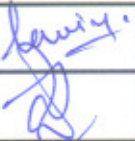


दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF06046 Rev 03					
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सामग्री सूची संख्या को अधिकृतित करना SUPERSEDES INVENTORY NO.	<u>WASHED SILICA SAND FOR USE IN FOUNDRY WITH SODIUM SILICATE BINDER</u> 1. General This specification governs the quality requirements of washed high silica sand for use in foundries. 2. Application Used as raw material in the preparation of moulds and cores in sodium silicate bonded sand system for steel castings. 3. Compliance with national standard This specification is generally based on IS:1987-2002, " High silica sand for use in Foundries". 4. Shape and size 4.1 Washed sand grains shall be mostly sub-angular to round in shape. 4.2 Sieve analysis: 70% and above retained by three adjacent sieves 425 microns, 300 microns, 212 microns. Fines shall be limited to 4% max on 106 micron, 75 micron and pan. 4.3 Grain fineness number shall be in the range of AFS 35-50. 5. Composition 5.1 The sand, when analysed in accordance with IS:1917-1992 and IS:1918-1966, shall conform to the requirements given below: <table border="0"> <tr> <td>Clay</td> <td>0.5% max.</td> </tr> <tr> <td>Silica (SiO₂)</td> <td>99.0% min.</td> </tr> </table> 5.2 Moisture content in sand not to exceed 7%.				Clay	0.5% max.	Silica (SiO ₂)	99.0% min.
Clay	0.5% max.							
Silica (SiO ₂)	99.0% min.							
स्वतंत्राधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रयोग एवं आश्रयण रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो स किता जाए ।								
हस्ताक्षर एवं दिनांक	RMI MPIC CHAIRMAN PPSC	SOMNATH GHOSH SHANTANU VK AGARWAL	अनुवादक निर्माणकर्ता जांचकर्ता	TRANSLATED BY WORKED BY CHECKED BY	T DAVE L AGRAWAL T DAVE			
सामग्री सूची संख्या INVENTORY NO.	सहमत विभाग AGREED DEPT.	नाम NAME DATE & SIGNATURE	स्वीकृति APPROVED निर्माण PREPARED	संस्थान मानक समिति PLANT STANDARDS COMMITTEE : FOUNDRY TECH	जारी : फाउण्ट्री टेक्नालॉजी ISSUED : FOUNDRY TECHNOLOGY दिनांक: DATE:27.10.11			

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF 06046 Rev 03 पृष्ठ का Page 2 of 4	
सामग्री सूची संख्या इसे अधिकृतित करता है SUPERSEDES INVENTORY NO.	6. Sampling 6.1 Upto 10T – one composite sample, drawing samples from two places of the truck. 6.2 10-20T – One composite sample, drawing samples from four places of the truck. 6.3 Above 20T – One composite sample, drawing samples from six places of the truck.				
COPYRIGHT AND CONFIDENTIAL 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	7. Acceptance Tests Each consignment shall be accepted on the basis of tests carried out as per clauses 4 & 5. Shape of sand grains and % silica shall be checked on surveillance basis.				
	8. Inspection, Deviation and Replacement 8.1 Sand shall be tested at CFFP, BHEL and will be binding on supplier. If the material received at CFFP is not found in accordance with the requirements, it shall be rejected. 8.2 BHEL reserves the right to inspect material at site before despatch. The supplier shall be given prior intimation in such case. The supplier shall enclose a copy of test certificate in advance of the material offered for inspection. However inspection at BHEL shall be final. The supplier shall offer BHEL representative all reasonable test facilities without charge to satisfy the latter that the material is being furnished in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed tests elsewhere.				
	8.3 For any deviation from the specification demanded by the supplier prior approval of BHEL must be obtained in writing.				
स्वतंत्राधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रयोग एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न सिया जाए ।		निर्माणकर्ता WORKED BY	L AGRAWAL		
हस्ताक्षर एवं दिनांक SIGN & DATE		जांचकर्ता CHECKED BY	T DAVE		
सामग्री सूची संख्या					

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF 06046 Rev 03 पृष्ठ का Page 3 of 4	
सामग्री सूची संख्या को अधिकृतित करना SUPERSEDES INVENTORY NO.	9. Test certificates 9.1 Unless otherwise specified, one original and three copies of original manufacturer's test certificates shall be supplied with each consignment bearing the 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. a. BHEL PO No. with Date b. Specification No. c. Supplier reference / trade mark d. Identification No. / Batch No. e. Grain size, grain fineness and test results as per Clause 4 & 5 f. Any other specific information which the supplier would like to convey. 9.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to supplier's invoice stating the batch No., lot No., etc of the supply.				
10. Packing and Marking The washed sand shall be transported in loose condition and does not require any packing. Proper care should be taken to prevent wastage, damage or clay pickup during transportation.					
स्वत्वधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत हेवी इलेक्ट्रिकल्स की संपत्ति है। इसका प्रयोग एवं आगमन रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो सके बिना नहीं।					
दिनांक एवं हस्ताक्षर SIGN & DATE					
सामग्री सूची संख्या			निर्माणकर्ता WORKED BY	L AGRAWAL	
			जांचकर्ता CHECKED BY	T DAVE	

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SUPERSEDES INVENTORY NO.	RECORD OF CHANGES												
समीची सूची													
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								REV CODE	NO. OF CHANGES	SHEET NO.	NATURE OF CHANGE	SIGN	DATE
								01	1	3	Clause 9 modified to incorporate original manufacturer's test certificate condition		20.8.09
								02	1	2	% silica to be tested on surveillance basis introduced.		08.07.10
03	1	1	GFN No. modified from 40-50 (with 2 point tolerance on upper and lower limit) to 35-50.	27.10.11									
DISTRIBUTION OF PRINTS													
RMI			✓										
STANDARD SECTION			✓										
MPIC			✓										
हस्ताक्षर एवं दिनांक SIGN & DATE				निर्माणकर्ता WORKED BY	L AGRAWAL								
शास्त्री सूची संख्या				जांचकर्ता CHECKED BY	T DAVE								