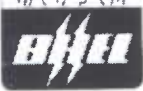


डी.एन.ए. 3 एम 	संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFEP - HARDWAR)		FF06026 Rev 04 पृष्ठ का Page 1 of 3	
	ANTIPIPING COMPOUND (GRANULAR & EXPANDABLE) FOR USE IN FOUNDRY AND STEEL MELTING			
प्रमाणित की गयी की जा रही है	SUPERSEDES INVENTORY NO.	1. General This specification governs the technical requirements of Antipiping compound for covering of risers in moulds of steel castings and hot tops of steel ingots to reduce the heat loss from the liquid metal surface in the riser/hot top.		
COPYRIGHT AND CONFIDENTIAL The information on this document 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.		2. Application The antipiping compound material will be used for covering of open risers in the moulds for steel castings and hot top of steel ingots to reduce heat loss from top liquid metal surface in the riser/ingots. The antipiping compound shall be added immediately after completion of pouring.		
		3. Compliance with national standard This specification is related to IS 10469 - 1983 and IS 1387 - 1967		
		4. Size The material shall be in granular form of size ranging from 2 to 15 mm. 90% of the material size should fall in this range. It shall burn uniformly without explosion.		
स्वतंत्रता एवं गोपनीयता इस दस्तावेज़ में दी गई सूचना भारत की प्रत्येक राज्य में उपलब्ध होनी चाहिए और इसे किसी भी रूप में प्रकाशित नहीं किया जाना चाहिए।		5. Properties 5.1 The heat generated during burning of antipiping compound shall nullify the cooling tendency of the top metal layer in the riser/hot top of steel ingots. The burnt material, in turn shall form a soft thick - fluffy insulating layer to reduce the heat loss. 5.2 A. Bulk density 0.7-1.5 g/cc B. Moisture 2.5% max. C. Thermal Expansion 6-8 cc/gm D. Calorific Value 1599 cal/gm - minimum E. Temperature attained on burning 1600 °C minimum F. Ignition time after addition 30 sec. Maximum G. Thermal conductivity 0.10-0.15 Wm/K at 1500 °C		
रजिस्ट्रार REGD. DEPT.	RMI S.N. GHOSH	अनुवादक TRANSLATED BY	T. AGRAWAL	
अध्यक्ष CHAIRMAN	SIBENDU RAY	विकसितकर्ता WORKED BY	T. DAVE	
अध्यक्ष CHAIRMAN	VK AGARWAL	जांचकर्ता CHECKED BY	T. DAVE	
पर्यवेक्षण SUPERVISED BY	T. DAVE	सत्यान मानक समिति PLANT STANDARDS COMMITTEE		
तैयारी PREPARED	फाउंड्री टेक्नोलॉजी FOUNDRY TECH	जारी ISSUED	फाउंड्री टेक्नोलॉजी FOUNDRY TECHNOLOGY	दिनांक DATE 05.05.14

निष्पन्न एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हार्डवेयर) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF 06026 Rev 04 पृष्ठ का Page 2 of 3	
निष्पन्न एवं हस्ताक्षर SIGN & DATE	निष्पन्न एवं हस्ताक्षर SIGN & DATE	6. Addition level and storage 6.1 The supplier shall give the addition quantity related to riser size and condition for storage. The addition quantity should be related to size of riser and ingot hot top diameter. 6.2 When stored as recommended by the supplier, the material shall not fail to meet the requirement as per Cl. No. 5 7. Test Certificates 7.1 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 d. Identification No. / Batch No. e. Date of manufacture f. The properties as per Clause 4 and 5 g. Storage conditions, if any. h. Any other specific information which the supplier would like to convey. 7.2 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.		
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स्वतंत्रताधिकार एवं गोपनीयता स्वतंत्रताधिकार एवं गोपनीयता स्वतंत्रताधिकार एवं गोपनीयता	स्वतंत्रताधिकार एवं गोपनीयता स्वतंत्रताधिकार एवं गोपनीयता स्वतंत्रताधिकार एवं गोपनीयता	8. Inspection, Deviation and Replacement 8.1 BHEL reserves the right to inspect the material at site before despatch. The supplier shall intimate in advance enclosing a copy of test certificate of the material offered for inspection. The supplier shall extend all test facilities at their works to BHEL representative free of cost for verification of properties at Clause No. 5.2. However acceptance of the material shall be based on receipt inspection at CFFP and the decision of CFFP shall be final and binding. 8.2 If the material received is not found in accordance with the requirements, it is liable to be rejected and the supplier will have to replace it free of cost at the earliest. 8.3 For any deviation from the specification sought by the supplier prior approval of BHEL must be obtained in writing. 9. Packing and Marking The material shall be packed in 5 kg polypacks. These polypacks shall be further packed in 50 kg polythene lined gunny bags. The packing should be that of original manufacturer. Each gunny bag shall bear the following (a) Supplier's name and trade mark, if any. (b) Name of the product (c) Date of manufacture (d) Batch No. (e) Net Weight & Gross Weight		
निष्पन्न एवं हस्ताक्षर SIGN & DATE	निष्पन्न एवं हस्ताक्षर SIGN & DATE	निष्पन्न एवं हस्ताक्षर SIGN & DATE	निष्पन्न एवं हस्ताक्षर SIGN & DATE	निष्पन्न एवं हस्ताक्षर SIGN & DATE
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ड्राफ्ट नं. 001/2014 SHEEN A-1111	RECORD OF CHANGES						
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	01	1	CL. 5.2 MODIFIED	1		25/5/04	
	02	1	POWDER FORM REPLACED BY GRANULAR FORM	1		27-3-09	
	03	2	Clauses 7 & 9 modified to incorporate original manufacturer's test certificate and packing condition.	2		29-8-09	
	04	2	Moisture content and Bulk Density revised.	1		05-05-2014	
स्वाधिकार एवं गोपनीयता भारत भारी बिजलीकरण की संपत्ति है। इसका प्रयोग एवं प्रसारण केवल भारत भारी बिजलीकरण की लिमिटेड द्वारा ही किया जायेगा।	DISTRIBUTION OF PRINTS						
	RMI	✓					
	STANDARD SECTION	✓					
ड्राफ्ट नं. 001/2014 SHEEN A-1111	MPIC	✓					
ड्राफ्ट नं. 001/2014 SHEEN A-1111					निर्माणाधीन WORKED BY	T DAVE	25/5/14
					जांचकर्ता CHECKED BY	L AGRAWAL	25/5/14