

निर्देश एवं हस्ताक्षर SIGN & DATE				संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)		FF06003 Rev 05											
सामग्री सूची संख्या को अधिकृतित कक्षा		SUPERSIDES INVENTORY NO		PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का Page 1 of 4											
स्वाधिकार एवं गोपनीयता हस्ताक्षर एवं निर्देश 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.		IRON POWDER FOR USE IN FOUNDRIES															
		1.0 General This specification governs the requirement of Iron powder used in Foundry.															
		2.0 Application Used for cutting stainless steel castings and for removal of fused sand in Steel castings.															
		3.0 Compliance with national standard There is no equivalent National Standard available.															
		4.0 Grain Size: The grain size of the material shall be as under when determined by sieving using Indian Standard Sieves :															
		<table><thead><tr><th>Sieve Size</th><th>% of iron powder retained on the sieve</th></tr></thead><tbody><tr><td>+212 microns</td><td>0.5 max</td></tr><tr><td>+180 microns</td><td>2 (Max)</td></tr><tr><td>+ 45 microns</td><td>Balance</td></tr><tr><td>-45 microns</td><td>25 (max)</td></tr></tbody></table>		Sieve Size	% of iron powder retained on the sieve	+212 microns	0.5 max	+180 microns	2 (Max)	+ 45 microns	Balance	-45 microns	25 (max)				
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		5.0 Chemical composition: The material shall have the following composition: Iron - Base Carbon - 0.25 % (Max) Phosphorous - 0.03 % (Max) Moisture - 0.5% (Max)															
		6.0 Properties: Flow shall be Maximum 35 sec/ 50 gm.															
हस्ताक्षर एवं निर्देश		RMI	SOMNATH GHOSH	अनुवादक	TRANSLATED BY												
		MPIC	SHANTANU	निर्माणकर्ता	WORKED BY	T DAVE											
		CHAIRMAN PPSC	VK AGARWAL	जांचकर्ता	CHECKED BY	AK CHAKRABORTY											
सामग्री सूची संख्या INVENTORY NO		सहमत विभाग AGREED DEPTT	नाम NAME	व्यक्ति एवं हस्ताक्षर DATE & SIGNATURE	SECRETARY PPSC	DR. MS RAWAT											
		स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE															
		निर्माण : PREPARED : FOUNDRY TECH		जारी : फाउण्ट्री टेक्नालॉजी ISSUED : FOUNDRY TECHNOLOGY		दिनांक : DATE : 21.5.11											

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सामग्री सूची संख्या को अधिकतम करता	SUPERSEDES INVENTORY NO	7.0 Sampling: For each lot of 5 tons of supply, samples shall be taken from 5 different places to make a composite sample for testing. 8.0 Acceptance Test: Each consignment shall be accepted on the basis of test carried out as per clauses 4.0 and 5.0. For new suppliers, shop trial shall be done to assess the feasibility of cutting. Phosphorous shall be checked on surveillance basis.				
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		10.0 Inspection and Replacement: 10.1 BHEL reserves the right to inspect material at vendor/manufacturers' premises before despatch. The supplier shall intimate in advance about readiness of material 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 being furnished is 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. 10.2 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.				
दिनांक एवं हस्ताक्षर SIGN & DATE				निर्माणकर्ता WORKED BY	T DAVE	
सामग्री सूची संख्या				जांचकर्ता CHECKED BY	AKC	

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राजकीय सूची संख्या सो अधिपत्ति क्रमांक	SUPERSEDES INVENTORY NO	11.0 Packing & Marking: 11.1 Packing of the material should be that of original manufacturer's. Packing shall be done in such a way as to prevent moisture pickup and damage during transit and storage. Packing should be in 15/20/25 kg bags. 11.2 Each packing shall be clearly marked with the following information: a) Supplier's name & trade mark c) Batch No. b) Net weight.			
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दिनांक SIGN & DATE		निर्माणकर्ता WORKED BY जांचकर्ता CHECKED BY T DAVE AKC			
राजकीय सूची संख्या					