
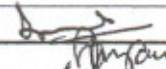
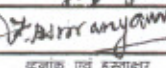
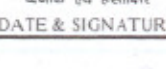
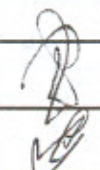






दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)		FF06030 Rev 01	
		PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का Page 1 of 4	
सामग्री सूची संख्या को अतिरिक्तित्व करता	SUPERSEDES INVENTORY NO	<p align="center">WATER BASE ZIRCON PAINT FOR USE IN FOUNDRIES (READY TO USE)</p> <p align="right"><i>CONTROLLED COPY-2</i></p>			
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.		<p>1. General</p> <p>This specification governs the quality requirements of Water base Zircon paint for use in Foundries.</p>			
स्वतंत्राधिकार एवं गोपनीयता हम प्रत्यक्ष में ही : हमारी इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हस्तिकारक हो न किया जाए।		<p>2. Application</p> <p>The water base Zircon paint shall be ready to use to coat the resin bonded mould and core surfaces coming in contact with liquid steel (Temp 1550°C-1610°C). The paint shall be applied with the help of brush.</p>			
		<p>3. Compliance with national standard</p> <p>The specification is based on IS 10033-1992</p>			
		<p>4. Properties</p> <p>4.1 ZrO₂ content - 62% minimum Solid content - 75% minimum</p> <p>4.2 The paint shall be free from low melting minerals and clay.</p> <p>4.3 The paint should have thicksotropic property.</p> <p>4.4 The paint shall give uniform coating on mould surface and should not peel off or develop cracks on lighting or drying.</p> <p>4.5 The dried coating surface should have sufficient hardness so that the paint does not peel off when scratched by nail or does not come out on gentle rubbing.</p>			
हस्ताक्षर एवं दिनांक	RMI MPIC CHAIRMAN CPSC	SOMNATH GHOSH SHYAM BABU KB SUBRAMANYAM	  	अनुवादक TRANSLATED BY निर्माणकर्ता WORKED BY जांचकर्ता CHECKED BY पर्यवेक्षणकर्ता SUPERVISED BY	T DAVE AK CHAKRABORTY AK CHAKRABORTY
सामग्री सूची संख्या INVENTORY	सहमत विभाग AGREED DEPTT	नाम NAME दिनांक एवं हस्ताक्षर DATE & SIGNATURE	स्वीकृति APPROVED : संस्थान मानक समिति PLANT STANDARDS COMMITTEE		
			निर्माण PREPARED : FOUNDRY TECH	जारी ISSUED : FOUNDRY TECHNOLOGY	दिनांक DATE : 3 9 09

दिनांक एवं हस्ताक्षर SIGN & DATE	सहायकी सूची रचना	स्वतंत्राधिकार एवं गोपनीयता इस प्रलेख में सूचना भारत देशी हस्तक्षेप के बिना ही हस्तक्षेपक हो या किया जाए । इस प्रलेख में सूचना प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, हस्तक्षेपक की समझ में सूचना प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हस्तक्षेपक हो या किया जाए ।	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.	सामग्री सूची रचना को अधिकृतित करता SUPERSEDES INVENTORY NO	दिनांक एवं हस्ताक्षर SIGN & DATE	संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF 06030 Rev 01 पृष्ठ का Page 2 of 4		
						4.6 The solid content of the paint should not settle in layer when left undisturbed for 24 hours in a container. 4.7 The paint should not develop cracks or peel off from a coated AFS Sample dried at 200 °C for 2 hours. 4.8 The available shelf life for Water base paint shall be 6 months minimum at CFFP. The paint material should not form a solid mass.			
						CONTROLLED COPY			
5. Information from supplier The supplier shall furnish the following information: 5.1 Whether more than one coating is required for thick castings (When wall thickness is more than 70 mm) 5.2 If more than one coating is recommended, what should be the time interval between the coating. 5.3 Material Safety Data Sheet.									
6. Acceptance 6.1 The material shall be accepted on the basis of the properties given in Clause No. 4.1 and 4.7. 6.2 For a new vendor, shop trial shall be additional where mould and core of a casting shall be painted and properties as per Clause No. 4.4, 4.5, 4.6, 4.7. The casting shall be checked at Knock-out stage to assess the surface finish, sand fusion and sand sticking.									
7. Test Certificates 7.1 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 d. Identification No. / Batch No. e. Date of manufacture f. Any other specific information which the supplier would like to convey. 7.2 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.									
						निर्माणकर्ता WORKED BY	T DAVE		
						जांचकर्ता CHECKED BY	AKC		

दिनांक एवं हस्ताक्षर SIGN & DATE	सामग्री सूची संख्या Inventory NO	BHEL भारतीया भारत भारत भारत भारत भारत	संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF 06030 Rev 01	
				पृष्ठ Page	का of
8. Inspection, Deviation and Replacement			CONTROLLED COPY		
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 tests elsewhere.					
8.2 If the material received at CFFP 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.					
8.3 For any deviation from the specification demanded by the supplier prior approval of BHEL must be obtained in writing.					
9. Packing and Marking					
The material shall be supplied in clean corrosion resistant containers of 30 kg capacity with precaution to avoid corrosion. Packing should be that of original manufacturer. Each drum shall be legibly marked or labeled with the following information.					
(a) Supplier's name and trade mark, if any. (b) Name of the product (c) Date of manufacture (d) Batch No. (e) Net Weight & Gross Weight					
स्वतंत्रता एवं गोपनीयता 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.					
निर्माणकर्ता WORKED BY			T DAVE		
जांचकर्ता CHECKED BY			AKC		

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार)		FF06030 Rev 01	
		PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का Page 4 of 4	
SUPERSEDES INVENTORY NO	RECORD OF CHANGES <i>CONTROLLED COPY</i>				
सामग्री सूची	REV CODE	NO. OF CHANGES	NATURE OF CHANGE	SIGN	DATE
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	01	2	Clause 7 & 9 modified to incorporate original manufacturer test certificate and packing condition.		3.9.09
स्वत्वधिकार एवं गोपनीयता सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है, इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में प्रतिकूल हो, न किया जाए।	DISTRIBUTION OF PRINTS				
हस्ताक्षर एवं दिनांक SIGN & DATE	RMI		<input checked="" type="checkbox"/>		
	STANDARD SECTION		<input checked="" type="checkbox"/>		
	MPIC		<input checked="" type="checkbox"/>		
सामग्री सूची संख्या				निर्माणकर्ता WORKED BY T DAVE	
				जांचकर्ता CHECKED BY AKC	