



BHEL PIPING CENTRE, CHENNAI
BARH STPP STAGE- (3 X 660 MW) PCP PACKAGE
PAINTING AND PACKING REQUIREMENT FOR RIGID STRUTS

1. For all unthreaded surfaces of rigid struts, the following painting to be adopted
 - Surface Preparation : SSPC-SP10 (Blast cleaning)
 - Primer : 1 Coat of 50 Microns of Epoxy Rich Zinc Primer to IS 14589 (Gr II) – 92% Zinc in dry film (min), %VS =35.0 (min)
 - Shade : Grey
 - Total DFT : 50 Microns
2. All threaded surfaces shall be protected by applying good quality rust preventive coating
3. Work Order / DU/Tag No shall be stencilled and engraved as indicated in the Purchase order
4. After completion of the above activities, the product shall be properly packed to avoid any damage to the components during transit. All exposed threads shall be protected with plasto peel.
5. The rod ends (spherical bearings) shall be applied with grease and covered with thick polythene cover and properly tied so that rain water does not get into the bearings
6. For clamps, the following painting shall be adopted
 - Surface Preparation : SSPC-SP3 (Power Tool Cleaning)
 - Primer : 2 Coats of 25 Microns each of Red oxide Zinc Phosphate Primer (Alkyd Base) to IS 12744
 - Shade : Grey
 - Total DFT : 50 Microns