



BHARAT HEAVY ELECTRICALS LTD.,

ELECTROPORCELAINS DIVISION

BANGALORE - 560 012

Ref No. PS - **L&T** KHARGONE - BENDS / **PIPES** Rev: 00 Date 09-11-2016 Page No. 1 of 1

PAINTING SCHEDULE PERTAINING TO NTPC **KHARGONE** PROJECT BENDS AT CASING STAGE AND ASSEMBLY STAGE

FIRST COAT BY CASING VENDOR.

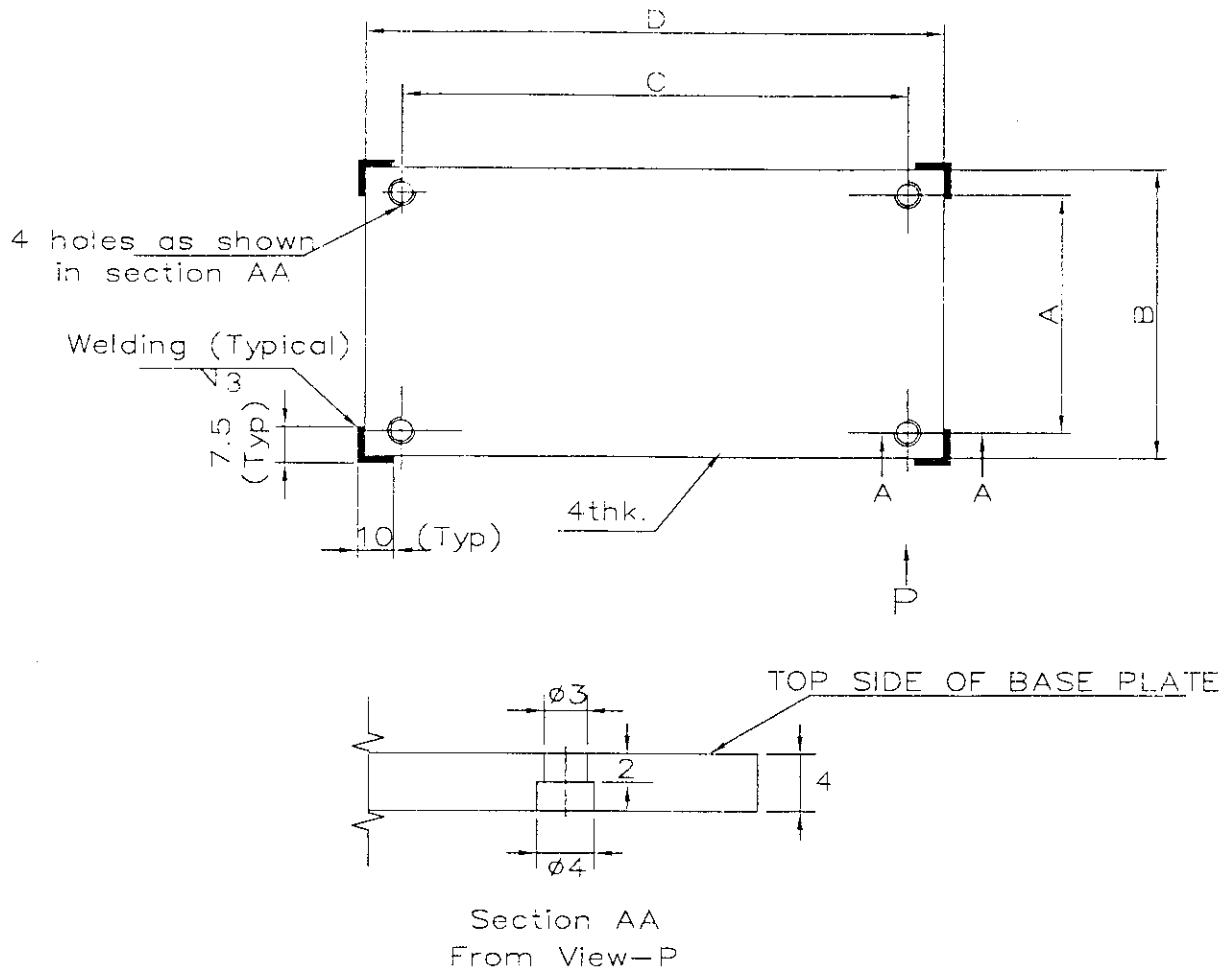
	LOCATION	SURFACE PREPARATION	PAINT	No. OF COATS	SHADE
1(a)	CASING All over (INSIDE AND OUTSIDE)	BLAST CLEANING TO SA:2 STD: SIS : 55900	HEAT RESISTANT ALUMINIUM PAINT SUITABLE FOR 400°C CONFORMING TO IS: 13183	ONE COAT 20 MICRONS DFT	ALUMINIUM
(b)	END RINGS, EARTH LUG, SPOOL SUPPORT LUG AND SHOULDER	BLAST CLEANING TO SA:2 STD: SIS : 55900	HEAT RESISTANT ALUMINIUM PAINT SUITABLE FOR 400°C CONFORMING TO IS: 13183	ONE COAT 20 MICRONS DFT	ALUMINIUM
(c)	FLANGES	BLAST CLEANING TO SA:2 STD: SIS : 55900	[a] HEAT RESISTANT ALUMINIUM PAINT SUITABLE FOR 400°C CONFORMING TO IS: 13183 ALL OVER EXCEPT FRONT FACE OF FLANGE [b] FRONT FACE OF FLANGE IS TO BE COATED WITH RUST PREVENTIVE COAT	[a] ONE COAT 20 MICRONS DFT [b] ONE COAT	ALUMINIUM —
(d)	Lifting Lug	BLAST CLEANING TO SA:2 STD: SIS : 55900	ENAMEL PAINT CONFORMING TO IS: 2932	ONE COAT	YELLOW

