



CORPORATE PURCHASING SPECIFICATION

AA 511 01

PLYWOOD FOR GENERAL PURPOSES

FOR INTERNAL USE ONLY

REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS

Equivalent / Comparable Standards:

User Plants & Replaced Plant Specifications / References:

- | | | |
|--------------|---|----------------------------|
| 1. BHOPAL | : | IS: 303, Gr: WWR, Type: BB |
| 2. HYDERABAD | : | IS: 303, Gr: WWR, Type: BC |

Revisions : Reference of IS: 303 deleted.
Refer Cl 4.5 of MOM WG(T&PM).

Approved :
INTERPLANT MATERIAL WG(T&PM)
RATIONALISATION COMMITTEE

Rev. No.	Rev. Date	Revised :	Prepared	Issued	Date
02	Feb. '93.	BHOPAL	CORP. R&D	CORP. R&D	July, '80.

PLYWOOD FOR GENERAL PURPOSES1. GENERAL:

This specification governs the quality of Plywood For General Purposes.

2. APPLICATION:

Used in protective packaging, partitions, etc.

3. COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian Standard Covering this type of material.

4. DIMENSIONS AND TOLERANCES:4.1 Sizes:

Length, Width, thickness and number of Plies shall be stated on our order.

4.2 Tolerances:

The following tolerances on the nominal sizes of finished boards shall be permissible.

Dimension	Nominal Size	Tolerances
a) Length	Upto & Includ. 120 cm	+ 3 mm - 0 mm
	Above 120 cm	+ 6 mm - 0 mm
b) Width	Upto & Includ. 90 cm	+ 3 mm - 0 mm
	Above 90 cm	+ 6 mm - 0 mm
c) Thickness	Upto & Includ 5 mm	± 10 Percent
	6 to 9 mm	± 7 Percent
	Above 9 mm	± 5 Percent

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Rev. No. 02	Rev. Date Feb. '93	Revised: BHOPAL	Prepared CORP. R&D	Issued CORP. R&D	Date July, '80
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5. FINISH:

The faces of plywood boards shall be reasonably smooth and face veneers shall be of reasonably uniform thickness. Slight sanding may be given to rough boards in order to make them reasonably smooth. The edge of the boards shall be trimmed square within 3 mm.

6. TEST SAMPLES:

Two boards of 300 x 300 mm size in ordered thickness shall be supplied for testing.

7. PROPERTIES:

When tested in accordance with IS: 1734, the test pieces shall show the following properties:

7.1 Moisture Content (IS: 1734, Part I):

5 to 15 percent.

7.2 Glue Shear Strength In Dry State (IS: 1734, Part IV):

Average Value : 685 N (70 kgf) minimum.

Individual Value : 490 N (50 kgf) minimum.

8. TEST CERTIFICATES:

Unless otherwise stated, three copies of test certificates shall be supplied giving the following information:

AA 511 01 : Plywood For General Purposes.
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BHEL Order No.

Supplier's Name & Trade Mark, if any:

Batch No.

Test Results of Clauses 7.1 & 7.2.

9. PACKING AND MARKING :

Each Plywood board shall be legibly and indelibly marked or stamped on the face near one corner with the following:

AA 511 01 : Plywood For General Purposes.

BHEL Order No.

Manufacturer's/Supplier's Name:

Trade Mark, if any:

Batch No.

Year of Manufacture:

Grade & Type:

Size & Quantity:

The Plywood boards shall be suitably packed to prevent damage during transit.