

TR 10005 P

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Form no.2038

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PRODUCT STANDARD  
TRANSFORMER

शाप / अभि. निर्देश SHOP / ENGG. INSTRUCTIONS

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शीर्षक :  
TITLE :

**PAINTING INSTRUCTIONS**

SR NO	PARTS	SUR. FACE	PAINT	NO OF COATS	HOW APPLIED	PAINT SPEC	DRY PAINT FILM THK MICRON	PROCESS SPEC	REMARKS
1	1. TRANSFORMER/ REACTOR TANK & COVER, TOP TANK BOTTOM TANK ii. TURRETS iii. INSPECTION COVERS, CONSERVATOR HEADERS	IN SIDE OUT SIDE	CHEMICAL & THERMAL RESISTANT EPOXY ENAMEL WHITE / CREAM SHADE i. CHEMICAL & THERM. RESIST EPOXY PRIMER. ii. CHEM. & THERM. RESISTANT EPOXY ENAMEL LIGHT GREY SHADE 631 OF IS:5	2 2 2	SPRAY OR BRUSH SPRAY OR BRUSH SPRAY OR BRUSH	BP 56179 AA 56105 BP 56179	TOTAL DFT 50 Min. 50 Min 100 Min.	TR10206P	EPOXY PAINTING
2	END FRAME, CLAMP PLATE, T.G & T.C BRACKETS & OTHER STEEL PARTS GOING INSIDE TRANSFORMER TANK		CHEMICAL & THERMAL RESISTANT EPOXY ENAMEL WHITE / CREAM SHADE	2	SPRAY OR BRUSH	BP 56179	TOTAL DFT 50 Min.	TR10206P	
2 (A)	E/F, CLAMP PLATE, CROSS BEAM, T.G & T.C BRACKET, OTHER STEEL PARTS GOING INSIDE TANK UPTO 400 KV CLASS FOR TRANS. & REACTORS		OIL RESISTANT FULL GLOSSY WHITE PAINT	2	SPRAY OR BRUSH	BP 56183	TOTAL DFT 40 Min.	TR10211P	
3	BARE COPPER GOING INSIDE TRANS TANK		ONE 50% OVERLAP WOUND LAYER OF CREPE KRAFT PAPER TO AA21117 TYPE B						
4	i. TRANSF. TANKS UPTO 400 KV CLASS ii. REACTOR TANKS UP TO 400 KV CLASS iii. SPARE COIL TANK iv. CONSERVATOR, RELIEF VENT, RAD HEADER v. CABLE BOX vi. COMPOUND FILLED TURRETS	IN SIDE OUT SIDE	OIL RESISTANT FULL GLOSSY WHITE PAINT i. ANTI CORROSIVE PRIMER PAINT ii. HIGH QUALITY FULL GLOSSY OUTDOOR FINISHING PAINT LIGHT GREY SHADE 631 OF IS:5	2 2 2	SPRAY OR BRUSH SPRAY OR BRUSH SPRAY OR BRUSH	BP 56183 AA 56101 AA 56126	TOTAL DFT 40 Min. 40 Min. 40 Min TOTAL DFT 80 Min	TR10211P	

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पुनः Rev. 18	दिनांक: Date 10.02.10	SKG A. DEOTA S.G.B		तैयार किया : PREPD. : SD/-SJ
				दिनांक : DATE : 23-03-1986

Handwritten signatures and initials: SKG, A. DEOTA, S.G.B, and a date stamp 15/8.