FINISH COAT AT BHEL

2(a)	CASING (EXTERNAL SURFACES)	REFER NOTE-2	HEAT RESISTANT ALUMINIUM PAINT SUITABLE FOR 400°C CONFORMING TO IS: 13183	ONE COAT 20 MICRONS DFT/COAT TOTAL DFT: 40 MICRONS	ALUMINIUM
(b)	END RINGS, EARTH LUG, SPOOL SUPPORT LUG AND SHOULDER	REFER NOTE-2	HEAT RESISTANT ALUMINIUM PAINT SUITABLE FOR 400°C CONFORMING TO IS: 13183	ONE COAT 20 MICRONS DFT/COAT TOTAL DFT: 40 MICRONS	ALUMINIUM
(c)	FLANGES	REFER NOTE-2	[a] HEAT RESISTANT ALUMINIUM PAINT SUITABLE FOR 400°C CONFORMING TO IS: 13183 ALL OVER EXCEPT FRONT FACE OF FLANGE [b] FRONT FACE OF FLANGE IS TO BE COATED WITH RUST PREVENTIVE COAT	[a] ONE COAT 20 MICRONS DFT TOTAL DFT: 40 MICRONS [b] ONE COAT	ALUMINIUM —
(d)	Lifting Lug	REFER NOTE-2	ENAMEL PAINT CONFORMING TO IS: 2932	ONE COAT	YELLOW

- NOTE:
- General guidelines given in painting SPEC:CE:1501/20 to be followed.
 - Surface preparation should be adequate to remove rust, dust, oil and other contaminants which will hamper proper adhesion of finish coat.
 - Rust preventive coat for Machined Front Face of Flanges.
 - Final coat paint on casing & lugs etc.
 - COMMERCIAL BLAST MANDATORY AT CASING STAGE BY CASING VENDOR, BEFORE APPLICATION OF FIRST COAT PAINT.
 - AT CASING STAGE ONE COAT OF PAINT TO BE APPLIED IMMEDIATELY AFTER BLASTING, IN ANY CASE NOT LATER THAN 6 HRS AFTER BLASTING.

Prepared by Kaushik.K *Kaushik.K* Checked by VINOD.M *Vinod.M* Approved by J.FELIX *J.FELIX*



Note: -

1. Material M.S. should conform to IS:2062 - E250 BR - killed.
2. This base plate to be welded on all bends, at location shown. This will serve as base plate for the name plate.
3. Each Base plate to be supplied along with 4 Nos. aluminium rivets suitable for the hole size shown.

2	Ø685.8	128	143	180	200
1	Ø482.6	135	150	180	200
Var. No.	For Bends/Pipes with ID	A	B	C	D

Table - 1

Project: NTPC TANDA / KHARGONE



BHARAT HEAVY ELECTRICALS LTD;
ELECTROPORCELAINS DIVISION
BANGALORE 560 012

	NAME	SIGN	DATE
DRN	KAUSHIK.K	<i>[Signature]</i>	12.07.2016
CHD	VINOD.M	<i>[Signature]</i>	12.07.2016
APPD	J.FELIX	<i>[Signature]</i>	12.07.2016

DEPT	GRADE OF TOL. DIM.	SCALE	WEIGHT (kg)	REF. TO ASSY DRG.	ITEM No.	No. OF ITEMS
CODE	C/M/F	NTS	(Approx)			
TITLE	BASE PLATE (FOR NAME PLATE)			CARD CODE	DRAWING No. 4-986-99-07720	REV 01
SUB No.		No. OF SHEETS				