



PRODUCT STANDARD
BUSDUCT ENGINEERING DIVISION

ANNEXURE-I

TO P.I. No.
20170107

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SPECIFICATION FOR HOT GALVANIZED STEEL
FOUNDATION BOLT

TECHNICAL SPECIFICATION:-

- 1) Raw material shall be in conformance to IS: 2062/2006 and our Corp. Std. No. AA10108.
- 2) Tolerance of the Raw material shall be as Per IS: 1852/ latest.
- 3) The firm must source all the Steel Raw Material from SAIL, IISCO, TISCO, RISNL or their authorized re-rollers or any other manufacturers or their re-rollers having BIS license for the required raw material. The firm must submit documentary evidence like invoice, Test certificate, BIS License as proof of procurement from BIS license holder, with each consignment of supply to sustain that the raw material used is as per the above IS and procured from BIS License.
- 4) Finish: All the Components are Hot Dip Galvanized as per IS: 4759 (latest)/ IS: 2629 and it should pass the DIP Test as per IS: 2633. Thickness of zinc coating shall be minimum 610 gm. /sq. meter.
- 5) Components shall be fabricated as per the drawing provided with respective purchase orders (sample drawings only for estimation purpose attached. Actual requirement may partially/entirely differ from the sample drawings).
- 6) Supply of the components should strictly conform to dimensions and tolerances indicated in the Drawings and Quality Plan, if applicable.
- 7) Inspection shall be by our Quality Control Department and / or by our customers and / or by an appointed agency or persons authorized by us.
- 8) T.C. & G.C. shall be submitted for Chemical composition, Mechanical properties and Galvanizing.

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REV.	00	PRINTS TO:-	APPROVED BY-		
ALTD.			A. NARAYAN		
APPD.			PREPARED BY	CHECKED BY	DATE
DATE.			RUPESH KUMAR	RUPESH KUMAR	10/05/2017



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9)PVC Formula: The prices in the contract will be variable as per New PVC Clause for Transmissions Line Tower published by IEEMA vide circular no. IEEMA (PVC)/TLT-2014)/03/2017 dated MARCH 2017. Copy of the same attached for ready reference.

10) BHEL reserve the right to cross check the WEIGHBRIDGE's weight either at vendor's works or at site or both.

11) Packing slip shall be accompanied with each delivery challan listing of elements being supplied as per drawing. Final payment shall be released to vendor only after reconciliation of each item of BOQ having been supplied.

12) Our CORPORATE STANDARD shall be as applicable -

S. No.	MATERIAL DESCRIPTION	CORPORATE STANDARD APPLICABLE
1.	Foundation Bolts M-24	AA 711 51 90
2.	Nut, Hexagon, Product Grade-B, Course Pitch, Steel, Property Class-6 (M-24)	AA 715 11 12
3.	Washer, Punched, Type-A, Steel	AA 716 10 05
4.	Washer, Spring Lock, Single Coil, Rectangular Section, Type-A (with bent ends) steel	AA 716 40 01
5.	Nut, Hexagon A M12-8	AA 715 11 15

13) WEIGHT VARIATION CLAUSE:

Variation in weight is expected due to various reasons. Major factor being tolerance in section (plate/BAR) weights. Guidelines regarding these are listed in IS: 1852. Further, Weight reduction due to holes and slots etc. are to be ignored in line with guidelines of IS: 802 (part-2). Some weight of weld deposits shall also be there, in addition to calculated engineering weight. Based on these considerations, weight variation maximum up to $\pm 3\%$ shall be allowed.

However, payment shall be released on the basis of WEIGHBRIDGE's actual weight basis (billed by supplier or received at BHEL Rudrapur (if applicable), whichever is lower), within the tolerance limit of PO Weight as mentioned above.

For cases of direct supply to site, BHEL reserve the right to cross check the WEIGHBRIDGE's weight either at vendor's works or at site or both. This will be frequently done.

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