

TECHNICAL DELIVERY CONDITIONS

Project : Metro cars.
Item : Heat Resistant Aluminium Paint to IS:13183-91

SI No.	Part No.	Item Description
1	R605100087	Heat Resistant Aluminium Paint to standard IS:13183-91 of Grade-I

1. Aluminium Paint shall be supplied conforming to standard IS:13183-91 of Grade-I. The firm shall carry out the following test & submit all test certificates along with each supplies.

Sl. No.	Characteristic	Requirement
1	Color	Metallic Aluminium, As per clause 4.7 & table 1 of IS:13183-91
2	Finish	Bright, Smooth and Lustrous, As per clause 4.7 & table 1 of IS:13183-91
3	Drying Time: a. Surface dry hrs, Max b. Tack free hrs, Max c. Hard dry hrs, Max	1 hrs, As per clause 4.7 & table 1 of IS:13183-91 3 hrs, As per clause 4.7 & table 1 of IS:13183-91 18 hrs, As per clause 4.7 & table 1 of IS:13183-91
4	Flash Point (°C)	Above 27 °C, As per clause 4.7 & table 1 of IS:13183-91
5	Non-Volatile Matter % by mass, min	30, As per clause 4.7 & table 1 of IS:13183-91
6	Flexibility and Adhesion after (48 hrs air dry)	No damage or detachment or cracking of the film, As per clause 4.7 & table 1 of IS:13183-91
7	Scratch Hardness (750 g, load) (48 hrs air dry)	Bear metal shall not be visible through the scratch, As per clause 4.7 & table 1 of IS:13183-91
8	Protection against corrosion under conditions of condensation(7 days)	To pass the test, As per clause 4.7 & table 1 of IS:13183-91
9	Consistency seconds, Min	20 seconds, As per clause 4.7 & table 1 of IS:13183-91
10	Heat resistance (DFT=20-30 microns): a. Hot rolled steel (Grade I) b. Cold rolled steel (Grade I)	Free from cracking, blistering, flaking or peeling (As per Annexure-B of IS:13183) Hot rolled - 600° C @ 8 hrs Cold rolled - 600° C @ 24 hrs
11	Salt spray resistance: a. Hot rolled steel (24 hrs) b. Cold rolled steel (96 hrs)	Shall show not more than a trace of rusting and not more than 5 blisters, none of which is larger than 1mm in diameter.(As per Annexure-C of IS:13183-91)
12	Water resistance (24 hrs @ 27 ± 2° C)	No wrinkling or blistering, slight whitening or dulling allowed, (As per Annexure-D of IS:13183-91)
13	Mass in Kg/10 ltrs	Min ± 3% of approved sample, As per clause 4.7 & table 1 of IS:13183-91
14	Shelf life	12 to 24 months
15	Packing unit	4L (The packing shall be turned regularly twice a month to prevent the deposition)

2. Chemical Resistance : Indicate chemical resistance of Aluminium heat resistant paint to the substances as per table given below as Poor/Fair/Good.

	Acids	Alkalis	Solvents	Salts	Water
Splash & Spillage	-	-	-	-	-
Fumes	-	-	-	-	-

3. The firm shall be a original manufacturer of paint/ Supplier providing all the material test certificates as given above.

4. Packing & Marking shall be as per clause 5 of Standard IS:13183-91.

5. The supplier shall submit confirmation for the above points along with their technical offer.



GRB