

**BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL**

FOUNDRY DIVISION	DS NO : FYM/013
DEPARTMENT PURCHASING SPECIFICATION	REV. NO : 01
	PAGE : 1 OF 1

**CORE JOINING GUM**

**(1) GENERAL :**

The specification governs the technical requirements of core joining gum used to join various core segments in sand moulds. The material is equivalent to Core Fix - 8 of Fosco.

**(2) APPLICATION :**

Core joining gum is required for joining core segments in moulds, joining top half and bottom half of shell moulds.

**(3) COMPLIANCE WITH NATIONAL STANDARD :**

N/A

**(4) SHAPE AND SIZE :**

The material shall be supplied in semi-solid Paste form.

**(5) PROPERTIES :**

The core joining gum must be having strong adhesive property. The joining gum should dry in ambient temperature within 2 Hours. The material should not allow liquid metal of steel/CLNF to pass through the joining interface.

**(6) TESTING AND APPROVAL :**

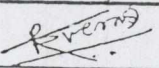
Shop trial shall be done to ensure proper joining particularly in shell mould-closing for acceptance.

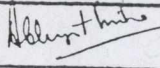
**(7) PACKING :**

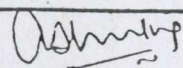
Packing shall be done in 5 Kg. capacity airtight Poly Corboy container or steel container to prevent drying.

Each container shall bear the following :

- a) Supplier's Name / Trade Mark, if any
- b) Name of product
- c) Date of manufacture
- d) Net weight & gross weight

PREPARED BY	
SIGN.	
DATE	22/02/06

CHECKED BY	
SIGN.	
DATE	22/2/06

APPROVED BY	
SIGN.	
DATE	22/2/06