

**3 X 660 MW- LALITPUR STPP**

**BOM FOR ALUMINIUM SHEET**

Specification Ref. No- PE-SS-999-169-M034 / Rev 02

Vol. II-B Section-D


Dated- 26.04.2012

The quantities of Aluminum sheet is to be ordered are as given below:

- 1. 20 SWG to Gr 19000H2- 54800 Kg**
- 2. 22 SWG to Gr 19000H2- 22000 Kg**
- 3. 22 SWG to Gr 19000H2- 2000 Kg**

**NOTE: ABOVE B.O.M. IS FOR ONE UNIT. ORDER & SUPPLY WILL BE FOR THREE UNITS .**



	<b>TITLE:</b>  <b>STANDARD TECHNICAL SPECIFICATION FOR ALUMINIUM CLADDING SHEETS</b>	STD SPECIFICATION No: PE-SS-999-169-M034	
		VOLUME II-B	
		SECTION "D"	
		REV. NO. 03      DATE: 05.03.2011	
		SHEET 1 OF 2	

## 1.00.00 GENERAL

This specification covers the requirements for supply of Aluminium sheet for using it as cladding or protective covering over Thermal insulation.

## 2.00.00 CODES & STANDARDS

- 2.01.01 The manufacture, physical & chemical properties, inspection and testing of Aluminium sheets to be supplied under this specification shall conform to the latest edition of the following codes and standards.
- 2.01.02 IS:737 Specification for wrought aluminium and aluminium alloy sheet and strip for general engineering purposes.
- 2.01.03 IS:504 Methods of chemical analysis of aluminium and its alloys.
- 2.01.04 IS:1608 Metallic materials - Tensile testing at ambient temperature
- 2.01.05 IS:2676 Dimensions for wrought aluminium and aluminium alloys, sheet and strip.
- 2.01.06 IS:5052 Aluminium and its alloys - Temper designations.

## 3.00.00 MATERIAL REQUIREMENTS:

### 3.01.00 FORM

The aluminium sheets to be supplied will be in coil form.

### 3.02.00 FREEDOM FROM DEFECTS

The material shall be sound and free from harmful defects for the intended application.

### 3.03.00 DESIGNATION AND CONDITION

The designation and the condition of the material will be in line with IS:737 **Gr. 19000 H2 or Gr. 31000 H3** as specified in the BOM.

### 3.04.00 CHEMICAL COMPOSITION

The material when analyzed as per IS 504 or any other instrumental/chemical method shall conform to the requirements as given in Table 1 of IS:737.

### 3.05.00 MECHANICAL PROPERTIES

#### 3.05.01 TENSILE TEST

The material when tested in accordance with IS:1608 shall conform to the values given in Table 2 of IS:737.

#### 3.05.02 BEND TEST

When tested in accordance with the method prescribed in IS:737, the outer surface of the bend shall not show any visible crack.

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#### **4.00.00 DIMENSION AND TOLERANCES**

- 4.01.00 The width of the aluminium sheet will be 900 or 1200 mm.
- 4.02.00 Standard thicknesses of the aluminium sheet will be 0.56, 0.71, 0.91, 1.22 mm. (Requirements to be given separately).
- 4.03.00 Tolerances on width and sheet thickness shall be as given in IS:2676.

#### **5.00.00 INSPECTION AND TESTING**

- 5.01.00 The material sampling will be done as given in IS:737.
- 5.02.00 The material to be supplied under this specification will be of tested quality. Inspection and testing of Aluminium sheets will be carried out as per the requirements of IS:737. Manufacturer's test certificate indicating all the chemical composition and mechanical properties will be furnished.
- 5.03.00 All test certificates will be submitted in ORIGINAL for BHEL / CUSTOMER review and based on the satisfactory test results MDCC will be issued.

#### **6.00.00 PACKING AND MARKING**

- 6.01.00 The material will have to be packed in polythene-lined hessian and covered with metallic sheets and finally strapped with metallic bands suitably. Material shall be packed in such a manner so as to prevent damage in ordinary handling & transport.
- 6.02.00 Each package shall contain only one size of material.
- 6.03.00 Each package / coil will be suitably marked with a tag for identification as given below: (legibly written on the packet).
- BHEL's Purchase order number
  - Project Name
  - Name of the manufacturer
  - Material grade & condition
  - Sheet thickness
  - Weight of the contents