



उत्पाद मानक
परिणामित्र

PRODUCT STANDARD
TRANSFORMER

TR,10211P

Form No. 2038

शाप/अभि. निर्देश

SHOP/ENGG INSTRUCTIONS

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शीर्षक TITLE

PROCESS FOR PAINTING OF TRANSFORMER
TANK AND ACCESSORIES

1.0 GENERAL:

This specification details the process to be followed for painting of Transformer/Reactor Tanks, Conservators, Headers etc. (hereinafter referred as tank) by brushing or spraying.

This specification details the schedule for the application of 2 coats of Oil resistant Paint of Jasmine Yellow shade to AA 56132 or white shade to BP 56183 by brushing for inside tank surface, while 2 coats of primer paint to AA 56101 (by brushing/Spraying) followed by 2 coats of Light/Dark grey finishing paint to AA 56126 (by brushing/Spraying) for out side surface of transformer tank.

2.0 MATERIALS:

- 2.1 Anti-corrosive Priming Paint (Red) : AA 56101
- 2.2 Anti-corrosive Priming, Paint (Brown) : AA 56101
- 2.3 High Quality full Glossy Outdoor Finishing Paint : AA 56126
- Light Grey Shade No. 631 of IS - 5
- Dark grey shade No. 632 of IS - 5
- 2.4 Oil Resistant Air Drying synthetic Enamel (Jasmine Yellow shade no. 397) : AA 56132
- or
- Oil resistant non yellowing full glossy white paint : BP 56183
- 2.5 White spirit grade 145/205 : AA 56701
- 2.6 Water proof abrasive paper grit 220 :
- 2.7 Degreasing agent : Teepol or Chemokleen liquid 1009

3.0 PREPARATION OF THE PAINTS:

3.1 Removal of skin from the paint:

Before application, any skin formed on the paint in the tin shall be carefully removed, any settled pigment broken up and loosened and the paint thoroughly stirred to ensure complete and uniform mixing constituents. Care shall be taken to avoid entraining air into the paint while stirring. The paint shall be strained through a muslin cloth or 60 mesh sieve.

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शु. Rev 02 P.D. 20/11/99	SPECIFICATION SHEETS UPDATED.
2A 11-2-00	DRG. RETRACED
03 30/06	SHEET REAFFIRMED

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Afterward before drying, clean the surface with fresh water at about 60°C by means of high pressure water ejection pump.

Finally dry the surface using compressed air.

Safety precautions:

Protect the eyes against splashes, use protective goggles and plastic gloves. Use breathing protection with prefilter fine filter and gas filter.

4.2.2 Out side surface of tank.

4.2.2.1 Tanks smaller than shot Blasting Plant.

After dressing, grinding and degreasing as per Cl. 4.1 & 4.2.1 the tank shall be shot blasted to Swedish Standard SIS 055900 Gr. SA 2.5 and then painted with priming paint or oil proof paint as required.

It is recommended that first coat of paint is applied within 24 hours of completion of shot blasting to control onset of corrosion on the surface. Before application of the paint, condition of the surface shall be visually examined. In case of any deficiency the surface shall be cleaned by suitable means (wire brushing etc.)

4.2.2.2 Tanks Larger than Shot Blasting Plant:

Such tanks shall be shot blasted in parts. To start with a portion of tank shall be blasted to Swedish standard SIS 055900 Gr. SA 2.5 and first coat of primer or oil proof paint applied preferably within 24 hours of completion of shot blasting, to control onset of corrosion on the surface.

Before application of the paint condition of the surface shall be visually examined. In case of any deficiency the surface shall be cleaned by suitable means.

4.2.3 Inside surface of tank:

Inside portion of the tank shall be shot blasted and painted with oil resistant paint (Jasmine Yellow/White shade Cl. 2.4) in the similar manner as detailed in Cl. 4.2.2.

Note: In case shot blasting facility is not available the tanks and accessories shall be sand blasted as per plant standard BP 069 00 98.

