

दिनांक (Date) SIGN & DATE		संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF06033 Rev 08 पृष्ठ का Page 1 of 5	
		GRINDING WHEELS			
SUPERVISION INSPECTION NO	सांगी सुचित सहाय को अधिलेखित करें	1. General This specification governs the technical requirement of Grinding Wheels for use in fettling of Steel Castings.			
		2. Application The grinding wheel shall be used after fitting/mounting on portable pneumatic grinders (CPT or equivalents) and/or Swing Frame Grinder for large surface grinding in dry process. The castings to be ground shall be of various material grades such as Plain C steels, Low alloy steels containing Cr, Mo, V, 13Cr4Ni Stainless Steels and 9Cr 1 Mo steels. The cutting wheel mentioned at serial no 4.5 is meant for cutting fire clay refractory hollowares.			
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electrical Limited (BHEL) and not to be used directly or indirectly in any way detrimental to the interest of the company.		3. Compliance with National Standard This specification is related to IS:2324 –1985 Reaffirmed 2014 For dimensions and shape IS:3300 –1980 Reaffirmed 2018 IS:8915 –1978 Reaffirmed 2018 Tolerance as per IS:13596 – 1993 Reaffirmed 2014 Safety requirements as per IS:1991 or EN12413			
इस प्रलेख में दी गयी सूचना भारत हेवी इलेक्ट्रिकल्स की संपत्ति है। इसका प्रयोग एवं अप्रत्यक्ष रूप में किसी भी तरह प्रयोग जो की कंपनी के हित में नहीं है, न किया जाये।		4. Size and Shape and type of bonding			
		SL. NO.	Type of Wheel	CFFP Material Code	Approved models
		4.1	Straight Grinding Wheel (Resinoid Bonding)		
		4.1.1	OD 40 mm X Thickness 20 mm x Bore 10 mm	FF6411499080	CUMI: A163R2BM4 Grindwell Norton: A20T3BL4
		4.1.2	OD 63 mm X Thickness 20 mm x Bore 10 mm * Tolerance on OD 63 : +0.5/-1	FF6411499071	CUMI: A163R2BM4 Grindwell Norton: A20T3BL4 IGC Abrasives: ASTRA Rhino Abrasives: A20T3B3R
		4.1.3	OD 100 mm X Thickness 25 mm x Bore 16 mm	FF6411499063	CUMI: A163R2BM4 Grindwell Norton: A16Q4BL3 IGC Abrasives: ASTRA Rhino Abrasives: A16Q3B3R Excel Abrasives: A163R2BM4
दिनांक (Date) SIGN & DATE	सांगी सुचित सहाय INVENTORY NO	SF	Shailendra Kumar	अनुवादक TRANSLATED	
		RMI	Arun Agrawal	निर्माणकर्ता WORKED	L Agrawal
		Chairman PSC	GM Verma	जांचकर्ता CHECKED	R Lakra
		सहमत विभाग Agreed Deptt	नाम Name	दिनांक ऐवम हस्ताक्षर Date and Signature	अनुमोदित APPROVED Tushar Dave
		स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE			
		निर्माण : PREPARED : FOUNDRY TECH		जारी : फाउंड्री प्रौद्योगिकी ISSUED : FOUNDRY TECHNOLOGY	
		दिनांक DATE 3.6.2019			

निर्माणकर्ता WORKED BY	Lavin Agrawal	<i>Lavin</i> 8/6/19
जांचकर्ता CHECKED BY	R Lakra	<i>R. Lakra</i> 8/6/19



संस्थान क्रय विनीर्देश (सी एफ एफ पी)
PLANT PURCHASE SPECIFICATION
(CFFP - HARDWAR)

SL. NO.	Type of Wheel	CFFP Material Code	Approved Models
4.6	Straight Grinding Wheel- Vitrified		
4.6.1	OD 63 mm x Thickness 16 mm x bore dia 10 mm	FF6411253030	CUMI: AA46J5V8 Grindwell Norton: 38A60K5VBE Excel Abrasives: A6/54
4.6.2	OD 150 mm x Thickness 25 mm x bore dia 16 mm	FF6411253056	CUMI: AA46J5V8 Grindwell Norton: 38A60K5VBE Excel Abrasives: AA46J5V8, A6/54
4.7	Mounted Point: Vitrified		
	Shape A11, Spindle dia 6 mm	FF6411180024	Excel Abrasives Rhino Abrasives Grindwell Norton CUMI

The Resinoid bonded wheels shall have minimum Shelf Life of 2 years from date of despatch. For Vitrified type wheels there shall be no Shelf Life.

