



PLANT STANDARD HYDERABAD

HY 21597

REV. NO: 00

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ASBESTOS MILL BOARD

1.0 SCOPE:

This specification covers the requirements of Asbestos Mill Board for use in foundries.

2.0 APPLICATION :

used in the lining of coreless induction furnaces.

3.0 COMPLIANCE WITH NATIONAL / INTERNATIONAL STANDARDS:

There is no national standard covering this type of material. However assistance has been taken from BHEL C.P.S. AA 21525 "Asbestos Mill Board", in formulating this specification.

4.0 SHAPE AND SIZE :

Thickness x width x length of the sheet/board shall be as mentioned on the purchase order.

5.0 TOLERANCES :

The dimensional tolerances shall be as under.

On length	-	+ 10mm
On breadth	-	+ 10mm
On thickness	-	+ 0.5mm

6.0 FREEDOM FROM DEFECTS :

The finished product when delivered shall be free from visible defects that impair appearance or serviceability and shall have been manufactured atleast four weeks before despatch. The surface of the boards shall be of uniform texture and shall have neatly trimmed edges and shall be square at the corners.

7.0 REQUIREMENTS :

7.1 The material shall not suffer appreciable loss of strength upto 50⁰c and even at higher temperatures when properly supported.

7.2 The material should be suitable for high duty work and should be flexible and strong and should not break easily on bending.

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7.3 **Density (I.S.2712):** Density of the material shall be 1.0 to 1.3 gm/cc.

7.4 **Loss on Ignition (I.S.2712) :** The loss on ignition at 800°C – 15% max.

7.5 **Tensile Strength (I.S.2612) :** The tensile strength of the material shall be,

Along grain	-	25kg/cm ² min.
Across grain	-	15kg/cm ² min.

7.6 **Thermal Conductivity :** The thermal conductivity of the material shall be 0.12 w/m max. at 150°C mean temperature.

8.0 **SAMPLES FOR TESTING :**

Two sheets of ordered thickness and size 300x300mm prepared from the same batch, shall be supplied for testing and approval purpose.

9.0 **INSPECTION AT SUPPLIER’S WORKS :**

Whenever specified, tests and inspection are to be conducted in the presence of BHEL’s representative. The supplier shall offer BHEL’s representative all reasonable 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. The supplier shall notify BHEL in advance about the readiness of the material for inspection and testing.

BHEL reserves the right to test the material at BHEL’s works and the final acceptance of the material shall be based on these test results.

10.0 **TEST CERTIFICATES :**

Unless and otherwise stated, three copies of certificates shall be supplied along with each consignment giving the following information.

In addition, the supplier shall ensure the enclose one copy of test certificate alongwith their despatch documents to facilitate quick clearance of the material.

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BHEL Order No.

Manufacturer’s/supplier’s Name

Batch No.

Quantity supplied

Test results of clauses 4 and 7.



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11.0 PACKING AND MARKING :

The material shall be packed in wooden crates as to prevent damage during transit. Each board and each package shall be legibly marked by any suitable method with the following information.

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BHEL Order No.
Manufacturer's / supplier's Name
Batch No.
Net weight.

12.0 REJECTION AND REPLACEMENT :

If the material does not comply with the requirements of this specification during receipt inspection at BHEL or if any defect is found during further processing of the material, BHEL reserves the right to reject the whole consignment notwithstanding any previous certification shall undertake to replace the rejected material at his own cost and the rejected material shall be taken back by the supplier after fulfilling the commercial terms and conditions.

13.0 REFERRED STANDARDS :

AA 21525

IS:2712

IS:2612