
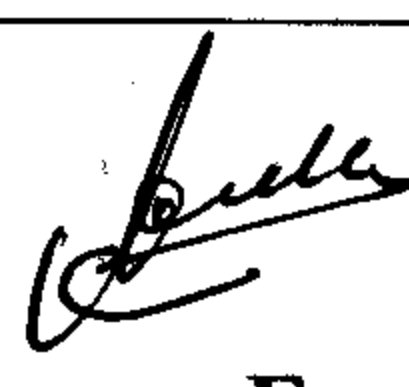



0. GENERAL :

- 0.1 The components and aggregates of Construction & Mining equipments which go into the assembly of final equipment need a variety of surface coatings and finish paints. The finishing paints also need to be applied at different stages of processing, depending on processing/assembly needs and accessibility of surfaces to painting.
- 0.2 The application of PU Primer as undercoat for finish painting on different categories of raw materials and parts is explained and codified in Company standard PR1031-C.
- 0.3 Wherever PU Paints (Primer to Company Standard C6001-53 & Golden Yellow finishpaint to Company Standard C6001-45 and Black Blue finish paint to Company Standard C6001-80) are to be used as finish paints for these components and aggregates, the code 'PF' shall be used. (also see Clause 5 of this standard for details regarding the usage of this code) .
- 0.4 In case Metallic coatings or finishing paints other than the above categories of finish paints are to be used on parts and aggregates, their details shall be specified by a 'NOTE' in the applicable drawings.
- 0.5 The stage of processing at which the finishing paint is to be applied shall be specified in the process sheet applicable to the part / aggregate.
- 0.6 Usage of recommended rust preventive oils /corrosion inhibitors on machined surfaces shall also be mentioned in the surface treatment column of the drawings. However, it shall be noted that rust preventive application by itself is not a part of the finish painting process.
- 0.7 This Issuance supersedes PR1032-C Issue-0 dated 1993-03-01.

1. SCOPE:

This standard stipulates the procedure for finish painting of parts and aggregates which are to be finish painted individually and not on the assembled product. This standard also defines the code to be used for such directly finish painted parts.

PREPARED BY : CSD	ISSUE No : 01	REPLACEMENT FOR : -	REF :
APPROVED BY :	 G	 E	 D(M)

**2. APPLICABILITY :**

S L No.	PART /AGGREGATE	PROCEDURE	REMARKS
01	Fully finished vendor supply items like engines, Transmissions etc.,	PU paint system	As per Clause 3 of this standard
02	Exhaust system parts	Heat Resistant Aluminum paint to Company Standard C6001-50	—
03	Exterior surfaces of aggregates / assemblies manufactured at BEML, like Transmissions, Torque converters and Hydraulic components.	Follow pre-painting process as per Company Standards PR1031-C and PR1016-C.	Painting process as per Clause 3 of this standard.
a)	Accessible to finish painting when the equipment is fully assembled	Procedure as per PR1007-C 'Final painting of Construction & Mining Equipments'.	Finish paint to be specified in the relevant equipment drawings.
b)	Surface of components not accessible to finish painting in fully assembled condition.	Parts / aggregates to be finish painted as described in Clause 3 of this standard.	Refer Appendix-A for components & aggregates
04	Spare parts requiring finish painting.	Clause 3 of this standard	Packaging not covered in this standard.

**3. DETAILS OF FINISH PAINTING :**

- 3.1** Ensure the first coat of P.U Primer to Company Standard C6001-53 is applied as described in clause 3.1 of Company Standard PR1006-C.
- 3.2** Ensure P.U Putty to Company Standard C6001-49 is applied after first coat of primer as described in clause of 3.2 of Company Standard PR1006-C.

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**3.3** Ensure P.U surfacer to Company Standard C6001-48 is applied as described in clause 3.3 of Company Standard PR1006-C .

**3.4** The first finish coat of PU Golden Yellow to Company Standard C6001-45 / Black Blue C6001-80 is to be applied as described in 3.4 of Company Standard PR1006-C .

## **4. GENERAL REQUIREMENTS :**

Company Standard PR1007-C shall be referred for the following processes.

SL No	PROCESS	CLAUSE
01	System requirements	9.1
02	Spraying	9.2
03	Painting defects	9.3
04	Procedure for spot Touch-up	9.4
05	Inspection	9.5

## **5 USE OF CODE – 'PF'**

The code 'PF'– PR1032-C' shall be mentioned in the surface treatment columns of the drawings of components / aggregates to be independently finish painted with Polyurethane paints. The mention of this code, viz. 'PF' signifies that the component is to be finish painted directly after ensuring the application of PU primer, PU putty and PU surfacer.

## **6. FINISH PAINTING :**

Some components and aggregates for finish painting with PU Golden Yellow/ Black Blue to Company Standard C6001-45/ C6001-80 are indicated in Appendix-A for illustration.

## **7. CONNECTED STANDARDS :**

- 1) PR1006-C - 'Surface preparation, pre-treatment and painting process for parts & fabricated structures'
- 2) PR1007-C - 'Final Painting of Construction and Mining Equipments'
- 3) PR1031-C - 'Rust prevention by process primer application - Codes '

**NOTE :** Latest issuance of the standards shall be referred.

**APPENDIX - A****Finish painting of components and aggregates.**

- 1 Components and aggregates like Structures, Assemblies, Chassis, Tie rods, Revolving frames, Final drive cover, Hydraulic & fuel tanks, Brake booster assembly, Diagonal brace, Track frame, Engine hood, Ripper assembly, Control valves, P.T.Os, Pipes, Track chains, Track rollers, Canopy, etc., are to be finish painted with PU Golden Yellow to Company Standard C6001-45 / black blue to Company Standard C6001-80. For painting process Company Standard PR1006-C shall be referred.
- 2 Dash boards made out of Fiber reinforced plastics shall be painted with PU primer to Company Standard C6001-75 and PU finish to C6001-73.
- 3 Machined surfaces not requiring painting shall be protected with rust preventive as per Company Standard C6001-10
4. Drilled holes and tapped holes shall be protected with end caps.

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