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संस्थान

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

FF53685 Rev 04 पुष्ठ का

(CFFP - HARDWAR)

Page PLANT PURCHASE SPECIFICATION

CHROMITE SAND FOR USE IN FOUNDRIES

1. General:

This specification covers the requirements of Chromite sand for use in foundries.

2. Application:

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The Chromite sand shall be used for facing of pattern and core boxes in mould and core making.

3. Compliance with national standard:

This specification is based on IS-6788:1973, reaffirmed 1997.

4. Physical and Chemical Characteristics:

- 4.1 Chromite sand grains shall be crystalline, mostly sub-angular in shape.
- 4.2 The material shall have shining black appearance and shall be free from foreign material, e.g. low melting point minerals, carbonates.
- 4.3 Chemical Composition:

Chromite sand shall have typical analysis as under:

46% Min. Cr2 O3 Fe₂ O₃ 27% Max MgO 12% Max Al₂O₃ 16.5% Max. SiO2 1.1% Max. CaO 0.5% Max

- 4.4 Clay 0.5 % max.
- 4.5 Moisture 0.2% max.
- 4.6 pH value of sand shall be in between 6.5 and 8.0
- 4.7 Turbidity 210 ppm max.

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and a	CHAIRMAN CPSC	KB SUBRAMANYAM	- KAIMany	अध्यक्तां CHECKED BY	AKCHAKRABORTY	P.
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FF 53685 Rev 04 संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिग्रर) di un d un पुष्ठ Page PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR) Grain size & distribution: 5.1 The Grain Fineness No. (GFN) of chromite sand shall be AFS 45 to 55. Grain distribution: Total retention on ASTM Sieve Nos.50, 70 and 100 shall be 70% min. (Sizes corresponding Sieve Nos. 50, 70 and 100 are 300, 212 and 150 microns) 5.2 Fines i.e. grains having size less than 150 microns (-100 ASTM) shall be 4.0% max. COPYRIGHT AND CONFIDENTIAL 6. Sampling: Samples shall be drawn in accordance with IS-1811: 1961 for testing purposes. 7. Inspection, Deviation and Replacement: 7.1 BHEL reserves the right to inspect material at site 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 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 五百 available at his works, the supplier shall make necessary arrangements for carrying out the изда, prescribed tests elsewhere. स्टारवाधिकाद एवं जीपनीयरु खपका भिष्का हो। निकल्ल में कालीम है महन्न प्रकार के महन्न क्या है कियों भी नाइ। निकल्ल में कालीम है हिंग है महिकारक हो स किया सार। 7.2 The material shall be tested in CFFP/BHEL as per Clause 4,5,6,7 for new suppliers. For established supplier, the testing shall be done on surveillance basis. 7.3 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. 7.4 For any deviation from the specification sought by the supplier, prior approval of BHEL must be obtained in writing. B & SIGN A

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ny Buer seamal te	e. Properties as per Clause 4 & 5 f. Any other specific information which the supplier would like to convey.							
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of the company of the man	8.2 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.							
	9. Packing and Marking:							
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