



संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)

FF06003 Rev 05

पृष्ठ का
Page 1 of 4

PLANT PURCHASE SPECIFICATION
(CFFP - HARDWAR)

IRON POWDER FOR USE IN FOUNDRIES

1.0 General

This specification governs the requirement of Iron powder used in Foundry.

2.0 Application

Used for cutting stainless steel castings and for removal of fused sand in Steel castings.

3.0 Compliance with national standard

There is no equivalent National Standard available.

4.0 Grain Size:

The grain size of the material shall be as under when determined by sieving using Indian Standard Sieves :

Sieve Size	% of iron powder retained on the sieve
+212 microns	0.5 max
+180 microns	2 (Max)
+ 45 microns	Balance
-45 microns	25 (max)

5.0 Chemical composition:

The material shall have the following composition:

- Iron - Base
- Carbon - 0.25 % (Max)
- Phosphorous - 0.03 % (Max)
- Moisture - 0.5% (Max)

6.0 Properties:

Flow shall be Maximum 35 sec/ 50 gm.

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इस प्रलेख में दी गई सूचना भारत भारती इलेक्ट्रिकल्स लि. सम्पत्ति है इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।

RMI	SOMNATH GHOSH		अनुवादक	TRANSLATED BY	
MPIC	SHANTANU		निर्माणकर्ता	WORKED BY	T DAVE
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सहमत विभाग	नाम	छात्र एवं हस्ताक्षर	SECRETARY PPSC	DR. MS RAWAT	
AGREED DEPTT	NAME	DATE & SIGNATURE	स्वीकृति	संस्थान मानक समिति	
			APPROVED :	PLANT STANDARDS COMMITTEE	
			निर्माण	जारी	दिनांक
			PREPARED : FOUNDRY TECH	ISSUED : FOUNDRY TECHNOLOGY	DATE : 21.5.11

SUPERSEDES INVENTORY NO.

 सामग्री सूची संख्या को अधिकतम करता

7.0 Sampling:

For each lot of 5 tons of supply, samples shall be taken from 5 different places to make a composite sample for testing.

8.0 Acceptance Test:

Each consignment shall be accepted on the basis of test carried out as per clauses 4.0 and 5.0. For new suppliers, shop trial shall be done to assess the feasibility of cutting. Phosphorous shall be checked on surveillance basis.

9.0 Test Certificate:

9.1 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.

- a. BHEL PO No. with Date
- b. Specification No.
- c. Supplier reference / trade mark
- d. Identification No. / Batch No.
- e. Chemical Composition, Grain Size and Properties as per Clause 4, 5 & 6
- f. Any other specific information which the supplier would like to convey.

9.2 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.

10.0 Inspection and Replacement:

10.1 BHEL reserves the right to inspect material at vendor/manufacturers' premises 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 test 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 prescribed tests elsewhere.

10.2 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.

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चिनांक एवं दिनांक
SIGN & DATE

सामग्री सूची संख्या



निर्माणकर्ता WORKED BY	T DAVE		
जांचकर्ता CHECKED BY	AKC		

सामग्री सूची संख्या -
 नो. अधिपत्रित करता
 SUPERSEDES
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11.0 Packing & Marking:

11.1 Packing of the material should be that of original manufacturer's. Packing shall be done in such a way as to prevent moisture pickup and damage during transit and storage. Packing should be in 15/20/25 kg bags.

11.2 Each packing shall be clearly marked with the following information:

- | | |
|---------------------------------|----------------|
| a) Supplier`s name & trade mark | b) Net weight. |
| c) Batch No. | |



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निर्मागकर्ता WORKED BY	T DAVE		
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SUPERSEDES INVENTORY NO. समूची सूची	RECORD OF CHANGES
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REV CODE	Nature of change	DOCU. NO.	SHEET NO.	SIGN	DATE
02	P content was 0.02 max.		1 of 4		12.06.03
03	Clause 10 & 12 modified to incorporate original manufacturer's test certificate and packing conditions.		2 & 3		29.8.09
04	Correction made in Clause 4.0 – value of % iron retained for - 45 micron was left out in Rev 03 due to tyrographical error		1		12.03.2010
05	Clause for supply condition merged with Packing. Words "to assess feasibility of cutting" added in shop trial. %Fe was 99%. Clause 10.3 deleted. % retention on +212 micron sieve was 0.		1,3		21.5.2011


DISTRIBUTION OF PRINTS	
RMI	✓
STANDARD SECTION	✓
MPIC	✓

हस्ताक्षर एवं दिनांक SIGN & DATE		निर्माणकर्ता WORKED BY	T DAVE	
समूची सूची संख्या		जांचकर्ता CHECKED BY	AKC	

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