



CORPORATE PURCHASING SPECIFICATION

AA51101

Rev No. 02

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PLYWOOD FOR GENERAL PURPOSES

1.0 GENERAL:

This specification governs the quality of Plywood for general purposes.

2.0 APPLICATION:

Used in protective packaging, partitions, etc.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

There is no Indian Standard Covering this type of material.

4.0 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	Up to & Including 120 cm	+ 3 mm - 0 mm
	Above 120 cm	+ 6 mm - 0 mm
b) Width	Up to & Including 90 cm	+ 3 mm - 0 mm
	Above 900 cm	+ 6 mm - 0 mm
c) Thickness	Up to & Including 5 mm	± 10 Percent
	6 to 9 mm	± 7 Percent
	Above 9 mm	± 5 Percent

Revisions:

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

APPROVED:

INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC(T&PM)

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5.0 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.

6.0 TEST SAMPLES:

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

7.0 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

8.0 TEST CERTIFICATES:

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

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BHEL Order No.

Supplier's Name & Trade Mark, if any:

Batch No.

Test Results of Clauses 7.1 & 7.2

9.0 PACKING AND MARKING:

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

AA51101: PLYWOOD FOR GENERAL PURPOSES

BHEL Order No.

Manufacturer's/Supplier's Name:

Trade Mark, if any:

Batch No.

Year of Manufacture:

Grade a Type:

Size & Quantity:

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