

**PT/285/0609 – AS (June 2009)**  
**Assessment of Deepak Fasteners Ltd**  
**for the application of Rilsan coating**  
**for threaded fasteners - schedule**



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### **1. Scope**

To assess the anti-corrosion coating for threaded fasteners produced by Deepak Fasteners Ltd to WIS 4-52-03: using Rilsan ESY Blue 7265 with Primgreen Lat 12035 primer.

### **2. Assessment schedule**

2.1 To assess the performance of the Rilsan anti-corrosion coating against WIS 4-52-03.

2.2 To audit the quality control procedures at the Ludhiana plant, India.

### **3. Review of performance tests**

3.1 The following performance tests are required by WIS 4-52-03:

- Effect on water quality. The coating needs to comply with BS 6920 to demonstrate compliance with the requirements of Regulation 31 of the Water Supply (Water Quality) Regulations 2000
- Coating thickness and thickness of each layer (to value declared by manufacturer)
- Freedom from holidays/pinholes
- Adhesion (V-cut test, Cross-hatch test)
- Cure
- Long term protection of component (salt spray)
- Resistance to damage (impact)
- Ability to hold torque load

### **4. Review of procedures**

In addition to the performance of the anti-corrosion coating, the following items are checked.

Quality control, as it applies to:

- incoming materials;
- control of production;
- outgoing products (quality control testing)

### **5. Reference documents**

1. WIS 4-52-03 Specification for anti-corrosion coatings on threaded fasteners. Issue 1: 1994 (as amended).