



CORPORATE STANDARD

AA6210501

Rev. No. 00

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CHISEL FOR PNEUMATIC CHIPPING HAMMER

1 GENERAL

This specification governs the requirement of chisel to be used for fettling of castings with the help of pneumatic chipper.

2 Application

The chisel shall be used for removal of sand, fused sand, scales, fins from castings in fettling activities.

3 COMPLIANCE WITH NATIONAL STANDARD

There is no national standard in compliance with this specification. However, this has reference to corporate standard AA6210500

4 PROPERTIES

- Size of the chisel shall be as given in Drawing No. FT-11-93 and FT-11-90 or any other specific required.
- The chisel shall be made from Forged tool steel in one piece. The cutting edge and head shall be suitably hardened and tempered. The chisel shall be free from defects – e.g., seams, laps, cracks, and brittleness.
- The cutting edge hardness shall be in the range 55-58 HRC and shank hardness shall be in the range 45-50 HRC.
- The body cross section shall be hexagonal or round with knurled surface for firm grip while working manually.

5 ACCEPTANCE

The material shall be accepted on the basis of the properties given in Clause No. 4.

6 TEST CERTIFICATES

- Unless otherwise specified, one original and three copies of original manufacturer's test certificates 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.
 - BHEL PO No. with Date
 - Specification No.
 - Supplier reference / trade mark
 - Identification No. / Batch No.
 - Properties as per Clause 4
 - Any other specific information which the supplier would like to convey.
- 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.

Revisions: AA53631 withdrawn in favour of AA6210501

APPROVED:

INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC (FN)

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CORPORATE STANDARD**7 INSPECTION, DEVIATION AND REPLACEMENT**

- a) 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 tests elsewhere.
- b) If the material received at BHEL 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.
- c) For any deviation from the specification demanded by the supplier prior approval of BHEL must be obtained in writing.

8 PACKING AND MARKING

The material shall be supplied packed in suitable wooden case to avoid damage during transit. Packing shall be that of the original manufacturer. Each chisel shall bear the identification mark of the manufacturer.

Each packing shall bear the following information:

- Specification No.
- Supplier's name and trade mark, if any
- Name of the product
- Date of manufacture
- Batch No.
- Net weight and Gross Weight

