

ANNEXURE H (Optional)

Check list for Shot Blasting and Painting

1. Mandatory Facilities			
S.No	Description	Minimum requirements	Actual available with firms
1	Type of blasting unit available	Centrifugal / Compressed-air (300CFM, Air outlet pressure – 7Kg/cm ²)	
2	Facilities checking the quality of Compressed Air	Oil separator/ Water separator Blotter Test	
3	Facility for measurement of surface temperature & Relative Humidity	Digital measurement of temp & RH	
4	Availability of NACE Pictorial Std/ ISO 8501	ISO 8501	
5	Surface Profile meter, Digital DFT gauge (0-1500μ) and Wet Film gauge	Min. one no.	
6	Powered agitators for proper mixing of paints (Mandatory)	Battery powered / pneumatic agitators for small paint bottles and jars	
7	Handling Facility	EOT / Mobile Cranes - 2 x 10 MT	
8	Adhesion test : Cross Cut test as per ASTM D3359	One equipment	

2. Instructions for Mandatory Compliance by Vendors			
S.No	DESCRIPTION	Vendor Response	Remarks
1	Type of Abrasive materials used & procurement source : Copper slag, Iron slag, Al ₂ O ₃ and other environmental friendly abrasives permitted by TNPCB. Abrasives should be free from Cl, S, Si and permissible concentration of these are Cl<10ppm, S<20ppm and Total Si<1%.	Accepted / Not Accepted	
2	Solvents used for degreasing : Alkaline cleaners	Accepted / Not Accepted	
3	Shot blasting, Primer, Intermediate and Finish painting shall be done at one place.	Accepted / Not Accepted	
4	Painting shall commence within 4 hrs. of blasting	Accepted / Not Accepted	
5	Painting must be done where in external dust particles must not be allowed in order to provide an effective and uniform coating.	Accepted / Not Accepted	
6	All measuring devices/gauges should be calibrated from NABL accredited institution and records must be maintained.	Accepted / Not Accepted	
7	Qualified or experienced coating personnel must be deployed to provide a protective coating	Accepted / Not Accepted	

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8	Dust settled after blasting shall be removed by blowing air on the surfaces of components.	Accepted / Not Accepted	
9	Air less spray shall be used for paints with higher volume solids ($\geq 60\%$) and air spray shall be applied for other paints.	Accepted / Not Accepted	
10	Blasted products must be kept/stored in a clean space and to be painted within 4 hours to avoid painting imperfection.	Accepted / Not Accepted	
11	It is mandatory to have all quality records of workplace (i.e. calibration, surface cleaning, etc.) and it needs to be maintained properly.	Accepted / Not Accepted	
12	TC for shots/ grits must be available for all batches.	Accepted / Not Accepted	

Vendor's Signature with seal