



TECHNICAL INSTRUCTIONS - FOUNDRY
TECHNICAL DELIVERY CONDITIONS FOR
PROCUREMENT OF M.S. CHILLS

TIF :- 826
Page :- 1 of 1
Rev :- 02

1.0 SCOPE :-

This TIF covers the scope of supply of M.S./Alloy steel Chills.

2.0 APPLICATION :-

M.S./Alloy steel Chills are used in sand moulds/cores for chilling (externally) steel, G.I, casting surfaces.

3.0 MATERIAL :-

The material of chills shall be of M.S/alloy steel.

4.0 MANUFACTURE :-

The chills shall be cut from rust – free steel plates, as per the drawing /purchase order.

The surface shall be flat and smooth and the cutting edge shall be straight.

The edges shall be ground smoothly; there should not be any burrs on cutting edges.

Chills are to be supplied without any Heat- treatment.

5.0 QUALITY REQUIREMENTS:-

The dimensions are to be maintained as per the drawing/purchase order.

The chills shall be free from grease, oil, paints, moisture and rust.

Testing for mechanical properties is not required.

6.0 IDENTIFICATION :-

The chills shall be identified with chill no. & size by hard punching as per the drawing / purchase order.

Revision :- 02
Material changed.

ISSUED BY :- FOUNDRIES AND PATTERN SHOP

Prepared by

Approved by

Date :- 20-04-2017

Abhinav
अभिनाव अग्रवाल
ABHINAV AGRAWAL
वरिष्ठ अभियंता / प्रौद्योगिकी व पैटर्नशॉप-एफ व पी
Sr. Engineer / Technology & Pattern Shop - F & P
बी.एच.ई.एल. हैदराबाद BHEL, HYD-32

[Signature]
ए.एन. सुधाकर A.N.
उप महा प्रबंधक /
प्रौद्योगिकी व उत्पादन
Deputy General Manager M&S
Technology & Production(F&P)
बीएचईएल हैद/BHEL, HYD-32/32