


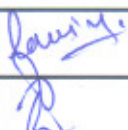








दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)		FF53693 Rev 05	
		PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का Page 1 of 4	
SUPERSEDES INVENTORY NO	<b>HIGH SILICA SAND FOR USE IN FOUNDRIES - UNWASHED</b>				
सामग्री सूची संख्या को अधिकृतित करता	<b>1. General</b> This specification governs the requirements of unwashed high silica sand for use in foundries.				
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	<b>2. Application</b> Used as raw material in the preparation of moulds and cores particularly for chemically bonded sands (sodium silicate, oil sand) for steel and cast iron castings.				
	<b>3. Compliance with national standard</b> This specification is generally based on IS:1987-2002, " High silica sand for use in Foundries".				
	<b>4. Shape and size</b> 4.1 Unwashed 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 6% max on 106 micron, 75 micron and pan. 4.3 Grain fineness number shall be in the range of AFS 35-50.				
	<b>5. Composition</b> 5.1 The sand, when analysed in accordance with IS:1917-1992, shall conform to the requirements given below: <div style="display: flex; justify-content: space-between; margin-top: 10px;"> <div>Clay</div> <div>0.7% max.</div> </div> <div style="display: flex; justify-content: space-between; margin-top: 5px;"> <div>Silica (SiO<sub>2</sub>)</div> <div>98.0% min.</div> </div> 5.2 Moisture content in sand not to exceed 3.5%.				
	स्वतंत्राधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत के वैज्ञानिक प्रयोजनों के लिए है। इसका प्रयोग एवं प्रसारण केवल भारत सरकार के अधिकारियों के द्वारा ही किया जा सकता है। अन्य किसी व्यक्ति या संस्था को इस सूचना के प्रयोग के लिए अधिकार नहीं है।				
हस्ताक्षर एवं दिनांक	RMI MPIC CHAIRMAN PPSC	SN GHOSH SHANTANU VK AGARWAL	अनुवादक निर्माणकर्ता जांचकर्ता	TRANSLATED BY WORKED BY CHECKED BY	L AGRAWAL T DAVE
सामग्री सूची संख्या INVENTORY NO.	सहमत विभाग AGREED DEPTT.	नाम NAME	तारीख एवं हस्ताक्षर DATE & SIGNATURE	APPROVED BY T DAVE	
			स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE		
			तैयार : फाउण्ट्री टेक्नालॉजी PREPARED : FOUNDRY TECH	जारी : फाउण्ट्री टेक्नालॉजी ISSUED : FOUNDRY TECHNOLOGY	दिनांक : DATE 27.10.11

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		<b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)		पृष्ठ Page	का 2 of 4
सुपरीसेड INVENTORY NO	सामग्री सूची संख्या को अधिकृतित करता	<p><b>6. Sampling</b></p> <p>6.1 Samples will be drawn as follows:          Upto 10T – one composite sample, drawing samples from two places of the truck.           10-20T – One composite sample, drawing samples from four places of the truck or wagon.</p> <p>After collecting samples as above, one composite sample will be sent to laboratory for testing by mixing all the samples taken from different trucks/wagons, of a particular supplier, received on a particular day.</p> <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 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 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.</p> <p>8.2 If the material received at CFFP is not found in accordance with the requirements, it shall be liable to be rejected and the supplier will have to replace it free of cost at the earliest.</p> <p>8.3 For any deviation from the specification sought by the supplier, prior approval of BHEL must be obtained in writing.</p>			
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स्वत्वाधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रलेख एवं अनुवाद स्वयं से किसी भी तरह प्रेषित, जो कि कंपनी के हित में आवश्यक हो या किया जाए।		निर्माणकर्ता WORKED BY L AGRAWAL			
हस्ताक्षर एवं दिनांक SIGN & DATE		जांचकर्ता CHECKED BY T DAVE			
सामग्री सूची संख्या					



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सामग्री सूची संख्या ओ. अधिकृतित नं.	SUPERSEDES INVENTORY NO.	<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 Size, Grain Fineness, and Properties 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.			
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		<b>10. Packing and Marking:</b>  10.1 The sand should be supplied in loose condition and does not require any packing. Proper care must be taken to avoid/prevent wastage, damage or clay pickup during transportation.			
स्वत्वाधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रयोग एवं आगमन सग से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए ।					
हस्ताक्षर एवं दिनांक SIGN & DATE					
सामग्री सूची संख्या			निर्माणकर्ता WORKED BY	L AGARWAL	
			जांचकर्ता CHECKED BY	T DAVE	

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		<b>PLANT PURCHASE SPECIFICATION</b> (CFFP - HARDWAR)		पृष्ठ का Page 4 of 4	
SUPERSEDES INVENTORY NO.	<b>RECORD OF CHANGES</b>				
सामग्री सूची	REV CODE	NO. OF CHANGES	NATURE OF CHANGE	SIGN	DATE
<b>COPYRIGHT AND CONFIDENTIAL</b> The information on this documents is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	03	2	Clause 9 modified to incorporate original manufacturer's Test certificate and Packing condition Complete specification written in new standard format.		20.8.09
	04	2	Surveillance test of % silica introduced. 2 point tolerance in GFN upper and lower limits introduced in lines with other sand specifications.		08.07.10
	05	1	GFN No. modified from 40-50 (with 2 point tolerance in upper and lower limit) to 35-50.		27.10.11
<b>स्वत्वाधिकार एवं गोपनीयता</b> युद्धाभारत भारती इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रयोग एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो सके, निषिद्ध है।	<b>DISTRIBUTION OF PRINTS</b>				
दिनांक एवं हस्ताक्षर SIGN & DATE	RMI		✓		
	STANDARD SECTION		✓		
	MPIC		✓		
सामग्री सूची संख्या				निर्माणकर्ता WORKED BY L AGRAWAL	
			जांचकर्ता CHECKED BY T DAVE		