



# CORPORATE PURCHASING SPECIFICATION

AA56138

Rev No. 02

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## BLACK – GLOSSY STOVING ENAMEL PAINT

### 1.0 GENERAL:

This specification governs the quality of stoving enamel finishing paint, black. The stoving schedule for this paint shall be 110-1200C for 30 minutes.

### 2.0 APPLICATION:

Suitable for application on the surfaces of energy meters made of steel components. The paint shall be capable of being sprayed with thinner for stoving paint over a surface prepared as per Corporate Standard AA0674101.

### 3.0 COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian Standard covering this material.

### 4.0 FINISH:

Smooth, uniform and full glossy.

### 5.0 FREEDOM FROM DEFECTS:

The paint shall remain free from defects like hard settling of pigments, skinning when kept in a closed container and livering (excessive viscosity build up) during its rated shelf life.

The dried paint shall be free from defects like bittiness, floating of pigments, surface haze, orange peel, colour fading, wrinkles, etc.

### 6.0 CHEMICAL COMPOSITION:

The stoving finish paint shall be based on synthetic resins. The composition of the pigment and the vehicle of the bulk shall meet the requirements mentioned in clause 8.0

### 7.0 TEST SAMPLES:

Tender samples will not be required when once the type approval (clause 9.0) is given and the supplier concerned declares that the material for which the tender is given is of the same quality as the type approved sample.

Representative samples of the material shall be drawn and treated as prescribed in IS:101: Part 1/Sec.1 & 2.

### 8.0 PROPERTIES:

When tested in accordance with IS: 101 the test samples shall show the following properties:

Revisions:

Refer clause 27.2.1 MOM of MRC (C)

**APPROVED:**

INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(CPO+NM)

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**CORPORATE PURCHASING  
SPECIFICATION****8.1 Flash Point:**

Not below 30°C

**8.2 Mass per 10 litres:**

9.5 to 10.0 kg

**8.3 Fineness of Grind:**

6.5 Min. on Hegman's gauge

**8.4 Gloss and Its Retention:**

60 minimum, when tested with a 60° gloss meter

**8.5 Flexibility and Adhesion:**

Shall pass the test

**8.6 Protection against Corrosion, Under Conditions of Condensation:**

The paint film shall not show any sign of deterioration and the metal surface no sign of corrosion.

**8.7 Resistance to Heat:**

When exposed to heat for 2 hours at 180°C, the sample shall not crack or blister.

**8.8 Non-volatile Matter:**

40% minimum

**8.9 Consistency:**

65 ± 5 seconds minimum, in Ford Cup.No.4 at 27 ± 2°C

**8.10 Spreading Capacity:**

140 to 150 Square metres minimum per 10 litres

**8.11 Scratch Hardness:**

1000 g minimum

**8.12 Resistance to Solvents:**

No blistering or softening for petrol and oil

**8.13 Resistance to Salt Spray:**

Panel prepared from the material shall show no signs of corrosion



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## 9.0 TYPE APPROVAL

Samples for type approval testing shall be accepted only from those manufacturers whose manufacturing and testing facilities are considered satisfactory to ensure continuous supply of good product.

## 10.0 TEST CERTIFICATES

Unless otherwise specified, three copies of test certificates shall be supplied along with each consignment.

In addition the supplier shall ensure to send one copy of test certificates along with the despatch documents to facilitate quick chance of the material.

The test certificates shall bear the followings information

AA56138 (Rev.No02): BLACK – GLOSSY STOVING ENAMEL PAINT

BHEL Order No.

Manufacturer's/Supplier's Name.

Trade Mark, if any.

Batch/Lot No.

Date of Manufacture & Expiry.

Test results of clauses 6.0, 8.0 and 9.0

## 11.0 KEEPING PROPERTY:

When stored in a covered dry place in the original sealed container under normal temperature conditions, the material shall retain the properties prescribed 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.

## 12.0 PACKING AND MARKING

Unless otherwise stated, the paint shall be packed in 20 litre steel drums.

Each container shall bear the following information:

AA56138: BLACK – GLOSSY STOVING ENAMEL PAINT.

Colour/Shade.

BHEL Order No.

Manufacturer's/Supplier's Name.

Trade Mark, if any.

Batch/Lot No.

Date of Manufacture & Expiry.

Quantity supplied.

## 13.0 REFERRED STANDARDS (Latest Publications Including Amendments)

1. IS: 101

2. AA0674101