning. The enamel is suitable for application by brush. Material has temperature index of atleast 130. 2. APPLICATION : Used for the treatment of armatures, field coils of traction machines and electrical rotating machines etc. 3. COMPLIANCE WITH NATIONAL STANDARDS : There is no Indian Standard covering this material. 4. TEST SAMPLE : One liter of varnish shall be supplied for testing and approval purposes. Approval will include laboratory test and shop trials. 5. TEST METHOD : The varnish shall be tested as per relevant parts of IS:101 unless otherwise stated. 6. PROPERTIES : 6.1 <u>General Condition</u> : Uniform in appearance & free from defects like skinning when kept in closed container, levering (excessive viscosity built up), heavy settling etc. 6.2 <u>Colour</u> : Grey. 6.3 <u>Specific Gravity</u> : 1.5 ± 0.2. 6.4 <u>Viscosity at 27 ± 2 deg.C by Ford Cup. No.4</u> : 130 ± 30 seconds. 6.5 <u>Solid Content at 100 ± 2 deg.C for 3 hrs</u> : 75 ± 2 %.		
Revision : Reviewed & Brought upto date		Issued by :  STANDARDS AND MATERIALS GROUP TECHNICAL SERVICES DEPARTMENT
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7. PROPERTIES OF FILM :

7.1 Air Drying Time :

7.1.1 Surface Dry: : 2 hours, max.

7.1.2 Hard Dry : 8 hours, max.

7.1.3 Tack Free : 16 hours, max.

7.2 Finish : Smooth & Uniform.

7.3 Gloss : 10 %, Max.

7.4 Flexibility & Adhesion (By Erichsen Tester) : 8 mm, min.

7.5 Scratch Hardness : 1500 gms, min., when Tested on mild steel panel.

7.6 Comparative Tracking Index (AA 085 17 10) : 350 min.

8. SHELF LIFE :

When stored under cover in a dry place in original sealed container under normal temperature conditions the material shall retain the properties prescribed in this specification for a period of at least 12 months after the date of manufacture, which shall be subsequent to the date of placing order.

9. TYPE APPROVAL :

Sample for the type approval testing shall be accepted only from those manufacturers whose manufacturing and testing facilities are considered satisfactory to ensure continuous supply of good product.

10. TEST CRTIFICATE :

Unless otherwise stated, three copies of certificates shall be supplied along with each consignment.

In addition, the supplier shall ensure to enclose one copy of test certificate alongwith their dispatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information :-



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BHEL Order No.

Batch No.

Date of Manufacture.

Date of expiry.

Test results of clauses 6 & 7.

11. PACKING & MARKING :

The material shall be packed in drums of 20 liter or any suitable size as per order and sealed. The drums are to be packed suitably to prevent damage during transit. Each drum shall bear the following information :

BP 27595 : Grey Insulating Enamel.

BHEL Order No.

Batch No.

Supplier's / Manufacturer's Name and Grade if any.

Date of Expiry

Quantity.