










दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)		FF53685 Rev 04													
		PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का Page 1 of 4													
सामग्री सूची संख्या को अभिलेखित करें	SUPERSEDES INVENTORY NO	CHROMITE SAND FOR USE IN FOUNDRIES															
		1. General: CONTROLLED COPY 2 This specification covers the requirements of Chromite sand for use in foundries.															
2. Application: The Chromite sand shall be used for facing of pattern and core boxes in mould and core making.																	
3. Compliance with national standard: 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:																	
<table border="0" style="width: 100%;"> <tr> <td style="width: 40%;">Cr₂ O₃</td> <td style="width: 60%;">46% Min.</td> </tr> <tr> <td>Fe₂ O₃</td> <td>27% Max</td> </tr> <tr> <td>MgO</td> <td>12% Max</td> </tr> <tr> <td>Al₂O₃</td> <td>16.5% Max.</td> </tr> <tr> <td>SiO₂</td> <td>1.1% Max.</td> </tr> <tr> <td>CaO</td> <td>0.5% Max</td> </tr> </table>						Cr ₂ O ₃	46% Min.	Fe ₂ O ₃	27% Max	MgO	12% Max	Al ₂ O ₃	16.5% Max.	SiO ₂	1.1% Max.	CaO	0.5% Max
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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 Turbidity - 210 ppm max.																	
हस्ताक्षर एवं दिनांक	RMI	SOMNATH GHOSH	अनुवादक	TRANSLATED BY													
	MPIC	SHYAM BABU	निर्माणकर्ता	WORKED BY	T DAVE												
सामग्री सूची संख्या INVENTORY NO.	CHAIRMAN CPSC	KB SUBRAMANYAM	जांचकर्ता	CHECKED BY	AK CHAKRABORTY												
	सहमत विभाग AGREED DEPTT	नाम NAME	दिनांक एवं हस्ताक्षर DATE & SIGNATURE	पर्यवेक्षणकर्ता SUPERVISED BY	AK CHAKRABORTY												
			स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE														
			तैयार : फाउण्ट्री टेक्नोलॉजी PREPARED : FOUNDRY TECH	जारी : फाउण्ट्री टेक्नोलॉजी ISSUED : FOUNDRY TECHNOLOGY	दिनांक DATE 18.8.09												

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सार्वजनिक सूची संख्या SUPERSEDES INVENTORY NO	8. Test Certificates: <i>CONTROLLED COPY</i> 8.1 Unless otherwise specified, one original and three copies of test certificate from the original manufacturer shall be supplied with each consignment bearing the 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. <ul style="list-style-type: none"> 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 the supplier would like to convey. 8.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to supplier's invoice stating the batch No., lot No., etc of the supply.													
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स्वतंत्राधिकार एवं गोपनीयता इस प्रलेख में सूचना भारत हेतु हस्तक्षेपकारी नहीं सम्मिलित है। इसका प्रयोग एवं आश्रय इस से किसी भी तरह प्रत्यक्ष, अप्रत्यक्ष, या किसी भी प्रकार से किया जाये।	9. Packing and Marking: 9.1 Chromite sand shall be packed in bags. However, adequate protection from moisture pickup/contamination/loss of material during transportation and storage shall be provided. 9.2 The packing shall be of the original manufacturer's. The bags containing chromite sand shall be clearly marked with the following: <div style="margin-left: 40px;"> Supplier's name Name of the material Identification No./Batch No. Net weight </div>													
दिनांक SIGN & DATE	<div style="text-align: center;">DISTRIBUTION OF PRINTS</div>													
सार्वजनिक सूची संख्या	<table border="1" style="width: 100%;"> <tr> <td style="width: 30%;">निर्माणकर्ता WORKED BY</td> <td style="width: 20%;">T DAVE</td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> <tr> <td>जांचकर्ता CHECKED BY</td> <td>AKC</td> <td></td> <td></td> <td></td> </tr> </table>				निर्माणकर्ता WORKED BY	T DAVE				जांचकर्ता CHECKED BY	AKC			
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		SUPERSEDES INVENTORY NO				
सार्वजनिक PUBLIC	RECORD OF CHANGES <i>CONTROLLED COPY</i>					
	REV CODE	NO. OF CHANGES	DOCU. NO.	SHEET NO.	SIGN	DATE
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	01	1. Clause 6.4 added. 2. Clause 8 modified.		2		29.08.03
	02	1. Clause no. 4,5 and 6 modified. 2. TC requirement modified.		1 and 2		25.10.06
	03	1. Clause No. 4.3 modified and 4.8 deleted		3		
	04	Clause 8 & 9 modified to introduced original manufacturer's criteria in test certificate & packing.		1 4		27.02.07 18.7.09
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				जांचकर्ता CHECKED BY	AKC	