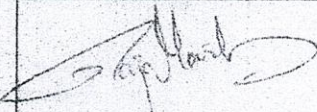
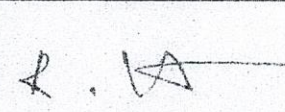
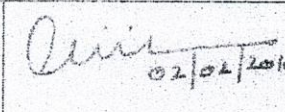


 Ranipet	TECHNICAL SPECIFICATION FOR TEMPORARY SEA WORTHY RUST PREVENTIVE FLUID (DRYING TYPE)	Doc no	PRQA:524
		Rev.	00
		Date	30.01.2018
		Page no	1 OF 1

SL NO	DESCRIPTION	REQUIREMENTS
01	Specific gravity at ambient temperature	0.85 – 0.95
02	Flash point °C (min)	40
03	Drying time: Surface dry (Hours, max)	½
	: Tack free (hours, max)	8
04	Dry film thickness (microns) per coat-min	25
05	Consistency	Smooth & Uniform
06	Film type Transparent/ Translucent	Transparent
07	% of Non-volatile by mass	55 ± 5
08	Temperature resistance of RPF film at 50°C (for 8 hours)	To pass test
09	Corrosion protection under conditions of condensation for 300 hrs	No sign of corrosion
10	Salt spray test for 500 hours	To pass test
11	Outdoor durability	The coating shall not crack or turn opaque when exposed to outdoor, unsheltered condition for 1 year
12	Scratch hardness test (under load of 1000g as per IS 101 (Latest))	To pass test
13	% of zinc phosphate content (min)	8
14	Keeping property- Months (Shelf life) min	12
15	General conformance to IS specification	IS 1153 (Latest)
16	Packing standard/ marking	4 litres tin as per IS 1407 (Latest) and 20 litres as per IS 2552 (Latest) Gr B2 Rust preventive fluid for BHEL use only. Suppliers name: Batch: Date: Quantity Shelf life: Use before: BHEL Specn: PRQA:524 (Latest)
17	Test certificate	The supplier shall furnish test certificate for the above requirements SI no: 1 to 15 in duplicate

Note: The TRPF shall be free from ROSIN and ROSIN derivatives and other natural resins. It shall pass through Liebermann- Storch test. Also it should protect the metal surfaces from corrosion during transportation by sea.

Issued by	Reviewed by	Approved by
		 02/01/2018
Rajamanickam.M Sr.Engineer/ QA	R. Arunachalam DGM/ QA& QC-OLI	C. Srinivasan DGM/ QA& QC-Proc.

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