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3.2 Consistencies of the paint AA 56101, AA 56126 and AA 56132 & BP 56183

The paints shall be used at the consistencies as given in the table

Paint Specification	Flow time of the paint in cup No. B-4 to IS:3944	
	Spraying	Brushing
AA 56101	35 ± 3	70 ± 10 secs
AA 56126	35 ± 3	70 ± 10 secs
AA 56132	--	70 ± 10 secs
BP 56183	--	70 ± 10 secs

The above consistencies shall be adjusted using white spirit and the flow times shall be maintained independent of shop temperature within normal variation.

4. SURFACE PREPARATION:

4.1 Dressing and Grinding

After welding all welds and flame cut edges shall be dressed and any major surface imperfections removed by grinding.

NOTE: After dressing and grinding the tank shall be subjected to air/oil pressure tests, vacuum test as per drawing.

4.2 Descaling and Cleaning

It is necessary that surface to be painted is free from loose dust, mill scale, rust, grease, oil, old paint, soap solution, tightness testing powder etc. For surface cleaning and preparation refer BHEL standard (AA 0674101)

Prior to shot/sand blasting degreasing operation as detailed below shall be done,

4.2.1 Degreasing :

The surface shall be degreased by using degreasing agent (Cl. 2.7) mixed with water in 15% approx concentration i.e. one litre of water with 150 to 160 ml of degreasing agent. This shall be warmed to 60 to 70°C and shall be applied at a low pressure. After degreasing, the operator shall carry out a visual inspection of the result. Surface that are difficult to wash shall be inspected carefully. If impurities still remain on the objects, these shall be degreased again.

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5.2.2 Application of second coat of primer (Brown/Red) AA 56101 ; Surface shall be cleaned where necessary. The second coat of primer shall be applied as is clause 5.2.1 above.

5.2.3 Application of First coat of finishing paint - AA56126 - (Light Grey or Dark Grey)
Same as clause 5.1.1 except that paint shall be in light grey/dark grey shade (as required) finishing paint.

5.2.4 Application of second coat of finishing paint - AA 56126 (light Grey or Dark Grey) ;
Same as clause 5.1.1 except paint shall be in light grey/dark grey (as required) finishing paint.

In case of damage to painted surface, it will be re-touched with the light grey/dark grey shade paint (as required).

Note :

1. Time gap between any two successive coats shall not be more than 7 days.
2. In case baking facility is not available, surface shall be allowed to air dry for 16 hrs (min).

6. INSPECTION FOR PROCESS CONTROL:

6.1 Thickness:

6.1.1 Outside Paint film thickness:

The average total dried paint film thickness shall be within 80 to 110 microns. However at certain local points, dry paint film thickness upto 200 microns shall be acceptable.

6.1.2 Inside paint film thickness: The average total dried film thickness shall be within 25 to 60 microns. However at certain local points, dry paint film thickness upto 100 microns shall be acceptable.

The finished component shall be visually inspected for various paint film defects such as gloss uniformity of shade, wrinkles, orange peel effect, blistering etc.

6.3 Adhesion by tape test:

This test is carried out by applying & removing pressure sensitive adhesion tape over cuts made in the paint film to ensure that adhesion of paint film to metallic substrate is adequate.

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The test shall be carried out generally in line with ASTM D 3359 except that pressure sensitive Adhesive tape of 25 mm width, shall confirm to IS: 2880

Method A of ASIM D 3359 shall be followed in case thickness of film is greater than 125 microns & acceptance criterion shall be "4A" and Method B of ASTM D 3359 shall be followed when thickness of said film is between 50 to 125 microns and acceptance criterion shall be "4B".

7. REPAIR OF DAMAGED PAINT WORK:
 - 7.1 Remove the damaged paint by using chisel /Grinder or other convenient tool.
 - 7.2 Roughen the surface by using a rough emery/wire brush.
 - 7.3 Remove oil or grease from the surface by swabbing with white spirit soaked cotton cloth. Allow the residual white spirit to evaporate from the surface.
 - 7.4 Apply Primer/Finishing paint as per relevant clauses above.

