



TD219
Rev.00

**PLANT PURCHASING
SPECIFICATION
HYDERABAD**

FY40008

Rev. No. 00

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CORE GUM

1.0 GENERAL:

Core gum is a silicate based product used for core and mould joining application

2.0 APPLICATION:

To join two or more cores together before using them for setting in mould making.

3.0 COMPLAINS WITH NATIONAL STANDARD

IS 8779 : 1978 (REAFFIRMED 2014)

4.0 PROPERTIES

- 4.1 Colour and appearance : Reddish paste
- 4.2 Specific gravity : 1.55 to 1.65
- 4.3 Viscosity by B4 cup on dilution 100:15 (P:W): 25-45 min

5.0 FREEDOM FROM DEFECTS

The material shall be free from any foreign matter.

6.0 ACCEPTANCE TEST

Each consignment shall be accepted based on test certificate issued by the vendor and successful shop trial after supply.

7.0 SHELF LIFE

Shelf life of the product will be six months.

8.0 INSPECTION, DEVIATION AND REPLACEMENT

BHEL reserves the right to inspect the material at BHEL and material can be accepted or rejected based on result.

9.0 TEST CERTIFICATE

One original and three copies of test certificate from the Manufacturer containing the following information should be provided.

- Manufacturer's Name
- Name of the material.
- Quantity.

10.0 PACKING AND MARKING

The material shall be packed such as to prevent loss / deterioration in quality during handling, transport and Storage i.e., preferably in 1Kg poly lined HDPE bag/squeeze bottle.

It should be marked with the following details.

- CORE GUM
- Net weight

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