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SR NO	PARTS	SUR- FACE	PAINT	NO.OF COATS	HOW APPLIED	PAINT SPEC.	DRY PAINT FILM THK MICRON	PROCESS SPEC.	REMARKS
5	PIPE WORK	IN SIDE	---AS IN SL.NO.4---		FLOODING	BP 56183			
		OUT SIDE	---AS IN SL.NO.4---	2	SPRAY OR BRUSH	AA 56101	40 Min.	TR10210P	
				2	SPRAY OR BRUSH	AA 56126	40 Min. TOTAL DFT. 80 Min.		
6	ROLLER ASSY, A- FRAMES, BREATHERS, STEEL PARTS, OUTSIDE TRANSFORMER TANK	OUT SIDE	---AS IN SL.NO.4---	2	SPRAY OR BRUSH	AA 56101	40 Min.	TR10211P	
				2	SPRAY OR BRUSH	AA 56126	40 Min. TOTAL DFT. 80 Min.		
7	RADIATORS	OUT SIDE	i. SELF ETCH PRIMER ii. ANTI CORROSIVE PRIMER iii. HIGH QUALITY FULL GLOSSY FINISHING PAINT	1	SPRAY OR BRUSH	AA56103	5 Min.	TR10205P	
				2	FLOODING	AA56101	40 Min.		
				2	FLOODING OR SPRAY OR BRUSH	AA56126	40 Min. TOTAL DFT. 85 Min.		
8	ALL BLANKING DURING SHIPPING	IN SIDE	---AS IN SL.NO.4---	2	SPRAY OR BRUSH	BP56183	TOTAL DFT. 40 Min.	TR10211P	
		OUT SIDE	POST OFFICE RED FINISHING PAINT	2	SPRAY OR BRUSH	AA56126	TOTAL DFT. 40 Min.		
9	INSTRUMENT TRANSFORMER CT/VT TANK	INSIDE EXCEPT SECONDARY TERMINAL BOX	---AS IN SL.NO.4---	2	SPRAY OR BRUSH	BP 56183	TOTAL DFT. 40 Min.		
		INSIDE SECONDARY TERMINAL BOX	i. ANTI CORROSIVE PRIMER ii. ANTI CORROSIVE PRIMER iii. NON YELLOWING FULL GLOSSY WHITE PAINT	2	SPRAY OR BRUSH	AA56101	40 Min.	TR10211P	
		OUT SIDE	---AS IN SL.NO.4---	2	SPRAY OR BRUSH	AA56126	40 Min. TOTAL DFT. 80 Min.		

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SR NO	PARTS	SUR-FACE	PAINT	NO. OF COATS	HOW APPLIED	PAINT SPEC.	DRY PAINT FILM TH. MICRON	PROCESS SPEC.	REMARKS
10	MARSHALLING BOX / KIOSK	IN SIDE	I. ANTICORROSIVE PRIMER PAINT. II. NON YELLOWING FULL GLOSSY WHITE PAINT	2	SPRAY OR BRUSH	AA56101 AA56127	40 Min. 40 Min. TOTAL DFT. 80 Min.	TR10211P	
		OUT SIDE	—SAME AS IN SL. NO. 4 —	2	SPRAY OR BRUSH	AA56101 AA56126	40 Min. 40 Min. TOTAL DFT. 80 Min.		
11	MARSHALLING BOX / KIOSK AIR FILLED CABLE BOX	IN SIDE	I. ANTICORROSIVE PRIMER PAINT. II. WHITE ANTI CONDENSATION PAINT	2	SPRAY OR BRUSH	AA56101 HE1006 BP56194	40 Min. 40 Min. TOTAL DFT. 80 Min.	TR10211P	
		OUT SIDE	—SAME AS IN SL. NO. 4 —	2	SPRAY OR BRUSH	AA56101 AA56126	40 Min. 40 Min. TOTAL DFT. 80 Min.		
12	PANELS MOUNTED INSIDE M.BOX/KIOSK		—SAME AS IN SL. NO. 10 (INSIDE) —	2	SPRAY OR BRUSH	AA56101 AA56127	40 Min. 40 Min. TOTAL DFT. 80 Min.	TR10211P	
13	MARSHALLING BOX / KIOSK PARTS INCLUDING PANELS EXPOSED TO CHLORINE CONTAMINATED ATMOSPHERE	IN SIDE	I. CHEMICAL & THERMAL RESISTANT EPOXY PRIMER PAINT. II. CHEMICAL & THERMAL RESISTANT EPOXY ENAMEL WHITE SHADE	2	SPRAY OR BRUSH	AA56105 BP56179	50 Min. 50 Min. TOTAL DFT. 100 Min.		
		OUT SIDE	I. CHEMICAL & THERMAL RESISTANT PRIMER PAINT. II. CHEMICAL & THERMAL RESISTANT EPOXY ENAMEL PAINT LIGHT GREY SHADE 6310F IS:5	2	SPRAY OR BRUSH	AA56105 AA56179	50 Min. 50 Min. TOTAL DFT. 100 Min.	TR10208P	
14	NON FERROUS PARTS EXPOSED TO CHLORINE CONTAMINATED ATMOSPHERE	OUT SIDE	I. SELF ETCH PRIMER II. CHEMICAL & THERMAL RESISTANT EPOXIDE PRIMING PAINT. III. CHEMICAL & THERMAL RESISTANT EPOXY ENAMEL PAINT LIGHT GREY SHADE 6310F IS:5	1	SPRAY OR BRUSH	AA56103 AA56105	5 Min. 25 Min.		
15	RADIATORS ( EPOXY PAINTING	OUT SIDE	—SAME AS IN SL. NO. 1 —	2	SPRAY OR BRUSH	AA56105 BP56179	50 Min. 50 Min. TOTAL DFT. 100 Min.	TR10208P	