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शीर्षक TITLE

PAINTING OF STEEL TANK AND ACCESSORIES
USING POLYURETHANE BASE FINISHING PAINT

1.0 GENERAL:

This specification details the process to be followed for painting steel component with epoxy primer of high solid content and polyurethane base finishing paint. The paint shall be applied by conventional/airless spraying in a booth and dried by stoving in an oven.

2.0 MATERIALS:

- | | | | |
|-----|---|---|--------------------------------------|
| 2.1 | Chemical Resistant High Build Epoxide Priming Paint | : | AA 56109 |
| 2.2 | Polyurethane Finishing Paint | : | AA 56142 |
| 2.3 | Thinner for AA 56109 & AA 56142 | : | Amercoat 65 of M/s. Goodlass Nerolac |
| 2.4 | Nitro Cellulose Stopper | : | AA 55306 |
| 2.5 | Waterproof Abrasive Paper | : | 220 Grit |
| 2.6 | Degreasing agent | : | Tee Pol or Chemokleen liquid 1009 |

3.0 PREPARATION OF THE PAINTS:

3.1 Mixing of the constituents of Priming & Finishing Paint.

These paints as supplied consist of two separate ingredients namely base and accelerator. Shortly before mixing and use, these shall be thoroughly stirred.

The base and the accelerator shall be accurately mixed together in the proportions as given in Annexure - I.

Accelerator should be added to the base and not the base to the accelerator. The paints shall be mixed and stirred until a uniform consistency is obtained.

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IN PAGE 40 OF 6 NOTE-2 ADDED.
IN PAGE 50 OF 6, 6.2 UPDATED.
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3.1.1 Consistencies of the Priming and finishing paint.

The paints mixed as per clause 3.1 shall be used at the consistencies as given on next page.

Paint Specification	Flow time of the paint in IS cup No. B-4	
	Conventional Spraying	Airless spraying
Chemical Resistant High Build Epoxide Priming Paint to AA 56109	40 to 60 Secs.	See Note-1
Polyurethane Finishing paint to AA 56142	40 to 60 Secs.	

NOTE:

- If required the Polyurethane Finishing Paint to AA 56142 shall be thinned down by adding required quantity of thinner as recommended by the supplier.

The above consistencies shall be adjusted using thinner for these paints and the flow time shall be maintained independently of temperature within normal shop variations.

IMPORT NOTE:

After mixing, the paint shall be allowed to mature for 1/2 hour. The mixed paint shall be used within 8 hrs.

3.2 Safety Precautions:

Priming Paint (AA 56109) and Finishing Paint (AA 56142) are liable to cause irritation to the skin. This may transpire into inflammation, Swelling, rash or pustules on the hands, arms and occasionally on whole of the body.

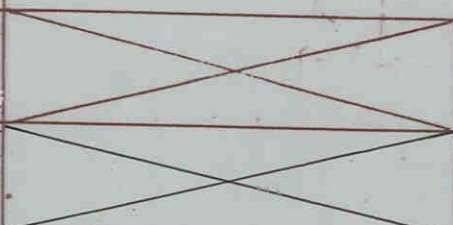
Following precautions should be observed while handling these materials:

- Work place and storage rooms should be adequately ventilated.
- Before starting the work, hands should be washed with soap and water and good barrier cream applied.
- Maximum care should be taken to avoid splashes on the skin.
- Splashing on the skin should be immediately washed with soap and water.

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4.0 Surface Preparation:

It is necessary that surface to be painted is free from loose dust, mill scale, rust, grease, oil, old paint, soap solution, tightness testing powder etc. For surface cleaning and preparation refer BHEL standard (AA 0674101)

However prior to shot/sand blasting decreasing operation as detailed below shall be done.

4.1 Degreasing:

The surface shall be decreased by using degreasing agent (Cl. 2.6) mixed with water in 15% approx concentration i.e. one liter of water with 150 to 160 ml. of degreasing agent. This shall be warmed to 60 to 70°C and shall be applied at a low pressure.

After degreasing, the operator shall carryout a visual inspection of the result.

Surfaces that are difficult to wash shall be inspected carefully. If impurities still remain on the objects, these shall be degreased again.

Afterward before drying, clean the surface with fresh water at about 60°C by means of high pressure water ejection pump.

