



PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

FF 05034 Rev01

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MORTAR FOR SLIDE GATE

1. SCOPE

This specification governs the quality requirement of mortar for slide gates.

2. APPLICATION

Used for joining slide plates and nozzle for fixing nozzles with well block.

3. COMPLIANCE WITH NATIONAL STANDARDS

The material in general shall conform to Indian standards specification IS-1527 and IS-1528.

4. FREEDOM FROM CONTAMINATION

The material shall be free from lumps and any other extraneous contamination.

5. PROPERTIES:

When tested in accordance with the relevant clauses of IS 1527 and IS 1528 mentioned against each, the test sample shall show the following values.

5.1 CHEMICAL COMPOSITION

Product	90K	70K
Al_2O_3 (%)	89 min	69 min
5.2 GRADING(mm):	0--0.35	0--0.20
5.3 SETTING:	Chemical/Ceramic	Ceramic
5.4 SINTERING TEMP.	1200°C	1200°C
5.5 C.C.S (kg/cm ² , 110°C)	200 min	200 min

6. SAMPLING AND METHOD FOR CHEMICAL ANALYSIS:

Each batch of the material shall be sampled in accordance with IS 1528 and IS 1527 or equivalent international standards./instrumental analysis traceable to international standard,

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CHAIRMAN CPSC	V K AGARWAL	<i>[Signature]</i>	SUPERVISED BY	B K.BEDI	<i>[Signature]</i>
			APPROVED : PLANT STANDARDS COMMITTEE		
			PREPARED : SMS TECH	ISSUED : Steel Melting Shop	DATE : 24.08.17



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7. INSPECTION

- CFFP reserves the right to witness the testing of the material at supplier works and therefore the supplier shall notify the readiness of the material in advance.
- If any specific inspection requirements are written in purchase order, the same shall be applicable.
- CFFP may, at its discretion, test the material after receipt and acceptance of the material will be based on the CFFP's test results.
- For any deviation from this specification prior approval shall be taken by the supplier.
- For result of analysis and properties of material the decision of CFFP shall be final and binding on the supplier.

8. TEST CERTIFICATES

One Original and three copies of Test Certificate from the manufacturer in English containing the following information should be provided.

Manufacturer's Name
Name of the material
Batch/Lot No.
Lot Quantity.
Date of manufacturing.

Note:

- a) A manufacturer supplying directly to BHEL should include BHEL's P.O. No. and Challan No. also in the TC.
- b) Any other supplier should provide a covering letter along with original Manufacturer's TC as above mentioning BHEL's P.O. No. and Challan No.

9. PACKING AND MARKING

Packing should be such as to prevent loss / deterioration in quality during handling, transport and storage and should be by the manufacturer. Each package should be marked with the following details.

Name of the material
Manufacturer's Name / Trade mark
Batch/Lot No.
Net weight.
Date of manufacturing.

WORKED
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REVISION RECORD SHEET

SN	Revision No.	Revision date	Nature of Changes
1	01	24.08.2017	Clause 6: International standards added to sampling and analysis. Clause 8 and 9: Date of manufacturing added.

ISSUED BY:	SMS	WORKED	M.K.SAHU	
REVISION	DATE:	CHECKED	M K RAJAK	
AGREED	PLANT PUR. SPEC.COMMTTEE	APPROVED	P.P.S.C.	