



PLANT PURCHASING SPECIFICATION BHOPAL

BP 55379

Rev. No. 03

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SUPERSEDES
BP 55379 Rev.02

LOCKING ADHESIVE FOR FASTENERS

1. GENERAL :

This specification governs the quality of air drying, single component, solvent free multipurpose adhesive for locking and sealing of threaded metal fasteners. Cured adhesive has excellent resistant to oil, petrol, synthetic lubricating oils, hydraulic oils and most of the chemicals but less resistant to water or to water or mixtures from water / glycol. Adhesive is suitable for use at temperature between - 55 to +155 °C.

2. APPLICATION :

Used for locking of metal bolts and nuts.

3. COMPLIANCE WITH NATIONAL STANDARDS :

There is no Indian Standard covering this type of material.

4. FREEDOM FROM DEFECTS :

The material shall be free from foreign matters so that it does not have any deleterious effect after application.

5. SAMPLE FOR TEST :

0.5 Kg. of sample shall be supplied for testing and approval.

6. PROPERTIES :

- 6.1 Colour : Blue
- 6.2 Viscosity : 5000 m Pas.
- 6.3 Density : 1.1 g/cc. Min
- 6.4 Flash Point : 100° C, Min
- 6.5 Gap Filling : 0.25 mm
- 6.6 Temperature Range : - 55 to 155° C
- 6.7 Shear Strength : 8-12 N/mm².
- 6.8 Breaking Strength : 4-8 N/mm².
- 6.9 Curing Strength : 3 hours. Min.
- 6.10 Prevailing Strength : 2-4 N/mm².
- 6.11 Handling Strength : 10-30 Minutes.

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7. KEEPING PROPERTIES :

When stored in a clean, cool and dry places in the original sealed containers under normal temperatures conditions, the material shall retain the properties in this specification for a period of 12 months after the date of manufacture which shall be subsequent to the date of placing the order .

8. TEST CERTIFICATE :

Three copies of test certificates shall be supplied, along with each consignment .

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

The test certificate shall bear the following information.

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BHEL order No.

Manufacturer's / Suppliers Name & Trade Mark if any

Batch No.

Date of Manufacture & Expiry

Test Results of Clause 6.

9 PACKING AND MARKING

Material shall be supplied in a suitable container of 50 ml or 250 ml as stated on order. Each container should bear the following particulars.

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BHEL Order No.

Manufacturer's / Supplier's Name, Trade Mark, if any

Batch No.

Date of Manufacture and Expiry

Quantity.

10 ENVIRONMENTAL REQUIREMENTS :

The supplier shall furnish Material Safety Data sheet (MSDS) covering all information relating to human safety and environmental impacts of the hazardous materials particularly during their transportation, storage, handling and disposal along with each supply.

Each container shall be marked with corresponding symbol and minimum worded cautionary notice for flammable / corrosive / toxic / harmful / irritant and oxidizing etc. as applicable.

11 REFERRED STANDARDS (LATEST Publications including Amendments)

Nil