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|  | **ONKAR ENGINE & GENERATOR (P) LIMITED** | | **Doc No: OM/IG/0** |
| **COATING INSPECTION GUIDELINES** | | **Rev No. /Date: 00/25.06.18** |
| **Department: Polymer Coating** | **Process Name: - Coating Inspection** | |

**Coating Finish**

* Coating should be smooth as per sample.
* Coating should be not crack.
* Any short fill should be not appear in coating surface.
* Any uncovered surface and holes should be not appear in coating
* Under This type of testing taken 100 % coating tank.

**(Note:** Use web Camera for bottom side coating inspection.)

**DFT**

* Average DFT should be >80 microns to 400 microns Avg. in all types of Polymer coating tank model.
* This type of testing done As per sampling plan.

**Pinhole**

* Any Beep Sound not found during pinhole testing of any types of Enamel coating tank model at 9 V
* Under This type of testing taken 100 % coating tank.

**(Note**: \* During This Type of Testing always remember the hand not touch with Sponge otherwise pinhole beep sound found so check it once if any pinhole found.

\*\*Under the inlet and outlet pipe found beep sound during such type of test because it connected with uncoated surface due to wet sponge so always remember and once check this if any pinhole deducted near.)

**HST**

* After visual and pinhole test ok tanks taken under HST at 8 bar for 2 min.
* This type of testing done One in each lot(one lot 120 nos).

**Note:** **Against These types of guidelines, coating tank taken under rejection and inform to supervisor for it and send to tank for storage in prescribed region after final decision of line supervisor**.

**Prepared by: Issued by: Approved by:**