

	PAINTING INSPECTION RECORD		Doc. No.	GR/TD/4390
			Project:	MRS1
Name of item	GRIT-BLASTING, PRIMER AND FINISH COAT OF BOGIE PAINTING		Inspected by	Approved by
Drawing No.	<input type="checkbox"/> 525-83026 <input type="checkbox"/> 525-83027 <input type="checkbox"/> 525-83028 <input type="checkbox"/> 525-83029	Signature		
Serial No.	Type of Bogie <input type="checkbox"/> DMC <input type="checkbox"/> TC <input type="checkbox"/> MC	Date		
BMRC-BF-M-		Result		
Insp. Equipment	Naked Eye, Comparator of SIS SA 2 ½ & Paint Thickness Meter			

No.	Inspection Items		Acceptance Criteria	Test Results	Remarks
1	Degreasing/ Cleaning	Check oil, rust etc. on the surface to be coated	Free from oil, rust etc.		
2	Interior Surfaces	Surfaces to be welded	Shall be masked		Paint interior surfaces of side frame and transom with heat resistant Al paint to Gr-1 of IS 13183-91 before closing with top plate.
		Grit Blast	ISO 8501-1, Min. SA 2 ½ & Avg. 45µm.		
		Dry Film thickness	Nominal: 40 µm.		
3	Exterior Surfaces	Machined surfaces	Shall be masked		
		Grit Blast	ISO 8501-1, Min. SA 2 ½ & Avg. 45µm.		Mild Steel Grits
4	Primer Application	Environment conditions	Temperature: ≥ 3°C Humidity: < 85%		
		Dry Film thickness	40 ≤ t ≤ 80 µm. Nominal: 60 µm.		Max.120 µm
		Check for unpainted, dirt, peel and run	Shall be good		
5	Finish Coat	Environment conditions	Temperature: ≥ 3°C Humidity: < 85%		
		Dry Film thickness	40 ≤ t ≤ 80 µm. Nominal: 60 µm.		Max.120 µm
6	Total Dry Film Thickness (DFT)	Primer + Finish Paint	80 ≤ t ≤ 160 µm. Nominal: 120 µm.		Max.240 µm
7	Adhesion Test	Adhesion of paint	5B of ASTM D 3359 (Method B)		

Remarks:

- Machined surfaces shall be protected with Anti-rust coating to spec. IS 1154-2000.**

NCR Report, if any	Record no. MRS1 690 BF PR 01	Rev.	Page
		Nil	1/1