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ATE	SECOND STREET, SQUARE,	संस्थान	क्रय विनि	दिश (सी.एफ.एफ.पी.	– हारद्वार)	पृष्ठ		का		
& DATE		PLAN		ASE SPECIFICA P-HARDWAR)	ATION	Page	1	of	4	
INVENTORY NO.	IRON POWDER FOR USE IN FOUNDRIES 1.0 General									
		This specification governs the requirement of Iron powder used in Foundry.								
10	2.0	.0 Application								
कामदी यूपी संक्रम को अधिकांभित करण	Used for cutting stainless steel castings and for removal of fused sand in Steel Foundry.									
	3.0 Compliance with national standard									
Limited It must be energeny		There is no equivalent National Standard available.								
Limits the coe	18.0	ritare is no equit	dicite reddorial o	andra available.						
NTIAL.	4.0	4.0 Grain Size:								
COPYRIGHT AND CONFIDENTIAL or the decuments at the property of Bleaza Heavy Streament easily or indirectly in any way decimental to the interest of	The grain size of the material shall be as under when determined by sieving using Indian Standard Sieves:									
AND Co		Siev	ve Size	% of iron pow on the	vder retained sieve					
off in the		+212	microns	0)					
YKIR			+180 microns 2 (Max) + 45 microns Balance							
COP atton on the d sed directly or			+ 45 microns -45 microns			_				
CO) The information on this not be used directly.	5.0	Chemical comp	osition :							
प्रतेशक में की माई मूचना अरचन रूप अप्राप्ताक करा से फिटडी भी एकाएक ही मा फिल्म धाए ।	The material shall have the following composition: Iron - 99.0 % (Min) Carbon - 0.25 % (Max) Phosphorous - 0.03 % (Max) Moisture - 0.5% (Max)									
प्रमेश में की गई सूचना न ले अप्राथम कर है जिल्ही एकरण हो म फिका प्राप्त ।		Iron Carbon Phosphore	- 0.25 % ous - 0.03 % (N	(Max) Max)						
yes police of the red agrees of the total assesses was the filled antiference of in fillent serve is	6.0	Iron Carbon Phosphore	- 0.25 % ous - 0.03 % (N	(Max) Max)						
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yes police of the red agusts of the the control of the filters of	6.0	Iron Carbon Phosphon Moisture	- 0.25 % ous - 0.03 % (N - 0.5% (Max	(Max) Max) x)						
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yes police of the red agrees of the total assesses was the filled antiference of in fillent serve is		Iron Carbon Phosphon Moisture Properties: Flow shall be Mac Supply Condition	- 0.25 % ous - 0.03 % (N - 0.5% (Max ximum 35 sec/ 5	(Max) Max) x)	(g					
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SACRITYANT ET THATEN SO POR SO THE SET SO SET SO THE SET SO SET SO THE SET SO SET SO THE SET SET SO SET SET SO SET	7.0	Iron Carbon Phosphon Moisture Properties: Flow shall be Ma Supply Condition The material sho SOMNATH GHOSH NK VERMA	- 0.25 % ous - 0.03 % (N - 0.5% (Max ximum 35 sec/ 5	(Max) Max) x) 50 gm. in HDPE bags in 20/25 i	T DAVE					
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interest of the company

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PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

8.0 Sampling:

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

9.0 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 also be mandatory. Phosphorous shall be checked on surveillance basis.

10.0 Test Certificate:

- 10.1 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.
 - BHEL PO No. with Date a.
 - Specification No. b.
 - Supplier reference / trade mark c.
 - Identification No. / Batch No. d.
 - 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.
- 10.2 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.

11.0 Inspection, Deviation and Replacement:

- 11.1 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.
- 11.2 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.
- For any deviation from the specification sought by the supplier, prior approval of BHEL must be obtained in writing.

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PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

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SUPERSEDES ENVENTORY N	12.0	Packing	& Marking:
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- 12.1 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.
- 12.2 Each container shall be clearly marked with the following information:
 - Supplier's name & trade mark a)
- BHEL P.O No. b)

Batch No. C)

Date of manufacture. d)

स्टारप्राप्तिकपाद स्टंड औरतमीदारू रूप एकत है के पूषमा माद्य हैगी विवृद्धमा में माद्योग है काम प्राप्त एवं माद्याक्ष करा से किसी की माद्य प्रतीम, सी में क्रेट्स के हिस है जीविक्स के मिता साम माद्य । Bele DATE SION & D विज्ञणिकर्ता TDAVE संख्या संख्या WORKED BY जांच कर्ता AKC CHECKED BY



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

PLANT PURCHASE SPECIFICATION

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(CFFP - HARDWAR) SUPERSEDES INVENTORY NO. RECORD OF CHANGES greft greft REV Nature of change DOCU. NO. SIGN DATE SHEET NO. CODE COPYRIGHT AND CONFIDENTIAL. The information on this documents is the property of Bleans Heavy Electrical Limited It must not be used detectly or indirectly in any way detrimental to the interest. of the company. 02 P content was 0.02 12.06.03 max. 03 Clause 10 & 12 29.8.09 2 & 3 modified to incorporate original manufacturer's test certificate and packing conditions. 04 Correction made in 12.03.2010 Clause 4.0 - value of % iron retained for -45 micron was left out in Rev 03 due to typrographical error स्वारमाधिकार, एवं गीपमीयक्ष्य कर गरेक में को व्यक्त सारत केले अभिनुक्ष्य में प्रमाति है स्थल प्रताब का सारवा का वे क्षिती भी ताद प्रतीव, को कि क्षेत्रकी के दिव में शिक्षरात है **DISTRIBUTION OF PRINTS** RMI fahir DATE STANDARD SECTION SIGN & L MPIC

निर्माणकर्ता

WORKED BY जांचकर्ता

CHECKED BY

TDAVE

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