

			PRODUCT STANDARD SWITCHGEAR ENGINEERING DIVISION			SG 15201 REV.05					
						PAGE 1 OF 1					
		<u>Surface Preparation and Finish of steel components</u>									
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited It must not be used directly or indirectly in any way detrimental to interest of Co.		A. <u>For Enamel painting (Semi-Glossy)</u> BP0690098 - Cleaning of steel components by sand blasting. BP0674196 - Painting of sand blasted components with priming paint to AA56101. AA0674113 - Painting of ferrous surfaces by semi Glossy paint. (shade as per P.O.) BP0431099 - Check list for painting of Equipments									
		B. <u>For Epoxy painting</u> BP0690098 - Cleaning of steel components by sand blasting AA0674111 - Process for painting of metallic surfaces by epoxide paint (shade as per P.O.) BP0431099 - Check list for painting of Equipments									
		C. <u>For Hot dip Galvanisation</u> BP0690098 - Cleaning of steel components by sand blasting. AA0673608 - Hot dip Galvanisation of iron and steel surfaces.									
		D. <u>For Enamel painting (Full glossy)</u> BP0690098 - Cleaning of steel components by sand blasting. BP0674196 - Painting of sand blasted components with priming paint to AA56101. AA0674112 - Painting of ferrous surfaces by full Glossy paint. (shade as per P.O.) BP0431099 - Check list for painting of Equipments									
		E. <u>For stove enamelled paint finish :-</u> AA0673617 - Zinc phosphating of Ferrous Surface by hot immersion process. (7 Tank pretreatment process) AA0674122 - Process of painting for panels with stoving paint. BP0431099 - Check list for painting of Equipments									
		F. <u>For Powder Coating :-</u> AA0674124 - Process for epoxy / epoxy polyester Powder coating. BP0431099 - Check list for painting of equipments.									
		Note:- 1. SWM to select and specify surface finishes Paint thickness and colour shade in the purchase order as per work order requirements. 2. In case if paint finish fails in adhesion test, clean the component by sand /shot blasting and should be repainted.									
				REV.		05		PRINTS TO :-		APPROVED –	
				ALTD.		AKJ		SWM(P)		VVN	
				APPD.		IP		QCX		PREPARED	
		DATE.		16.05.02		MCA		ISSUED			
						TCD,MCD,HVD		DATE			
								SM			
								ILB			
								7.8.93			