EPOXY PAINTING

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10	REMARKS	EPOXY PAINTING		ALUMINIUM PAINTING	
9	PROCESS SPEC.	TR10206P	TR10206P	TR10211P	TR10209P
8	DRY PAINT FILM THK. MICRON	50 Min.	50 Min. 50 Min. TOTAL DFT. 100 Min.	TOTAL DFT. 40 Min.	40 Min. 40 Min. TOTAL DFT. 80 Min.
7	PAINT SPEC.	BP56179	AA56105 BP56179	BP56179	AA56101 AA56128
6	HOW APPLIED	SPRAY OR BRUSH	SPRAY OR BRUSH	SPRAY OR BRUSH	SPRAY OR BRUSH
5	NO OF COATS	2	2 2	2	2 2
4	PAINT	CHEMICAL & THERMAL RESISTANT EPOXY ENAMEL WHITE SHADE	i. CHEMICAL & THERMAL RESISTANT EPOXY PRIMER ii. CHEMICAL & THERMAL RESIST EPOXY ENAMEL LIGHT GREY SHADE 631 OF IS : 5	OIL RESISTANT FULL GLOSSY WHITE PAINT	i. ANTI CORROSIVE PRIMING PAINT. ii. ALUMINIUM PAINT
3	SUR-FACE	IN SIDE	OUT SIDE	IN SIDE	OUT SIDE
2	PARTS	i. TRANSFORMER TANK & COVER, TOP TANK, BOT. TANK ii. TURRETS iii. INSPECTIONS COVERS, CONSERVATOR HEADERS		END FRAME, CLAMP PLATE, CROSS BEAM, T.G. & T.C. BRACKETS, OTHER STEEL PARTS GOING INSIDE TRANS. TANK	
1	SR NO	16	17	18	19
				TRANS. TANK, COVER, TURRETS, INSP COVER, CONS., RAD. HEADERS, RELIEF VENT., CABLE BOXES, P.W., A-FRAME MARSHALLING BOX ETC.	
				RADIATORS (ALUMINIUM PRINTING)	

