1	At un su	संस्थान	कय वि	नर्देश	(सी.एफ.एफ.	र्री – हरिद्वार)	FF536	85	Rev	v. 04	
	milia			(141-14-61 (111.642.64		iii circuity	पृष्ठ		का		
-		PLANT		HASE FP - HAF	SPECIFI RDWAR)	CATION	Page	1	of	4	
		CHR	OMITE SA	ND FC	OR USE IN	FOUNDRIE	ES				
	1. Genera	al:				CONTRO	DLLED (co	PY 2	2	
	This sp	ecification covers	s the requiren	nents of	Chromite sand	for use in four	dries.				
	2. Applica	ation:									
		romite sand shal	ll be used for	facing of	f pattern and co	ore boyes in m	ould and	core	maki	ina	
1					pattern and co	ore boxes in this	Julu ariu	core	IIIaki	ing.	
	3. Compi	iance with nat	ional standa	rd:	I Shifts Shift						
This specification is based on IS-6788:1973, reaffirmed 1997.											
4. Physical and Chemical Characteristics:											
	4.1 Chromite sand grains shall be crystalline, mostly sub-angular in shape.										
4.2 The material shall have shining black appearance and shall be free from foreign material, e.g. low melting point minerals, carbonates.											
4.3 Chemical Composition:											
Chromite sand shall have typical analysis as under:											
	0	r ₂ O ₃	46% Mi	n							
		e ₂ O ₃	27% Ma								
		lgO	12% Ma								
		I_2O_3	16.5% N								
		iO ₂	1.1%								
		aO	0.5%								
	4.4 Clay -	- 0.5 % max.									
4.5 Moisture - 0.2% max.											
4.6 pH value of sand shall be in between 6.5 and 8.0											
	4.7 Turbio	dity - 210 ppm m	nax.								
	RMI	SOMNATH GHOSH	. 1	अबुवादक	ŤRANSLATED BY	-		0	n		
	MPIC S	HYAM BABU	Myoundal	विर्माणकर्ता	WORKED BY	T-DAVE		14	-		
		KB SUBRAMANYAM	Hessmanyaw	जांचकर्ता	CHECKED BY	AK CHAKRABORT	ΓY	V	0		
+	CPSC सहमत विभाग	नात	व्यनांक एवं हर्मासर	पर्यवेक्षणकत	f SUPERVISED BY	AK CHAKRABORT	ry	11/	9		
	AGREED	NAME	DATE & SIGNATURI					100			
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-	DEPTT			स्थीकृति	संस्थान	मानक सर्वि	मेति				
-	DEPTI			स्थीकृति APPROV		मानक सरि STANDARDS C		EE			

E		संस्थात	क्रय विनिर्देश	(A A			FF 53685 Rev 04			
SIGN & DATE	नी एम ई एम	टाटवान	क्रम विशिष्टा	(सा.एफ.एफ.पा -	(५.एफ.पा – हारब्रार)			का		
SIGN	HH	PLANT	PURCHASE (CFFP - HAR		TION	Page	2	of	4	
INVENTORY NO	5. Grain size	e & distribut	ion:		CONTR	OLLED	COL	PY		
INVEN	5.1 The Grain	Fineness No. ((GFN) of chromite s	and shall be AFS	15 to 55.					
agus agus agus agus agus agus agus agus	Grain distribution:									
में अधिकमित करता	Total retention on ASTM Sieve Nos.50, 70 and 100 shall be 70% min. (Sizes corresponding Sieve Nos. 50, 70 and 100 are 300, 212 and 150 microns)									
Electrical intal to the	5.2 Fines i.e. grains having size less than 150 microns (-100 ASTM) shall be 4.0% max.									
arat Heav	6. Sampling:									
he property of Bh indirectly in any we he company	Samples shall be drawn in accordance with IS-1811: 1961 for testing purposes.									
I AINL iments is t firectly or terest of i	7. Inspection, Deviation and Replacement:									
The information on this documents is the property of Bhara Heavy Electrical Limited It must not be used directly or indirectly in any way detrimental to the interest of the company	7.1 BHEL reserves the right to inspect material at site before despatch. The supplier shall intimate in advance about readiness of material 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 facilities without charge to satisfy the latter that the material being furnished is 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									
म भारत इ प्रयोज,	prescribed tests elsewhere.									
ियं ए न इस प्रतेख ्या है। यूपना भारता है। एवं अप्रत्यंक रूप है। _{पा} री भी तरह प्रयोख, इ हमिनमस्म हो न किया जाए ।	7.2 The material shall be tested in CFFP/BHEL as per Clause 4,5,6,7 for new suppliers. For established supplier, the testing shall be done on surveillance basis.									
	7.3 If the material received at CFFP 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.									
स्पत्वापिकार, एवं गोपनीयरू स्व प्रस्व स्वेन्ट्रिस्ट में सम्पत्ति है इसम प्रवन्न एवं अप्रवन्न रूप से असी संपनी में हित में हामिनरूक हो म क्या जाए	7.4 For any de- obtained in		he specification sou	ight by the suppli	er, prior ap	oproval o	f BHEL	. mus	t be	
SIGN & DATE				•		_				
				जिर्माणकर्ता WORKED BY	T DAVE		7			
लामग्री कुषी संख्या				जांचकर्ता CHECKED BY	AKC/	1	7			

