RAIL COACH FACTORY, KAPURTHALA

Dated:07/10/2024 MD35131

Sub: Issue of amendment-1 to MDTS-48279 Rev-04 Technical Specification for Adhesion Promoting Primer.

Ref: Design office letter no.MD22151 dated 04.10.24.

Following clause of MDTS-48279 Rev-04 page 8 of 15 amended as below:

Existing

S.	Test	Type	Size in	Painting	DFT	Duration of Air	Special Instruction
No.		of	mm	Detail		Drying Before	
		Metal			2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	Commencement	8 8
	10	Panel		f .	0	of test	
				9	0 p	(Applicable for	*
			5	2		panels either air	R .
					8	dried or dried at	
				8	*	elevated	
				×	2 B	temperature)	
6.	Adhesion	S.S.	150 X 50	One coat	35- 40μ	7 days	Cross cut 1 mm
			X .315	of			(ASTM D3359 02.)
				Adhesion		2	Pull up adhesion as
	2			Promoting	o .		per ASTM D 4541
			- i	Primer			

Revised

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S.	Test	Type	Size in	Painting	DFT	Duration of Air	Special Instruction			
No.	5.	of	mm	Detail	0	Drying Before	V 10			
		Metal			5	Commencement	a a			
		Panel			2	of test	0			
	8		20	8 g	9	(Applicable for panels either air	2 9			
			19			dried or dried at				
				(4)		elevated	N 0			
550						temperature)				
6.	Adhesion	S.S.	150 X 50	One coat	35- 40μ	7 days	Cross cut 1 mm			
			X1.25	· of			(ASTM D3359 02.)			
				Adhesion			Pull up adhesion as			
				Promoting			per ASTM D 4541			
	,			Primer						

This has the approval of competent authority

CQM CPLE CWE/Fur

CMM/ HSQ

CMM/TKJ Dy.CMM/Fur CWE/Shell

CMT SSE/Filing Section/Design

Dy.CMM/LHB/Fur. SSE/Library/Mech. Design

Dy.CMM/G

Dy. CPLE-I,II SSE Record (Original copy)

SSE/Dev.

Copy for kind information to:

CDE

Dy.CME/Shell-Design

Dy.CME/V-D