



ISO 9001:2000
& 14001:2004
NAVARATNA
COMPANY

सामग्री प्रबन्धन (क्रय विभाग)
MATERIAL MANAGEMENT (PURCHASE)
सेन्ट्रल फाउन्ड्री फोर्ज प्लांट, भारत हेवी इलैक्ट्रिकल्स लिमिटेड
CENTRAL FOUNDRY FORGE PLANT, BHEL HARDWAR
रानीपुर, हरिद्वार (भारत)
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Ref: FF/PPX/EOI/19
Dt. 01/06/2009

Sub: EXPRESSION OF INTEREST FOR SUPPLY OF **Resin & Catalyst.**

Dear Sir,

CFFP/BHEL has huge requirement for following item and thus desires Expression of Interest from interested vendors for supply of this item.


EOI NO.	Description	Due date
FF/PPX/EOI/19	Resin & Catalyst	20/07/2009


You are requested to please submit your interest along with Supplier Registration Form (which can be downloaded from our web site www.bhel.com).

Kindly note that supplier registration form is mandatory requirement for processing your application against this Expression of Interest .

Thanking you.

(Rohit Varshney)
Engineer (Pur)

डिजाइन एवं स्थापना DESIGN & D/P'TE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF06004 Rev 02 पृष्ठ . . . का Page 1 of 6																
SUPERSEDES INVENTORY NO. जगदीश शर्मा के अधिकार क्षेत्र	PHENOL FORMALDEHYDE RESIN AND CATALYST SYSTEM <div style="border: 1px solid black; padding: 2px; display: inline-block;"> CONTROLLED COPY CTAL. No. 03 </div>																		
<p>1.0 General</p> <p>This specification governs the technical requirements for Phenol Formaldehyde Resin and Catalyst used in Foundries.</p> <p>2.0 Application</p> <p>2.1 The Resin and Catalyst shall be used as binder for sand mix for mould and core making in Foundries.</p> <p>2.2 The resin and catalyst are to be procured from same source as a system. The supplier shall stand guarantee for the performance of combination and ensure the compatibility of resin and catalyst with sand.</p> <p>3.0 Appearance</p> <p>3.1 The Resin and Catalyst shall be clear liquid, free from dust and other visible impurities.</p> <p>3.2 During storage, a separate layer at the top and sedimentation at the bottom should not be formed within the stipulated shelf life.</p> <p>4.0 Properties</p> <p>4.1 Resin</p> <p>The Resin shall have the following typical properties.</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">Appearance</td> <td>Clear liquid (Brown)</td> </tr> <tr> <td>Viscosity at 25° C</td> <td>150-250 CP/ 50-80 seconds in B4 cup as per IS3944</td> </tr> <tr> <td>pH value</td> <td>4 to 6.5</td> </tr> <tr> <td>Density at 25° C</td> <td>1.2 to 1.25 gms/cm³</td> </tr> <tr> <td>Nitrogen content</td> <td>0.6 % max</td> </tr> <tr> <td>Permissible content of</td> <td>Free Phenol 6% max</td> </tr> <tr> <td></td> <td>Free Formaldehyde (Formalene) 0.3% max</td> </tr> <tr> <td>Solid content</td> <td>71% minimum</td> </tr> </table>				Appearance	Clear liquid (Brown)	Viscosity at 25° C	150-250 CP/ 50-80 seconds in B4 cup as per IS3944	pH value	4 to 6.5	Density at 25° C	1.2 to 1.25 gms/cm ³	Nitrogen content	0.6 % max	Permissible content of	Free Phenol 6% max		Free Formaldehyde (Formalene) 0.3% max	Solid content	71% minimum
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डिजाइन एवं स्थापना DESIGN & D/P'TE	RMI MPIC CHAIRMAN CPSC सहस्रम विभाग AGREED DEPTT.	NK SAHU KD SOOD KK GUPTA नाम NAME	अनुमोदक TRANSLATED BY T DAVE T DAVE AK CHAKRABORTY NG SRINIVASAN संस्थान मानक समिति PLANT STANDARDS COMMITTEE PREPARED : FOUNDRY TECH ISSUED : FOUNDRY TECHNOLOGY																
जगदीश शर्मा INVENTORY NO.	तारीख DATE : 28.5.03																		

दिनांक एवं साइन SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFEP - HARDWAR)	FF 06004 Rev 02 पृष्ठ का Page 2 of 6											
SUPERSEDES INVENTORY NO. आगामी पूर्ण योजना को प्रतिस्थापित करण	<p>4.2 Catalyst (Typical)</p> <p>The catalyst should be super saturated solution of para toluene sulphonic acid (PTSA). The minimum normality of the catalyst shall be 4 N.</p> <p>4.3 Sand-Mixes</p> <p>4.3.1 The sand mix prepared as per clause 5.0 shall be tested for compression strength, bench life and following requirement shall be met.</p> <table border="1" data-bbox="446 659 1287 911"> <tr> <td data-bbox="446 659 721 730">Time after making of AFS standard specimen</td> <td data-bbox="721 659 1287 730">Minimum compression strength at ambient temperature of 25-30° C</td> </tr> <tr> <td data-bbox="446 730 721 766">A 2 Hour</td> <td data-bbox="721 730 1287 766">16 Kg/cm²</td> </tr> <tr> <td data-bbox="446 766 721 802">A 4 Hour</td> <td data-bbox="721 766 1287 802">18 Kg/cm²</td> </tr> <tr> <td data-bbox="446 802 721 837">A 24 Hour</td> <td data-bbox="721 802 1287 837">32 Kg/cm²</td> </tr> <tr> <td data-bbox="446 837 721 911">B Bench life</td> <td data-bbox="721 837 1287 911"> i) 15 minutes or more ^{and upto} at 30° C ii) 10 minutes or more above 30°C with or without dilution </td> </tr> </table> <p>4.3.2 Gas emission during pouring of the mould:</p> <p>The fumes generated during sand preparation and mould/core making shall not be excessive which inhibit working on the shop floor.</p>				Time after making of AFS standard specimen	Minimum compression strength at ambient temperature of 25-30° C	A 2 Hour	16 Kg/cm ²	A 4 Hour	18 Kg/cm ²	A 24 Hour	32 Kg/cm ²	B Bench life	i) 15 minutes or more ^{and upto} at 30° C ii) 10 minutes or more above 30°C with or without dilution
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दिनांक एवं साइन SIGN & DATE														
आगामी पूर्ण योजना		निर्मागकर्ता WORKED BY	T DAVE	28.5.03										
		जांचकर्ता CHECKED BY	AKC	28.5.03										