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SR NO	PARTS	SUR-FACE	PAINT	NO.OF COATS	HOW APPLIED	PAINT SPEC.	DRY PAINT FILM TH. MICRON	PROCESS SPEC.	REMARKS
20	i. TRANSFORMER TANK& COVER, TOP & BOT. TANK ii. TURRETS iii. INSPECTIONS COVERS, CONSERVATOR HEADERS, A-FRAMES, P/W ETC.	IN SIDE OUT SIDE	i. CHEMICAL & THERMAL RESISTANT EPOXY WHITE PAINT ii. CHEMICAL & THERMAL RESISTANT EPOXY ZINC PHOSPHATE PRIMER iii. POLYURETHANE FINISHING PAINT.	*	SPRAY OR BRUSH	TRE/168	TOTAL DFT 50 Min 50 Min.		POLYURETHANE PAINTING
	END FRAME, CLAMP PLATE, CROSS BEAM, T.G & I.C. BRACKETS, OTHER STEEL PARTS GOING INSIDE TRANS. TANK	IN SIDE	CHEMICAL & THERMAL RESISTANT EPOXY WHITE PAINT	*	SPRAY OR BRUSH	TRE/168	TOTAL DFT 50 Min.	TR10266P	
	RADIATOR	OUT SIDE	FLUSHED WITH VARNISH i. CHEMICAL & THERMAL RESISTANT EPOXY ZINC PHOSPHATE PRIMER ii. POLYURETHANE FINISHING PAINT.	*	SPRAY OR BRUSH	TRE/166 OR AA56105 TRE/165 OR AA56142	50 Min. 50 Min. TOTAL DFT 100 Min.		
21	i. TRANSFORMER TANK COVER, TOP TANK, BOT. TANK ii. TURRETS iii. INSPECTIONS COVERS, CONSERVATOR HEADERS, A FRAMES, P/W ETC	IN SIDE OUT SIDE	OIL RESISTANT FULL GLOSSY WHITE PAINT i. CHEMICAL RESISTANT HIGH BUILD EPOXIED PRIMING PAINT, OR CHEMICAL & THERMAL RESISTANT EPOXY PRIMER ii. POLYURETHANE FINISHING PAINT SHADE 631 OF IS.5	2 1 2 1 OR 2	SPRAY OR BRUSH	BP-96183 AA56109 AA56105 AA56142	40 Min. 50 Min. 50 Min. TOTAL DFT 100 Min.	TR10211P TR10229P	

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SR NO	PARTS	SUR-FACE	PAINT	NO.OF COATS	HOW APPLIED	PAINT SPEC.	DRY PAINT FILM TH. MICRON TOTAL DFT 50 Min	PROCESS SPEC.	REMARKS
22	i. TRANSFORMER TANK & COVER, TOP & BOT. TANK ii. TURRETS iii. INSPECTIONS COVERS, CONSERVATOR HEADERS, A-FRAMES, PIW ETC.  END FRAME, CLAMP PLATE, CROSS BEAM, T.G & T.C. BRACKETS, OTHER STEEL PARTS GOING INSIDE TRANS. TANK  RADIATOR	IN SIDE  OUT SIDE	CHEMICAL & THERMAL RESISTANT EPOXY WHITE PAINT  i. CHEMICAL & THERMAL RESISTANT EPOXY ZINC PHOSPHATE PRIMER ii. EPOXY HB MIO iii. POLYURETHANE FINISHING PAINT.  CHEMICAL & THERMAL RESISTANT EPOXY WHITE PAINT  FLUSHED WITH VARNISH  i. CHEMICAL & THERMAL RESISTANT EPOXY ZINC PHOSPHATE PRIMER ii. POLYURETHANE FINISHING PAINT.	.  .  .  .	SPRAY OR BRUSH  SPRAY OR BRUSH  SPRAY OR BRUSH  SPRAY OR BRUSH	TRE/168  TRE/166  TRE/167  TRE/165  TRE/168  TRE/382/03  TRE/166  TRE/165	50 Min.  75 Min.  50 Min. TOTAL DFT 155 Min  TOTAL DFT 50 Min.	TR10257P	POLYURETHANE PAINTING

## NOTE TO DO:

- EPOXY PAINTING TO BE CALLED WHEN SPECIFICALLY ASKED FOR BY THE CUSTOMERS.
- EPOXY PAINTING HOWEVER TO BE CALLED WHEN EQUIPMENTS ARE TO BE INSTALLED IN CHEMICAL ATMOSPHERE OR NEAR SEA SHORES.
- SHADE OF FINISHING PAINT IS TO BE COVERED ON MID/ DRAWINGS ALONG WITH RESPECTIVE S.NO. OF THIS STD.

(\* ) NUMBER OF COATS SHALL BE GIVEN TO ACHIEVE DFT AS PER COLUMN 08 .

## NOTE TO SHOP:

- PAINTING TO BE TOUCHED UP WHERE EVER REQUIRED BY TRANSFORMER SHOP BEFOR SHIPMENT.

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