








दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. – हरिद्वार)		FF06042 Rev 04																									
		PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का Page 1 of 4																									
सामग्री सूची संख्या INVENTORY NO	<u>WASHED AND DRIED SILICA SAND FOR USE IN FOUNDRY WITH SODIUM SILICATE BINDER</u>																												
COPYRIGHT AND CONFIDENTIAL The information on this document 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	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 in sodium silicate bonded sand system for steel 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.																												
स्वतंत्रताधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत के सभी दरेन्द्रिष्टव्य की सम्पत्ति है इसका प्रयोग एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न सके।	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 0.5% max. Silica (SiO ₂) 99.0% min.																												
	5.2 Moisture content in sand not to exceed 0.5%.																												
	<table border="1"> <tr> <td>RMI</td> <td>SOMNATH GHOSH</td> <td>अनुवादक</td> <td>TRANSLATED BY</td> <td></td> </tr> <tr> <td>MPIC</td> <td>SHANTANU</td> <td>निर्माणकर्ता</td> <td>WORKED BY</td> <td>L AGRAWAL</td> </tr> <tr> <td>CHAIRMAN PPSC</td> <td>VK AGARWAL</td> <td>जांचकर्ता</td> <td>CHECKED BY</td> <td>T DAVE</td> </tr> <tr> <td>सहमत विभाग</td> <td>नाम</td> <td>कक्षाक एवं हस्ताक्षर</td> <td>APPROVED BY</td> <td>T DAVE</td> </tr> <tr> <td>AGREED DEPTT</td> <td>NAME</td> <td>DATE & SIGNATURE</td> <td colspan="2"></td> </tr> </table>					RMI	SOMNATH GHOSH	अनुवादक	TRANSLATED BY		MPIC	SHANTANU	निर्माणकर्ता	WORKED BY	L AGRAWAL	CHAIRMAN PPSC	VK AGARWAL	जांचकर्ता	CHECKED BY	T DAVE	सहमत विभाग	नाम	कक्षाक एवं हस्ताक्षर	APPROVED BY	T DAVE	AGREED DEPTT	NAME	DATE & SIGNATURE	
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सामग्री सूची संख्या INVENTORY	स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE निर्माण : फाउण्ट्री टेक्नालॉजी PREPARED : FOUNDRY TECH																												
			जारी : फाउण्ट्री टेक्नालॉजी ISSUED : FOUNDRY TECHNOLOGY	दिनांक: DATE: 27.10.11																									

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सामग्री सूची संख्या को अधिकतम करना	SUPERSEDES INVENTORY NO.	6. Sampling 6.1 Upto 10T – one composite sample, drawing samples from two places of the truck. 6.2 10-20T – One composite sample, drawing samples from four places of the truck. 6.3 Above 20T – One composite sample, drawing samples from six places of the truck.		
COPYRIGHT AND CONFIDENTIAL The information on this document 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.		7. Acceptance Tests Each consignment shall be accepted on the basis of tests carried out as per clauses 4 & 5. Shape of sand grains and % silica shall be checked on surveillance basis.		
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सामग्री सूची संख्या			निर्माणकर्ता WORKED BY	L Agrawal 
			जांचकर्ता CHECKED BY	T Dave 

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<div style="display: flex; justify-content: space-between;"> <div> <p>कॉपीराइट और कॉन्फिडेंटियल</p> <p>The information on this document 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> </div> <div> <p>9. Test certificates</p> <p>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.</p> <ol style="list-style-type: none"> BHEL PO No. with Date Specification No. Supplier reference Grain size/fineness Grain shape Test results as per Clause 4 & 5 Any other specific information which the supplier would like to convey. <p>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.</p> <p>10. Packing and Marking</p> <p>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.</p> <p>The packing should have the following markings: Name/Trademark of supplier Name of material/Specification No. Identification No./Batch No.</p> </div> </div>	
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SUPERSEDES INVENTORY NO.	RECORD OF CHANGES						
सारणी शुद्धी	REV CODE	NO. OF CHANGES	SHEET NO.	NATURE OF CHANGE	SIGN	DATE	
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.	01	01	2	Surveillance checking of silica % introduced		31.5.08	
	02	02	2 & 3	Clause 9 and 10 modified to incorporate original manufacturer's test certificates and packing conditions.		19.8.09	
	03	01	3	Packing clause modified to remove "moisture-proof" from type of bag. Marking details on packing introduced.		08.07.2010	
	04	01	1	GFN size range modified from 40-50 (with 2 points deviation permitted in upper and lower limits) to 35-50		27.10.2011	
DISTRIBUTION OF PRINTS							
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	STANDARD SECTION		✓				
	MPIC		✓				
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