



PLANT PURCHASE SPECIFICATION

NO:BHEL/FSIP/STM/TL:01

FSIP, JAGDISHPUR

REV NO: 00

DEPARTMENT: STAMPING PRODUCTION

REV DATE: 24.08.2020

Grinding Wheel**1. GENERAL:**

This specification governs the quality & type of Grinding wheel to be used with FAVRETTO CNC grinding machine & Praga Surface grinding machine.

2. APPLICATION:

Sharpening of D2 steel cutting material of compound dies & notching dies.

3. TECHNICAL REQUIREMENTS:

1 Wheel Size: OD -508 mm, Thickness -100mm ,Bore ID : 203.2

Wheel Type -Type 1, **Straight face Grinding Wheel**

Abrasive type -Aluminium oxide

Grit Size : 46

Wheel Hardness- G (soft)

Wheel porosity :12 (open structure)

Bonding system : V (vitrified bond)

Machine - FAVRETTO CNC grinding machine, Max Operation speed-1400 RPM

Grinding material : D2 tool steel

2 Wheel Size: OD -250 mm, Thickness -25mm ,Bore ID : 76.2

Wheel Type -Type 1, **Straight face Grinding Wheel**

Abrasive type - Aluminium oxide

Grit Size : 46/54

Wheel porosity :12 (open structure)

Wheel Hardness- K (Medium)

Bonding system : V (vitrified bond)

Machine - Praga Surface grinding machine. Max operation speed -3000 RPM

Grinding material : D2 tool steel

4. PACKING:

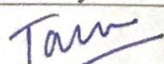
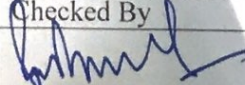
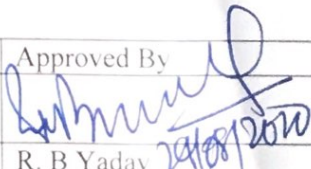
Wheel shall be packed suitably to avoid any transit damage.

5. INSPECTION:

Inspection will be carried out at BHEL works with this specification. Supplier has to submit all Test certificates along with consignment. Wheel should be able to grind D2 tool steel material failing to which wheel will be rejected.

6. GUARANTEE:

Guarantee certificate to be given for any manufacturing defects along with its consignment for free replacement within 12 months from the date of receipt at stores.

	Prepared By	Checked By	Approved By
Signature			
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