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संस्थागत प्रमाणन SGN & DAI		संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF06033 Rev 08 पृष्ठ का Page 1 of 5																															
		GRINDING WHEELS																																	
संस्थागत प्रमाणन SGN & DAI	संस्थागत प्रमाणन SGN & DAI	1. General This specification governs the technical requirement of Grinding Wheels for use in fettling of Steel Castings.																																	
		2. Application The grinding wheel shall be used after fitting/mounting on portable pneumatic grinders (CPT or equivalents) and/or Swing Frame Grinder for large surface grinding in dry process. The castings to be ground shall be of various material grades such as Plain C steels, Low alloy steels containing Cr, Mo, V, 13Cr4Ni Stainless Steels and 9Cr 1 Mo steels. The cutting wheel mentioned at serial no 4.5 is meant for cutting fire clay refractory hollowares.																																	
संस्थागत प्रमाणन SGN & DAI	संस्थागत प्रमाणन SGN & DAI	3. Compliance with National Standard This specification is related to IS:2324 –1985 Reaffirmed 2014 For dimensions and shape IS:3300 –1980 Reaffirmed 2018 IS:8915 –1978 Reaffirmed 2018 Tolerance as per IS:13596 – 1993 Reaffirmed 2014 Safety requirements as per IS:1991 or EN12413																																	
		4. Size and Shape and type of bonding																																	
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COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.		5. Shelf Life The Resinoid bonded wheels shall have minimum Shelf Life of 2 years from date of despatch. For Vitrified type wheels there shall be no Shelf Life.																											
इस प्रस्ताव में दी गयी सूचना भारत हेवी इलेक्ट्रिकल्स की संपत्ति है। इसका प्रसारण एवं प्रयोग केवल माली अधिकारी की उपस्थिति में ही किया जा सकता है। This is a confidential document and its use should be restricted to the authorized personnel only.		6. Test and Acceptance For established suppliers', the material shall be accepted on the basis of Test and Guarantee Certificates. During technical evaluation of tender enquiry, vendor will have to confirm that the model offered is same as that mentioned against individual types of wheels mentioned in Clause 4. For those cases where the model number is not mentioned, vendor will have to confirm that the offered model is same as that previously supplied and accepted at CFFP. For new vendors or vendors offering new model of grinding wheels, shop trial at technical evaluation stage shall be additional requirement. For this purpose, 2 Nos. wheels of the type asked for should be supplied free of cost alongwith submission of techno-commercial bid. The wheel shall be used for shop trial at CFFP and technical suitability of the wheel shall be judged based on shop trial.																											
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सुपरसेड्स NO आगामी सुविधा सूचक को अधिवर्धित करें	7. Marking All the grinding wheels shall be marked individually for safe operating speed, date of expiry of shelf life (in case of Resinoid bonded wheel) and grade. In case of wheels are of small size such as mounted point wheels, marking on individual wheels can be left out, however, detailed marking on the box should be given indicating safe operating speed, date of expiry and grade (if applicable).		
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	8. Inspection, Deviation and Replacement 8.1. BHEL reserves the right to inspect material at site before despatch. The supplier shall intimate in advance enclosing a copy of test certificate of the material offered for inspection. However, inspection at BHEL shall be final. The supplier shall offer BHEL representative all reasonable test facilities without charge to satisfy the latter that the material is being furnished in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed test elsewhere. 8.2. If the material received is not found in accordance with the requirements, it shall be rejected and the supplier will have to replace it free of cost at the earliest.		
	9. Test Certificates: 9.1 Unless otherwise stated one original and three copies of original manufacturer's test certificates shall be supplied along with each consignment giving following information. In order to facilitate quick clearance of material, the supplier shall ensure to send a copy of test certificate along with despatch document. 9.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to trader's invoice stating the batch No/lot No., etc. of the supply. 9.3 The test certificates should have at least the following details: BHEL PO No. Grinding Wheel Details Manufacturer's Name/ Trade marking if any Date of Expiry		
इस प्रालेख में दी गयी सुचना भारत भारती इलेक्ट्रिकल्स की संपत्ति है। इसका प्रयोग एवं अवलोकन केवल केवल ही की जा सकता है, जो कि कंपनी के हित में नहीं है, न कि अन्य रूप में किसी भी तरह प्रयोग, जो कि कंपनी के हित में नहीं है, न कि अन्य रूप में	10. Packing The grinding wheels shall be suitably packed to avoid any damage in transit and storage. The packing is to be of the original manufacturer's. The packing should bear the details such as supplier's name and trade mark, if any; Name of product, Date of manufacturing, Shelf life, Batch No.		
निर्माणकर्ता SIGN & DATE			निर्माणकर्ता WORKED BY जांचकर्ता CHECKED BY
निर्माणकर्ता SIGN & DATE			Lavin Agrawal R Lakra 8/6/19

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REVISION NO		REVISION RECORD SHEET					
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		02	1. Specification prepared in new format. 2. Specification number sequence updated. 3. Grades for Grindwell Norton Ltd. updated. 4. Details of Depressed Centre Wheel and Mounted Point Wheel introduced.	Whole Doc. Do Page 1&2 Page 2		06/08/2004	
		03	Equivalent grades for M/s SAK Abrasives introduced. Tolerance on $\phi 63$ wheel introduced. Purpose of $\phi 400$ wheel mentioned Spindle dia for mounted point wheel revised.	Page 1-2 Cl. 4.1/2 Page 1 Cl. 4.4/3 page 2 Cl. 4.6 page 2		10/2/06	
		04	Grades for Depressed centre wheel for M/s Carborundum added	Cl. 4.4 Page 2		21.3.07	
		05	Grades of Refractory cutting wheel revised	Cl. 4.4 Page 2		14.5.07	
		06	Clause 9 & 10 modified	Cl. 9 & 10		17.8.09	
		07	Grades for M/s Apidor added. Grades of M/s Sak Abrasive removed.	4.0		10/1/2014	
		08	Clause 4 updated for including models which have been used in shop floor. Clause 2, 3, 6 and 7 modified.	1, 2, 3		08/6/2019	
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8/6/19