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Revision and History SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF06049 Rev 01 पृष्ठ का Page 1 of 3	
SUPERIMPOSE INVENTORY NO सहाई सूची संख्या को. अभिलेखित क्रमांक	QUARTZ SAND FOR USE IN FOUNDRY			
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	1. General This specification governs the quality requirements of quartz sand for use in foundries.			
	2. Application Used as raw material in the preparation of moulds and cores in sodium-silicate bonded sand system/resin sand system for steel castings.			
	3. Compliance with national standard There is no equivalent national standard.			
	4. Manufacturing process, Shape and size 4.1 Sand should be manufactured by process of crushing/grinding of rock particles followed by grading them into varying sizes depending on need. 4.2 Sand grains shall be mostly sub-angular to round in shape. 4.3 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. 4.4 Grain fineness number shall be in the range of AFS 35-50.			
स्वतंत्रिकार एवं गोपनीयता इस दस्तावेज को ही एवं सूचना अर्थात् की कुंजी/सूचना की समझ में इसका प्रयोग एवं अप्रमाणिक रूप से किसी भी रूप में प्रयोग, जो कि, संस्था के हित में सहायक हो, न किया जाय।	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: Clay 0.5% max. Silica (SiO ₂) 97.0% min. 5.2 Moisture content in sand not to exceed 0.5%.			
	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.			
	RMI MPIC CHAIRMAN PPSC	SOMNATH GHOSH SHAILENDRA VK AGARWAL	अनुवादक TRANSLATED BY रिसॉल्यूट WORKED BY जांचकर्ता CHECKED BY	R Lakra T Dave T Dave
	सहमत विभाग AGREED DEPT	नाम NAME	तारीख एवं हस्ताक्षर DATE & SIGNATURE	अनुमोदित APPROVED BY संस्थान ज्ञानक समिति PLANT STANDARDS COMMITTEE
सहाई सूची संख्या INVENTORY NO	तैयारी PREPARED: FOUNDRY TECH जारी ISSUED: FOUNDRY TECHNOLOGY तिथि DATE: 20.10.14			

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दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF 06049 Rev 01 पृष्ठ का Page 2 of 3	
सप्लायर की सूची SUPPLIER'S NO INVENTORY NO	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.			
सप्लायर की सूची को अधिकृत करें COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	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.			
स्वतंत्रताधिकार एवं औपनिवेशिक स्वतंत्रताधिकार एवं औपनिवेशिक	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.			
दिनांक एवं हस्ताक्षर SIGN & DATE	10. Packing and Marking The sand shall be packed in bags weighing around 50 kg sand per bag. There should not be any contamination of sand from the material of the bag. Proper care should be taken to prevent wastage, damage, and moisture or clay pickup during transportation.			
सप्लायर की सूची संख्या	निर्माणकर्ता WORKED BY जाँचकर्ता CHECKED BY		R Lakra T Dave 20/10/14 20/10/14	