

सामग्री सूची संख्या को अतिरिक्त अंक  
SUPERSEDES INVENTORY NO

## WASHED AND DRIED SILICA SAND FOR USE IN FOUNDRY WITH RESIN BINDERS

### 1. General

This specification governs the quality requirements of washed and dried high silica sand for use in foundries.

### 2. Application

Used as raw material in the preparation of moulds and cores particularly for resin bonded sand system (acidic and basic) for steel and cast iron castings.

### 3. Compliance with national standard

This specification is generally based on IS:1987-2002, " High silica sand for use in Foundries".

### 4. Shape and size

- 4.1 Washed sand grains shall be mostly sub-angular to round in shape.
- 4.2 Sieve analysis: 70% and above retained by three adjacent sieves 425 microns, 300 microns, 212 microns. Fines shall be limited to 4% max on 106 micron, 75 micron and pan.
- 4.3 Grain fineness number shall be in the range of AFS 35-50.


### 5. Composition



- 5.1 The sand, when analysed in accordance with IS:1917-1992 and IS:1918-1966, shall conform to the requirements given below:
 


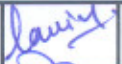

Clay	0.2% max.
Silica (SiO <sub>2</sub> )	99.0% min.
- 5.2 Moisture content in sand not to exceed 0.5%.

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 इस दस्तावेज में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रयोग एवं अप्रयोग तब से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए ।

दिनांक एवं संख्या SIGN & DATE		RMI	SOMNATH GHOSH	अनुवादक TRANSLATED BY	
दिनांक		MPIC	SHANTANU	निर्माणकर्ता WORKED BY	L AGARWAL
दिनांक		CHAIRMAN PPSC	VK AGARWAL	जांचकर्ता CHECKED BY	T DAVE
सामग्री सूची संख्या INVENTORY NO.		सहमत विभाग AGREED DEPTT	नाम NAME	अनुमोदक एवं हस्ताक्षर DATE & SIGNATURE	APPROVED BY T DAVE
स्वीकृति : <b>संस्थान मानक समिति</b> APPROVED : <b>PLANT STANDARDS COMMITTEE</b>					
		तैयारी : फाउण्ड्री टेक्नालॉजी PREPARED : FOUNDRY TECH	जारी : फाउण्ड्री टेक्नालॉजी ISSUED : FOUNDRY TECHNOLOGY	दिनांक DATE: 27.10.11	

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) <b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)	<b>FF 06041 Rev 04</b> पृष्ठ का Page 2 of 4	
राजकी सूची संख्या के अधिदेशित अंश SUPERSEDES INVENTORY NO.	<p><b>6. Sampling</b></p> <p>6.1 Upto 10T – one composite sample, drawing samples from two places of the truck.</p> <p>6.2 10-20T – One composite sample, drawing samples from four places of the truck.</p> <p>6.3 Above 20T – One composite sample, drawing samples from six places of the truck.</p>			
COPYRIGHT AND CONFIDENTIAL. The information on this documents 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	<p><b>7. Acceptance Tests</b></p> <p>Each consignment shall be accepted on the basis of tests carried out as per clauses 4 &amp; 5. Shape of sand grains and % silica shall be checked on surveillance basis.</p> <p><b>8. Inspection, Deviation and Replacement</b></p> <p>8.1 Sand shall be tested at CFFP, BHEL and will be binding on supplier. If the material received at CFFP is not found in accordance with the requirements, it shall be rejected.</p> <p>8.2 BHEL reserves the right to inspect material at site before despatch. The supplier shall be given prior intimation in such case. The supplier shall enclose a copy of test certificate in advance 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.</p> <p>8.3 For any deviation from the specification demanded by the supplier, prior approval of BHEL must be obtained in writing.</p>			
स्वत्वाधिकार एवं गोपनीयता इस प्रलेख में की गई सूचना भारत की संपत्ति है। इसका प्रयोग एवं आश्रयण हम से किसी भी तरह प्रत्यक्ष, अप्रत्यक्ष या किसी भी प्रकार से किया जाए।				
दिनांक एवं SIGN & DATE				
राजकी सूची संख्या		निर्माणकर्ता WORKED BY	L AGARWAL	
		जांचकर्ता CHECKED BY	T DAVE	

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सापेक्षी सूची संख्या को अधिष्ठापित करना	SUPERSIDES INVENTORY NO.	<b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)			पृष्ठ का Page 3 of 4
<b>COPYRIGHT AND CONFIDENTIAL.</b> The information on this documents 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		<b>9. Test certificates</b>  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. Grain Fineness/size, shape and test results as per Clause 4 & 5 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.			
<b>स्वत्वाधिकार एवं गोपनीयता</b> इस प्रयोग में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रयोग एवं अपर्याप्त रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो स किना जाए ।		<b>10.Packing and Marking</b>  The washed and dried sand shall be packed in bags weighing around 50 kg sand per bag. The packing should be that of the original manufacturer. There should not be any contamination of sand from the material of the bag. Proper care should be taken to prevent wastage, damage, and moisture or clay pickup during transportation. The packing should have the following markings: Name/Trademark of supplier Name of material/Specification No. Identification No./Batch No.			
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सापेक्षी सूची संख्या	निर्माणकर्ता WORKED BY		L AGARWAL		
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सामग्री सूची SUPERSEDES INVENTORY NO.	<b>RECORD OF CHANGES</b>
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REV CODE	NO. OF CHANGES	SHEET NO.	NATURE OF CHANGE	SIGN	DATE
01	1	2	Surveillance checking of silica % introduced		31.5.08
02	2	3	Clause 9 and 10 modified to incorporate original manufacturer in Test Certificate and Packing conditions.		18.8.09
03	1	3	Packing clause modified – "moisture proof" deleted. Details of marking on packing specified.		08.07.10
04	1	1	GFN No. modified from 40-50 (with 2 points deviation permitted on upper and lower limit) to 35-50		27.10.11

DISTRIBUTION OF PRINTS	
RMI	✓
STANDARD SECTION	✓
MPIC	✓

चिह्नक एवं तारीख SIGN & DATE		निर्माणकर्ता WORKED BY	L AGARWAL		
सामग्री सूची संख्या		जांचकर्ता CHECKED BY	T DAVE		

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