9 REFERRED STANDARDS (Latest Publications Including Amendments)

Nil

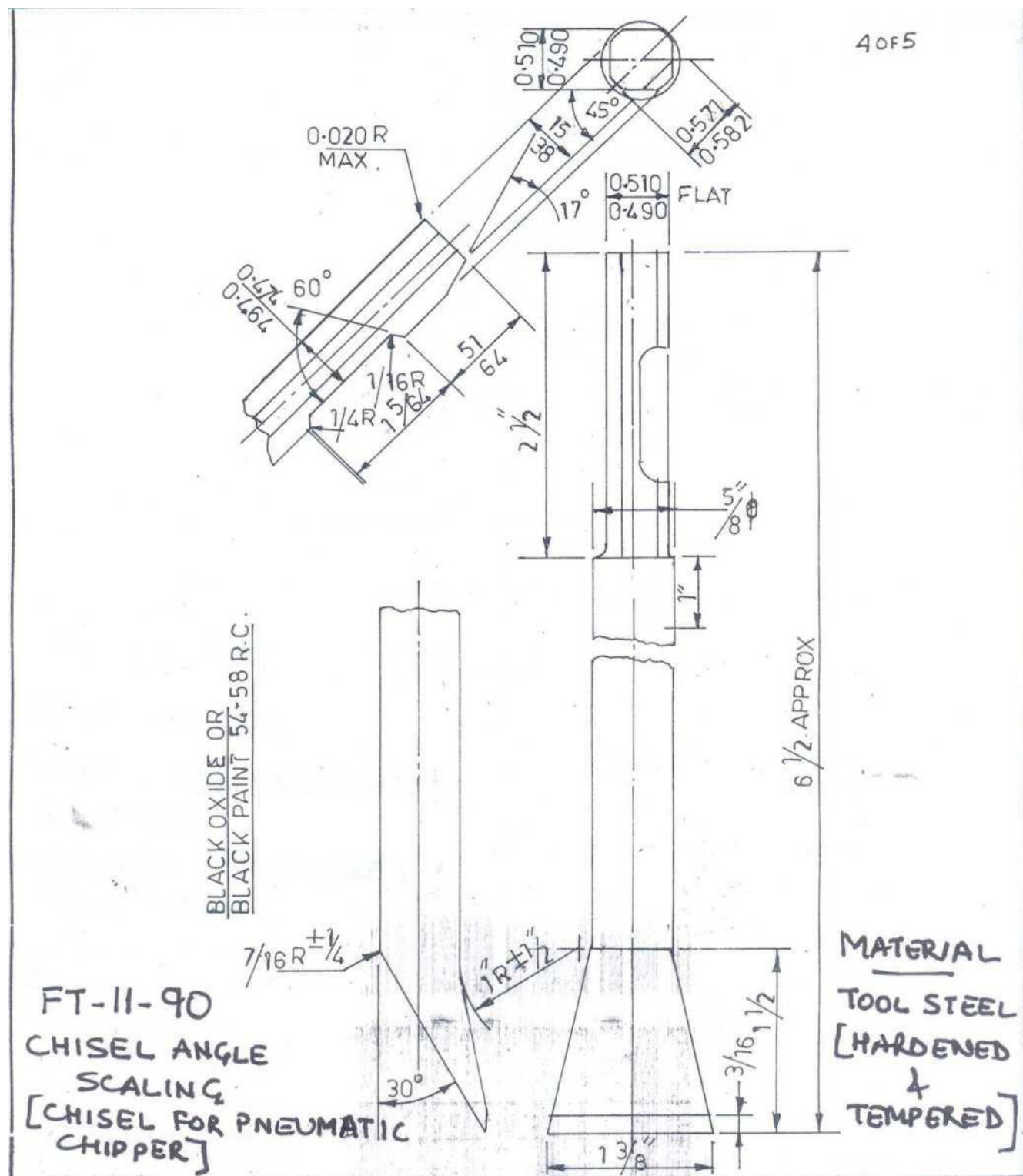


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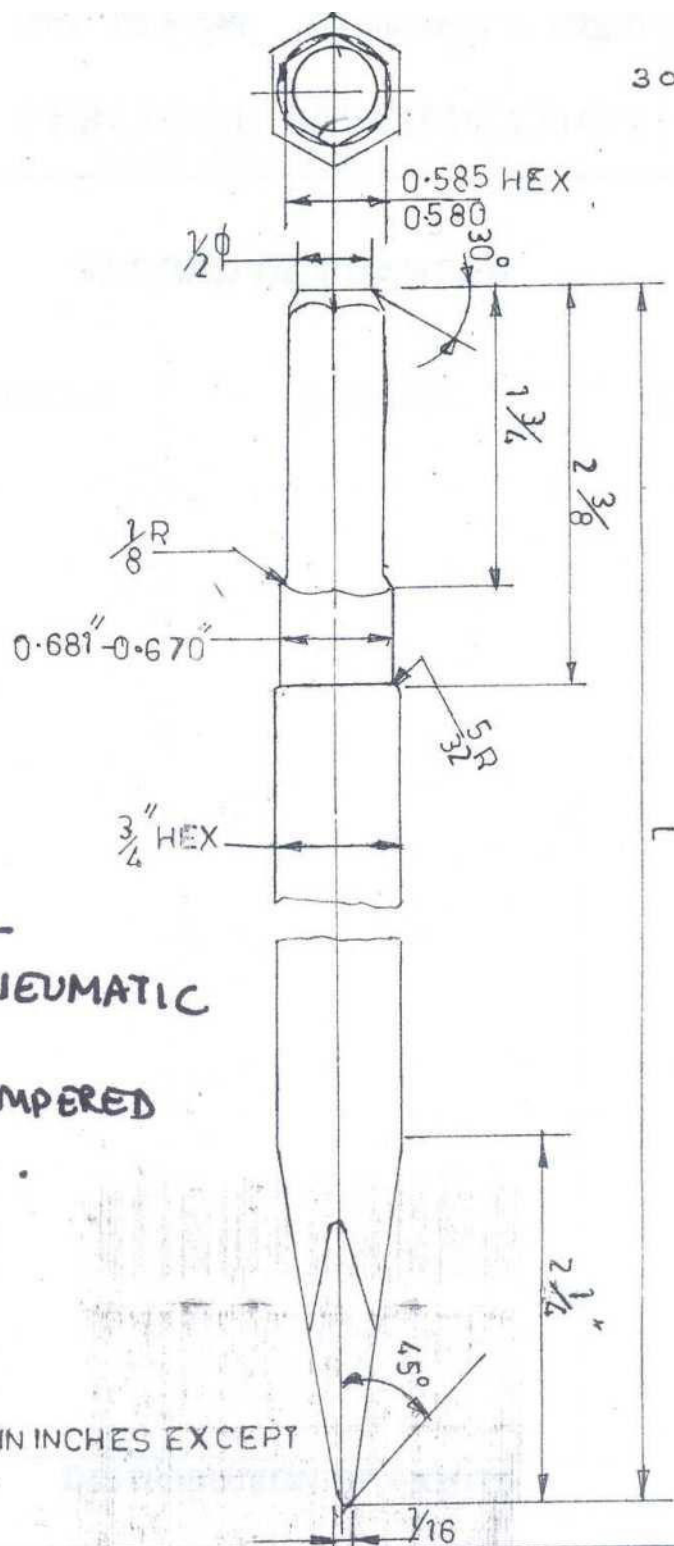
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FT-11-93
 FLAT CHISEL
 [CHISEL FOR PNEUMATIC
 CHIPPER]
 HARDENED & TEMPERED
 TOOL STEEL.

VAR.	L
I	9" ± 0.25"
II	18.5" ± 0.25"
III	36.5" ± 0.25"

ALL DIMENSIONS ARE IN INCHES EXCEPT
 OTHERWISE STATED.