

# DATA SHEET FOR WATER BASE ZIRCON PAINT PAINT FOR STEEL CASTING (EQUIVALENT TO HOLECOTE 100 FOSECO)

DS/PPC/15-16/01

20.10.2015

1. **Application:** Used for coating the moulds and cores of two part & three part system for Steel Castings
2. **Characteristics:**
  - Viscosity by B4 Ford Cup : 50+/- 5 Sec (100 Parts Paste+10 Parts Water)
  - Density: 2.3+/-0.1 gm/cc
  - pH: 8-10
  - Settling % per hour: 10 to 20 %
  - Solid Content: 75+/-2%
  - ZrO2 content : 65% minimum
  - The paint shall be free from low melting point minerals such as carbonaceous materials and clay.
3. **Adhesion**
  - 3.1 The wash should not develop cracks or peel off on drying the sample at 200°C for 2 hours.
  - 3.2 The dried coating surface should have sufficient hardness so that the paint does not peel off when scratched by nail or does not come out on gentle rubbing.
  - 3.3 The paint should have thixotropic properties.
  - 3.4 The paint shall give uniform coating on mould surface and should not peel off or develop cracks on drying.
4. **Settling**

When left undisturbed for 24 hours in glass beaker, the solid content should not settle down.
5. **Appearance:** Ready mix for direct application. Brushing of the paint
6. **Shelf Life:** Minimum shelf life of 6 months.
7. **Packing & Marking:** 25-40 Kg Carboys. Each container shall be legibly marked with the following details:
  - I. BHEL PO No.
  - II. Manufacturer/Supplier Name
  - III. Batch No.
  - IV. Quantity
  - V. Manufacturing Date
  - VI. Expiry Date
8. **Inspection:** BHEL reserves the right to test the material at BHEL works and the final acceptance of the material shall be based on these performance of the material.
9. **Test Certificates:** In addition to the relevant dispatch documents, vendor has to send three copies of test certificates along with each consignment with the test results along with the details mentioned in Point 7.

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20/10/15  
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