For established suppliers', the material shall be accepted on the basis of Test and Guarantee Certificates. During technical evaluation of tender enquiry, vendor will have to confirm that the model offered is same as that mentioned against individual types of wheels mentioned in Clause 4. For those cases where the model number is not mentioned, vendor will have to confirm that the offered model is same as that previously supplied and accepted at CFFP.

For new vendors or vendors offering new model of grinding wheels, shop trial at technical evaluation stage shall be additional requirement. For this purpose, 2 Nos. wheels of the type asked for should be supplied free of cost alongwith submission of techno-commercial bid. The wheel shall be used for shop trial at CFFP and technical suitability of the wheel shall be judged based on shop trial.

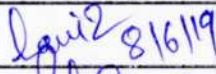
निर्माणकर्ता
WORKED BY

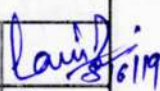
Lavin Agrawal

जांचकर्ता
CHECKED BY

R Lakra

David
8/6/19
Alie
8/6/19

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सुपरसेडिंग INVENTORY NO सामग्री सुविधा संख्या को अभिलेखित करें	7. Marking All the grinding wheels shall be marked individually for safe operating speed, date of expiry of shelf life (in case of Resinoid bonded wheel) and grade. In case of wheels are of small size such as mounted point wheels, marking on individual wheels can be left out, however, detailed marking on the box should be given indicating safe operating speed, date of expiry and grade (if applicable).			
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.	8. Inspection, Deviation and Replacement 8.1. BHEL reserves the right to inspect material at site before despatch. The supplier shall intimate in advance 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 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 test elsewhere. 8.2. If the material received 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.			
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दिनांक (Date) SIGN & DATE	10. Packing The grinding wheels shall be suitably packed to avoid any damage in transit and storage. The packing is to be of the original manufacturer's. The packing should bear the details such as supplier's name and trade mark, if any; Name of product, Date of manufacturing, Shelf life, Batch No.			
जारी/विकास संख्या ISSUE/DEVELOPMENT NO			निर्माणकर्ता WORKED BY	Lavin Agrawal 
			जांचकर्ता CHECKED BY	R Lakra 

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	REVISION RECORD SHEET				
COPYRIGHT AND CONFIDENTIAL The information on this document 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.	REV	NATURE OF CHANGES	SHEET NO.	SIGN	DATE
	02	1. Specification prepared in new format. 2. Specification number sequence updated. 3. Grades for Grindwell Norton Ltd. updated. 4. Details of Depressed Centre Wheel and Mounted Point Wheel introduced.	Whole Doc. Do Page 1&2 Page 2		06/08/2004
	03	Equivalent grades for M/s SAK Abrasives introduced. Tolerance on $\phi 63$ wheel introduced. Purpose of $\phi 400$ wheel mentioned Spindle dia for mounted point wheel revised.	Page 1-2 Cl. 4.1/2 Page 1 Cl. 4.4/3 page 2 Cl. 4.6 page 2		10/2/06
	04	Grades for Depressed centre wheel for M/s Carborundum added	Cl. 4.4 Page 2		21.3.07
	05	Grades of Refractory cutting wheel revised	Cl. 4.4 Page 2		14.5.07
	06	Clause 9 & 10 modified	Cl. 9 & 10		17.8.09
	07	Grades for M/s Apidor added. Grades of M/s Sak Abrasive removed.	4.0		10/1/2014
	08	Clause 4 updated for including models which have been used in shop floor. Clause 2, 3, 6 and 7 modified.	1, 2, 3		08/6/2019
	DISTRIBUTION OF PRINTS				
RMI					
STANDARD SECTION					
SF & LF					
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			जांचकर्ता CHECKED BY	R Lakra	