Finally dry the surface using compressed air.

Safety Precaution:

Protect the eyes against splashes, use protective goggles and plastic gloves. Use breathing protection with pre filter, fine filter and gas filter.

5.0 APPLICATION OF PAINTS:

The paints shall be applied by conventional/airless spraying and then stoved in conveyorised painting Booth. Setting temperature and indicating temperature of all the four zones shall be 90°C ± 10°C. Stoving time shall be adjusted as per following given time. Transformer tanks- 1 hour.

Accessories/pipe work - 1 Hour
Smaller item less than 100 kg - 1 hour

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Above time shall be maintained after attaining the temp of $90 \pm 10^\circ\text{C}$.

5.1 Application of first coat of High Build Epoxide Priming paint. (AA 56109)

Priming paint as prepared in clause 3.1.1 shall be applied by spraying over the shot/sand blasted and degreased surface.

5.1.1 Drying of Paint:

The painted surface shall be dried by baking in an oven at $90 \pm 10^\circ\text{C}$.

Job shall be kept in the oven after allowing about 20 min. drying at room temperature after paint application.

5.2 Application of second coat of High Build Epoxide Priming Paint (AA 56109)

Surface shall be degreased where necessary. Second coat of primer shall be applied in accordance with the above practice.

5.3 Application of first coat of polyurethane Finishing paint AA 56142.

Immediately before painting the surface shall be degreased where necessary. Any damage which has been caused to the previous coat shall be repaired depending upon the severity of the damage. After the repairs, the surfaces shall be painted with polyurethane, finishing paint by spraying as prepared in clause 3.1.1 and dried in the oven as specified above.

5.4 Application of second coat of polyurethane finishing paint AA 56142 (if required)

Surfaces shall be degreased where necessary. Another coat of polyurethane finishing paint shall be applied in accordance with clause 5.3 above, followed by drying as above.

NOTE:

- The time gap between any two successive coats shall be not more than 7 days.
- In case baking facility is not available, surface shall be allowed to air dry for 16 hrs (Min.).

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6.0 INSPECTION FOR PROCESS CONTROL:

6.1 Quality control inspector shall visually inspect the finished component for various paint film defects such as gloss, uniformity of shade, Wrinkles orange peel effect, blistering etc.

6.2 Thickness:

The thickness of dried painted film after adequate number of primer and finish paint shall be 80 to 150 microns when measured by using a suitable instrument for the nondestructive measurement of the coats as detailed in IS: 6012-1970.

However at certain local paints, dry paint film thickness upto 300 microns is acceptable. Additional finishing coats may be given to achieve the thickness for a specific application, if can be achieved by giving further finishing coats.

6.3 Adhesion (As per ASTM D.3359): To be performed after 24 hours of application of final coat of paint.

7.0 REPAIR OF DAMAGED PAINT WORK:

7.1 Local damage unrusted:

Where local damage to the paint work has occurred without subsequent rusting the damaged area shall be cleaned with white spirit. The number of paint coats shall be applied sufficient to provide a dry film thickness not less than that of the surrounding paint.

7.2 Local damage rusted:

Where local damage to the paint work with subsequent rusting has occurred, the rust shall be removed by mechanical cleaning by emery paper grade 12/150 and followed by subsequent procedure laid down in clause 7.1

7.3 Extensive damage:

In case of extensive damage entire old film shall be removed and surface prepared as per clause 4.

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ANNEXURE-1

1.0 Mixing Ratio of Chemical Resistance High Build Epoxide Priming Paint to AA 56109.

(Stocked in CPM Stores)

TABLE - I

Supplier's Name
& Grade

Mixing Ratio in
parts by Volume
Base: Accelerator

Good lass
(Amerlock 400)

1 : 1

2.0 Mixing Ratio of Polyurethane Finishing Paint to AA 56142
(Stocked in CPM Stores) in Light Grey Shade 631 of IS:5

TABLE II

Supplier's Name
& Grade

Mixing Ratio in
Part by volume
Base: Accelerator

Goodlass
(Amerlock 450 GL)

4 : 1

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