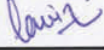


| दिनांक एवं हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <b>संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार)</b><br><br><b>PLANT PURCHASE SPECIFICATION</b><br>(CFFP - HARDWAR) | <b>FF06033 Rev 07</b><br><br>पृष्ठ का<br><b>Page 1 of 4</b>                         |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
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| SUPERSEDES<br>INVENTORY NO                                                                                                                                                                                                 | <b>GRINDING WHEELS</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                        |                                                                                     |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| सागरी सूची संख्या को अधिकृत करता                                                                                                                                                                                           | <p><b>1. General</b><br/>This specification governs the technical requirement of Grinding Wheels for use in fettling of Steel Castings.</p> <p><b>2. Application</b><br/>The grinding wheel shall be used after fitting/mounting on portable pneumatic grinders (CPT or equivalents) and/or Swing frame Grinder for large surface grinding in dry process.<br/>The cutting wheel mentioned at serial no 4.5 is meant for cutting fire clay refractory hollowares.</p> <p><b>3. Compliance with National Standard</b><br/>This specification is related to IS:2324 –1985 Reaffirmed 1995<br/>For dimensions and shape IS:3300 –1980 Reaffirmed 1996<br/>IS:8915 –1978 Reaffirmed 1993<br/>Tolerance as per IS:13596<br/>Safety requirements as per IS:1991</p> <p><b>4. Size and Shape and type of bonding</b></p> <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th>SL. NO.</th> <th>Type of Wheel</th> <th>Model No. of M/s Carborundum Universal Ltd</th> <th>Model No. of M/s Grindwell Norton</th> <th>Model No. of M/s Apidor Abrasives</th> </tr> </thead> <tbody> <tr> <td><b>4.1</b></td> <td colspan="4"><b>Straight Grinding Wheel (Resinoid Bonding)</b></td> </tr> <tr> <td>4.1.1</td> <td>OD 40 mm X Thickness 20 mm x Bore 10 mm</td> <td>A163R2BM4</td> <td>A20T3BL4</td> <td></td> </tr> <tr> <td>4.1.2</td> <td>OD 63 mm X Thickness 20 mm x Bore 10 mm<br/>* Tolerance on OD 63 : +0.5/-1</td> <td>A163R2BM4</td> <td>A20T3BL4</td> <td></td> </tr> <tr> <td>4.1.3</td> <td>OD 100 mm X Thickness 25 mm x Bore 16 mm</td> <td>A163R2BM4</td> <td>A16Q4BL3</td> <td></td> </tr> <tr> <td>4.1.4</td> <td>OD 150 mm X Thickness 25 mm x Bore 16 mm</td> <td>A163R2BM4</td> <td>44A201R6B</td> <td></td> </tr> <tr> <td>4.1.5</td> <td>OD 400 mm X Thickness 63 mm X Bore 152.4 mm</td> <td>A143R5BSN 821</td> <td>44A14R3B</td> <td></td> </tr> <tr> <td>4.1.6</td> <td>OD 500 mm X Thickness 75 mm x Bore 203.2 mm</td> <td>A163R2BM4</td> <td>44A16R3B</td> <td></td> </tr> <tr> <td>4.1.7</td> <td>OD 500 mm X Thickness 100 mm x Bore 305 mm</td> <td>A163R2BM4</td> <td>44A16R3B</td> <td></td> </tr> <tr> <td><b>4.2</b></td> <td colspan="4"><b>Straight Cup Grinding Wheel (Type 6 R-40, B20) Resinoid Bonding)</b></td> </tr> <tr> <td>4.2.1</td> <td>OD 125 mm X Thickness 63 mm x Bore 16 mm</td> <td>A163R2BM4</td> <td>A16R4B L4</td> <td></td> </tr> <tr> <td><b>4.3</b></td> <td colspan="4"><b>Nut Inserted Wheel- Resinoid Bonded T5,B-26mm Bush Radius 22.5mm</b></td> </tr> <tr> <td></td> <td>OD 45 mm x Ht 60 mm x Nut M10 mm</td> <td>A163R2BM4</td> <td>A16R4BL4</td> <td></td> </tr> </tbody> </table> |                                                                                                                        |                                                                                     | SL. NO.                                                    | Type of Wheel                 | Model No. of M/s Carborundum Universal Ltd | Model No. of M/s Grindwell Norton | Model No. of M/s Apidor Abrasives | <b>4.1</b> | <b>Straight Grinding Wheel (Resinoid Bonding)</b> |  |  |  | 4.1.1 | OD 40 mm X Thickness 20 mm x Bore 10 mm | A163R2BM4 | A20T3BL4 |  | 4.1.2 | OD 63 mm X Thickness 20 mm x Bore 10 mm<br>* Tolerance on OD 63 : +0.5/-1 | A163R2BM4 | A20T3BL4 |  | 4.1.3 | OD 100 mm X Thickness 25 mm x Bore 16 mm | A163R2BM4 | A16Q4BL3 |  | 4.1.4 | OD 150 mm X Thickness 25 mm x Bore 16 mm | A163R2BM4 | 44A201R6B |  | 4.1.5 | OD 400 mm X Thickness 63 mm X Bore 152.4 mm | A143R5BSN 821 | 44A14R3B |  | 4.1.6 | OD 500 mm X Thickness 75 mm x Bore 203.2 mm | A163R2BM4 | 44A16R3B |  | 4.1.7 | OD 500 mm X Thickness 100 mm x Bore 305 mm | A163R2BM4 | 44A16R3B |  | <b>4.2</b> | <b>Straight Cup Grinding Wheel (Type 6 R-40, B20) Resinoid Bonding)</b> |  |  |  | 4.2.1 | OD 125 mm X Thickness 63 mm x Bore 16 mm | A163R2BM4 | A16R4B L4 |  | <b>4.3</b> | <b>Nut Inserted Wheel- Resinoid Bonded T5,B-26mm Bush Radius 22.5mm</b> |  |  |  |  | OD 45 mm x Ht 60 mm x Nut M10 mm | A163R2BM4 | A16R4BL4 |  |
| SL. NO.                                                                                                                                                                                                                    | Type of Wheel                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Model No. of M/s Carborundum Universal Ltd                                                                             | Model No. of M/s Grindwell Norton                                                   | Model No. of M/s Apidor Abrasives                          |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| <b>4.1</b>                                                                                                                                                                                                                 | <b>Straight Grinding Wheel (Resinoid Bonding)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                        |                                                                                     |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.1.1                                                                                                                                                                                                                      | OD 40 mm X Thickness 20 mm x Bore 10 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | A163R2BM4                                                                                                              | A20T3BL4                                                                            |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.1.2                                                                                                                                                                                                                      | OD 63 mm X Thickness 20 mm x Bore 10 mm<br>* Tolerance on OD 63 : +0.5/-1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | A163R2BM4                                                                                                              | A20T3BL4                                                                            |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.1.3                                                                                                                                                                                                                      | OD 100 mm X Thickness 25 mm x Bore 16 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A163R2BM4                                                                                                              | A16Q4BL3                                                                            |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.1.4                                                                                                                                                                                                                      | OD 150 mm X Thickness 25 mm x Bore 16 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A163R2BM4                                                                                                              | 44A201R6B                                                                           |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.1.5                                                                                                                                                                                                                      | OD 400 mm X Thickness 63 mm X Bore 152.4 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A143R5BSN 821                                                                                                          | 44A14R3B                                                                            |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.1.6                                                                                                                                                                                                                      | OD 500 mm X Thickness 75 mm x Bore 203.2 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A163R2BM4                                                                                                              | 44A16R3B                                                                            |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.1.7                                                                                                                                                                                                                      | OD 500 mm X Thickness 100 mm x Bore 305 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | A163R2BM4                                                                                                              | 44A16R3B                                                                            |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| <b>4.2</b>                                                                                                                                                                                                                 | <b>Straight Cup Grinding Wheel (Type 6 R-40, B20) Resinoid Bonding)</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                        |                                                                                     |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| 4.2.1                                                                                                                                                                                                                      | OD 125 mm X Thickness 63 mm x Bore 16 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A163R2BM4                                                                                                              | A16R4B L4                                                                           |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| <b>4.3</b>                                                                                                                                                                                                                 | <b>Nut Inserted Wheel- Resinoid Bonded T5,B-26mm Bush Radius 22.5mm</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                        |                                                                                     |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
|                                                                                                                                                                                                                            | OD 45 mm x Ht 60 mm x Nut M10 mm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | A163R2BM4                                                                                                              | A16R4BL4                                                                            |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
