

	TD219 Rev00	PLANT PURCHASING SPECIFICATION HYDERABAD	HY 53698		
			REV. NO. 02		
			PAGE 1 OF 2		
SILICA SAND (MEDIUM GRADE) 1.0 SCOPE: This specification covers the requirements for silica sand for use in foundry. 2.0 APPLICATION: Used as raw material in the preparation of moulds and cores for manufacturing of cast Iron & its alloys & aluminum copper alloy base castings. 3.0 COMPLIANCE WITH NATIONAL / INTERNATIONAL STANDARDS : This specification generally conforms to IS: 1987 – 2002 (Reaffirmed 2007). 4.0 SHAPE & SIZE: 4.1 GRAIN FINENESS AND DISTRIBUTION: Min. 72% of sand should be in well-defined grading distributed on 3 adjacent sieves. As per 4.3 Average American Foundry men’s Society (AFS) fineness no. should be 40 to 50 . 4.2 GRAIN SHAPE: Sand grain shape should be sub angular to round in shape. 4.3 SIZE GRADING : Coarse grain fraction retained on I.S. SIEVE 600 Microns and above should be 20% Max. Main fraction passing through I. S. SIEVE 600 microns and retained on I. S. SIEVE 425 Microns, 300 Microns and 212 Microns should be min. 72%. medium fine fraction retained on I.S. SIEVE No.150 Microns should be 6% max. fine fraction retained on I .S. SIEVE NO.106 Microns and below should be 2% max.					
Revisions : CL 5.0 modified, Clause 8.0 added As per MOM dated 13.07.19			ISSUED : STANDARD ENGINEERING & IPR COORDINATION DEPARTMENT		
Rev. No. 02	Amd.no.	Reaffirmed:	Prepared:	Approved:	Date of 1st issued
Dt. 20-Jul-19	Dt.	Year:	DM/F&P,CWS	AGM/ERDC	Nov.96

HY 53698	PLANT PURCHASING SPECIFICATION HYDERABAD	TD219 Rev00	
REV. NO.01			
PAGE 2 OF 2			

5.0 CHEMICAL COMPOSITION :

The chemical composition shall be as under:

Silica	:	90% Min.
Moisture	:	0.5% max
Clay content	:	0.5% max.

6.0 GENERAL INSPECTION CONDITIONS:

Samples of 2 kgs from each consignment of each lorry will be taken for testing grain distribution as per 4.0 (sieve analysis). Approved consignments only will be permitted for unloading.

7.0 SUPPLY CONDITION:

During transportation by open lorry sand to be protected from moisture by providing tarpaulin all around the sand.

8.0 TEST CERTIFICATES

For every lot of 500Tons or part thereof, random test sample shall be drawn and test certificate of the same specifying the below mentioned details shall be supplied

- HY53968 Rev 02: SILICA SAND (MEDIUM GRADE)
- BHEL PO Reference
- Suppliers Name:
- DC No. of the Lorry from which the random sample is drawn.
- Test result as per the clause 4.0 & 5.0 of BHEL Specification.

9.0 REJECTION AND REPLACEMENT :

If the material does not comply with the requirements of this specification during receipt inspection at BHEL or if any discrepancy is found during further processing of the material, BHEL reserves the right to reject the whole consignment notwithstanding any previous certification of satisfactory testing and /or inspection . The supplier shall replace the rejected material at his own cost after fulfilling all the commercial terms and conditions.