NO SIGN & DATE	मार्थान क्रय विनिर्देश (र	जा.एफ.एफ.पा - हारबार)	
	DI ANTE DUD CHACE		पृष्ठ का
ON I	PLANT PURCHASE (CFFP - HARD	SPECIFICATION OWAR)	Page ³ of ⁴
INVENTORY NO	8. Test Certificates:	CON	TROLLED COPY
The information on this documents is the property of Bharat Heavy Electrical of sufare Bre search in Limited It must not be used directly or of the company	 8.1 Unless otherwise specified, one original and manufacturer shall be supplied with each of order to facilitate quick clearance of material certificate along with despatch document. a. BHEL PO No. with Date b. Specification No. c. Supplier reference / trade mark d. Identification No. / Batch No. e. Properties as per Clause 4 & 5 f. Any other specific information which certificates with linkage to supplier's invoice st 8.2 Suppliers other than the original manufacture certificates with linkage to supplier's invoice st 9. Packing and Marking: 9.1 Chromite sand shall be packed in bags pickup/contamination/loss of material during 9.2 The packing shall be of the original manufacture clearly marked with the following: 	consignment bearing the al, the supplier shall ensure that the supplier would like to restall ensure providing or sating the batch No., lot No.	following information. In the to send a copy of test to send a copy
editional Country of the second of the secon	Supplier' name Name of the material Identification No./Batch No. Net weight		
SIGN & DATE			

ш	वीएम	र एक संस्थान	क्रय विनिर्देश (सी.एफ.एफ.पी		FF5	FF53685 Rev 04				
SIGN & DATE	B	4	PURCHA	SE SPECIFICAT	ųq∞	का 4 of 4				
INVENTORY NO	RECORD OF CHANGES CONTROLLED COPY									
	REV CODE	NO. OF CHANGES	DOCU. NO.	SHEET NO.	SIGN	DATE				
of the company	01	Clause 6.4 added Clause 8 modified.	1.	2		29.08.03				
y way detrimental to the interest of	02	 Clause no. 4,5 and 6 modified. TC requirement modified. 		1 and 2		25.10.06				
indirectly in any way de	03	1. Clause No. 4.3 modified and 4.8 deleted		3						
दित के हाकिकरक हो not be used directly or	04	Clause 8 & 9 modified to introduced original manufacturer's criteria in test certificate & packing		1 4	2	27.02.07 18.7.09				
आरताड होती हतेनिकुचल्य की सम्प्रतित है एन 🔭 अपरताड लय हो किसी भी तरह पतीज, को कि सम्बन्धी है हिन ब किया बाप I										
	DISTRIBUTION OF PRINTS									
अप्रतास कव	RMI		\							
	STANDARD SECTION		/							
	MPIC		/		^					
	1			निर्माणकर्ता WORKED BY जांचकर्ता CHECKED BY	T DAVE	R				

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