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| <b>स्वत्वधिकार एवं गोपनीयता</b><br>इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है, इसका प्रलेख एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए।                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                        |                                                                                     |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| हस्ताक्षर एवं दिनांक                                                                                                                                                                                                       | RMI<br>MPIC<br>CHAIRMAN CPSC                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | SOMNATH GHOSH<br>SIBENDU RAY<br>VK AGARWAL                                                                             | अनुवादक<br>निर्माणकर्ता<br>जांचकर्ता<br>पर्यवेक्षणकर्ता                             | TRANSLATED BY<br>WORKED BY<br>CHECKED BY<br>SUPERVISED BY  | L AGARWAL<br>T DAVE<br>T DAVE |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
| सागरी सूची संख्या<br>INVENTORY NO.                                                                                                                                                                                         | सहमत विभाग<br>AGREED DEPTT                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | नाम<br>NAME<br><br>दिनांक एवं हस्ताक्षर<br>DATE & SIGNATURE                                                            | स्वीकृति : <b>संस्थान मानक समिति</b><br><b>APPROVED : PLANT STANDARDS COMMITTEE</b> |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
|                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | निर्माण :<br>PREPARED : FOUNDRY TECH                                                                                   |                                                                                     | जारी : फाउण्ड्री टेक्नालॉजी<br>ISSUED : FOUNDRY TECHNOLOGY |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |
|                                                                                                                                                                                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | दिनांक :<br>DATE: 10/7/14                                                                                              |                                                                                     |                                                            |                               |                                            |                                   |                                   |            |                                                   |  |  |  |       |                                         |           |          |  |       |                                                                           |           |          |  |       |                                          |           |          |  |       |                                          |           |           |  |       |                                             |               |          |  |       |                                             |           |          |  |       |                                            |           |          |  |            |                                                                         |  |  |  |       |                                          |           |           |  |            |                                                                         |  |  |  |  |                                  |           |          |  |

| दिनांक एवं हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                        | संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   | <b>FF 06033 Rev 07</b>                     |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
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|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                         | <b>PLANT PURCHASE SPECIFICATION</b><br>(CFFP - HARDWAR)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                   | पृष्ठ का<br>Page 2 of 4                    |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| सामग्री सूची संख्या<br>को उपदिष्टित करता                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | SUPERSEDES<br>INVENTORY NO.                                                                                                                                             | <table border="1"> <tr> <th>SL. NO.</th> <th>Type of Wheel</th> <th>Model No. of M/s Carborundum Universal Ltd</th> <th>Model No. of M/s Grindwell Norton</th> <th>Model No. of M/s Apidor Abrasives</th> </tr> <tr> <td>4.4</td> <td colspan="4">Depressed Centre Wheel- Resinoid Bonded –Reinforced</td> </tr> <tr> <td>4.4.1</td> <td>OD 230 mm x Thickness 3.0 mm x Bore 22.23 mm</td> <td>HICUT - A24TBF (42HCT18032T)</td> <td>A24T8B27R</td> <td></td> </tr> <tr> <td>4.4.2</td> <td>OD 180 mm x Thickness 7.0 mm x Bore 22.23 mm</td> <td>HICUT – A24TBF (27HCT18063T)</td> <td>SPIT FIRES</td> <td>ZEN GOLD</td> </tr> <tr> <td>4.5</td> <td colspan="4">Reinforced cut off wheel for refractories (This wheel is meant for cutting refractory holloware in foundry)</td> </tr> <tr> <td></td> <td>OD 400 mm x Thickness 3.0 mm x Bore 25.40 mm</td> <td>C30 R5BFW</td> <td>37C24P6BL3R</td> <td></td> </tr> <tr> <td>4.6</td> <td colspan="4">4.6 Straight Grinding Wheel- Vitrified</td> </tr> <tr> <td>4.6.1</td> <td>63 16 10</td> <td>AA46J5V8</td> <td>38A60K5VBE</td> <td></td> </tr> <tr> <td>4.6.2</td> <td>150 25 16</td> <td>AA46J5V8</td> <td>38A60K5VBE</td> <td></td> </tr> <tr> <td>4.7</td> <td colspan="4">Mounted Point: Vitrified</td> </tr> <tr> <td></td> <td>Shape A11, Spindle dia 6 mm</td> <td></td> <td></td> <td></td> </tr> </table> |                                   |                                            |                                   |                                   | SL. NO. | Type of Wheel | Model No. of M/s Carborundum Universal Ltd | Model No. of M/s Grindwell Norton | Model No. of M/s Apidor Abrasives | 4.4 | Depressed Centre Wheel- Resinoid Bonded –Reinforced |  |  |  | 4.4.1 | OD 230 mm x Thickness 3.0 mm x Bore 22.23 mm | HICUT - A24TBF (42HCT18032T) | A24T8B27R |  | 4.4.2 | OD 180 mm x Thickness 7.0 mm x Bore 22.23 mm | HICUT – A24TBF (27HCT18063T) | SPIT FIRES | ZEN GOLD | 4.5 | Reinforced cut off wheel for refractories (This wheel is meant for cutting refractory holloware in foundry) |  |  |  |  | OD 400 mm x Thickness 3.0 mm x Bore 25.40 mm | C30 R5BFW | 37C24P6BL3R |  | 4.6 | 4.6 Straight Grinding Wheel- Vitrified |  |  |  | 4.6.1 | 63 16 10 | AA46J5V8 | 38A60K5VBE |  | 4.6.2 | 150 25 16 | AA46J5V8 | 38A60K5VBE |  | 4.7 | Mounted Point: Vitrified |  |  |  |  | Shape A11, Spindle dia 6 mm |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                                                                                                                                                         | SL. NO.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Type of Wheel                     | Model No. of M/s Carborundum Universal Ltd | Model No. of M/s Grindwell Norton | Model No. of M/s Apidor Abrasives |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.4                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Depressed Centre Wheel- Resinoid Bonded –Reinforced                                                                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.4.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | OD 230 mm x Thickness 3.0 mm x Bore 22.23 mm                                                                                                                            | HICUT - A24TBF (42HCT18032T)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | A24T8B27R                         |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.4.2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | OD 180 mm x Thickness 7.0 mm x Bore 22.23 mm                                                                                                                            | HICUT – A24TBF (27HCT18063T)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | SPIT FIRES                        | ZEN GOLD                                   |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.5                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Reinforced cut off wheel for refractories (This wheel is meant for cutting refractory holloware in foundry)                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | OD 400 mm x Thickness 3.0 mm x Bore 25.40 mm                                                                                                                            | C30 R5BFW                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 37C24P6BL3R                       |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.6                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 4.6 Straight Grinding Wheel- Vitrified                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.6.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 63 16 10                                                                                                                                                                | AA46J5V8                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 38A60K5VBE                        |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.6.2                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 150 25 16                                                                                                                                                               | AA46J5V8                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 38A60K5VBE                        |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 4.7                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Mounted Point: Vitrified                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Shape A11, Spindle dia 6 mm                                                                                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
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| स्वत्वाधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत देशी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रयुक्त एवं अप्रयुक्त रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए ।                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| दिनांक एवं हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 4. Shelf Life:<br>The Resinoid bonded wheels shall have minimum Shelf Life of 2 years from date of despatch.<br>For Vitrified type wheels there shall be no Shelf Life. |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 5. Test and Acceptance:<br>For established suppliers materials shall be accepted on the basis of Test and Guarantee Certificates.<br>For new vendor shop trial shall be additional requirement. For this purpose, 2 Nos. wheels of the type asked for should be supplied free of cost alongwith the offer for trials at the shop floor.                                                                                                                                                                                     |                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 6. Marking:<br>All the grinding wheels shall be marked individually for safe operating speed, date of expiry of shelf life (in case of Resinoid bonded wheel) and grade.                                                                                                                                                                                                                                                                                                                                                    |                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| 7. Inspection, Deviation and Replacement<br>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.<br>However, inspection of material at BHEL shall be final. If the material received is not found suitable to our requirements, the supplier shall replace it free of cost.<br>For any deviation from specification demanded by the supplier, prior approval of BHEL is to be obtained. |                                                                                                                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                   |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |
