



COMPANY STANDARDS

PR1029-C

TITLE:

**RUST PREVENTIVE COATINGS FOR
CASTINGS AND FORGINGS**

PAGE No. 01 OF 02

DATE: 2007-11-14

0. GENERAL :

This standard provides requirement of rust preventive coating on machined and non-machined surfaces of castings and forgings, to avoid rust during storage.

This issuance supersedes PR1029-C Issue-0 Dated 1999-01-12. This issuance is necessitated due to introduction of polyurethane painting system in the company.

1. SCOPE :

This standard covers the scheme for rust prevention of castings and forgings as supplied to BEML.

2. CASTINGS :

2.1 NON FERROUS CASTINGS AND FORGINGS :

No anti-corrosive coating is envisaged for these items.

2.2 GREY IRON AND S.G. IRON CASTINGS:

Blast clean if necessary to remove sand, scale or other surface contaminants.

Apply PU (Polyurethane) primer to Company Standard C6001-53 on all external surfaces and accessible internal surfaces.

2.3. STEEL CASTINGS :

2.3.1 STEEL CASTINGS REQUIRING NO FURTHER HEAT TREATMENT IN BEML:

Shot blast to remove adherent and fused sand and scales.

Apply PU (Polyurethane) primer to Company Standard C6001-53 on all external and accessible internal surfaces. Apply rust preventive oil to Company Standard C6001-08 / IS: 1153 on machined surfaces if any.

2.3.2 STEEL CASTINGS REQUIRING FURTHER HEAT TREATMENT IN BEML :

Shot blast to remove adherent and fused sand and scales.

Apply rust preventive oil to Company Standard C6001-08 / IS: 1153 on all external and accessible internal surfaces.

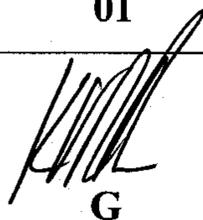
PREPARED BY :
CSD

ISSUE No. :
01

REPLACES:
PR1029-B

REF :

APPROVED BY :


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NEW FRONTIERS. NEW DREAMS

3. STEEL FORGINGS :

Shot blast to remove mill scale completely.

Apply rust preventive oil coating to Company Standard C6001-08 / IS: 1153.

4. REMOVABILITY :

The rust preventive applied on the machined surfaces shall be easily removable by wiping with cloth soaked in petroleum solvents/kerosene.

5. STANDARDS CITED :

1. C6001-53 - PU Primer Golden Yellow.
2. C6001-08 - Temporary corrosion preventive, hard film, solvent deposited
3. IS : 1153 - 'Temporary corrosion preventive, fluid, hard film, solvent deposited'

NOTE : Latest issuance of standards shall be referred.

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