| सामग्री सूची संख्या                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | निर्माणकर्ता<br>WORKED BY<br>L AGRAWAL                                                                                                                                  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | जांचकर्ता<br>CHECKED BY<br>T DAVE |                                            |                                   |                                   |         |               |                                            |                                   |                                   |     |                                                     |  |  |  |       |                                              |                              |           |  |       |                                              |                              |            |          |     |                                                                                                             |  |  |  |  |                                              |           |             |  |     |                                        |  |  |  |       |          |          |            |  |       |           |          |            |  |     |                          |  |  |  |  |                             |  |  |  |

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|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|--------------------------------------------------------------|---------------------------------------------------------------------------------------|
| दिनांक एवं हस्ताक्षर<br>SIGN & DATE                                                                                                                                                                                 |  | संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार)<br><br><b>PLANT PURCHASE SPECIFICATION</b><br>(CFFP - HARDWAR)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                           | <b>FF 06033 Rev 07</b><br><br>पृष्ठ का<br><b>Page 3 of 4</b> |                                                                                       |
| सामग्री सूची संख्या को अधिकृत करता                                                                                                                                                                                  | SUPERSEDES INVENTORY NO.                                                          | <b>8. Test Certificates:</b><br>8.1 Unless otherwise stated one original and three copies of original manufacturer's test certificates shall be supplied along with each consignment giving 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.<br>8.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to trader's invoice stating the batch No/lot No., etc. of the supply.<br>8.3 The test certificates should have at least the following details :<br>BHEL PO No.<br>Grinding Wheel Details<br>Manufacturer's Name/ Trade marking if any<br>Date of Expiry |                           |                                                              |                                                                                       |
| COPYRIGHT AND CONFIDENTIAL<br>The information on this documents 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 |                                                                                   | <b>9. Packing</b><br>The grinding wheels shall be suitably packed to avoid any damage in transit and storage. The packing is to be of the original manufacturer's. The packing should bear the details such as supplier's name and trade mark, if any; Name of product, Date of manufacturing, Shelf life, Batch No.                                                                                                                                                                                                                                                                                                                                                                                                                                          |                           |                                                              |                                                                                       |
| स्वत्वाधिकार एवं गोपनीयता<br>इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किया जाए ।              | दिनांक एवं हस्ताक्षर<br>SIGN & DATE                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                           |                                                              |                                                                                       |
| सामग्री सूची संख्या                                                                                                                                                                                                 |                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | निर्माणकर्ता<br>WORKED BY | L AGRAWAL                                                    |  |
|                                                                                                                                                                                                                     |                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | जांचकर्ता<br>CHECKED BY   | T DAVE                                                       |  |