

**COAL DUST****1.0 GENERAL:**

This specification governs the quality requirements of Coal Dust and its substitutes for use in foundry.

**2.0 APPLICATION:**

Used as an additive in the preparation of green sand for the production of moulds.

**3.0 CONDITION OF DELIVERY:**

The specification is generally based on following national standards and also meet the requirements of this specification.

IS:1752 – 1973 : Coal dust for use in cast iron foundry.

**4.0 FREEDOM FROM DEFECTS:**

The material shall be free from contaminations like iron pyrites, slates, etc.

**5.0 TEST SAMPLES:**

Composite samples shall be prepared from each lot of 10 MT or part thereof and tested for its properties and shop floor performance.

**6.0 PROPERTIES:**

The material shall show the following properties when tested as per IS : 1752.

- |                                                 |   |            |
|-------------------------------------------------|---|------------|
| a) Moisture<br>(to be analysed for two samples) | : | 1.5 % max. |
| b) Proximate analysis on dry basis              | : |            |
| i) Volatile matter                              | : | 50% min.   |
| ii) Ash                                         | : | 7% max     |

**7.0 SHOP TEST:**

The material shall be tested for its satisfactory performance on the shop floor.

**Revisions :**

Cl: 19.9.25 of MOM of MRC-FN

**APPROVED :**

**INTERPLANT MATERIAL  
RATIONALISATION COMMITTEE-MRC (FN)**

Rev. No. 01

Amd.No.

Reaffirmed

Prepared  
EPD,  
BANGALORE

Issued  
Corp. R&D

Dt. of 1st Issue  
July, 1996

Dt: 15.06.2005

Dt :

Year :

**8.0 INSPECTION AT SUPPLIER'S WORKS:**

Whenever specified, tests and inspection are to be conducted in the presence of BHEL's representative.

The supplier shall offer BHEL's representative all reasonable facilities, without charge to satisfy the latter that the material is being furnished in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed tests elsewhere. The supplier shall notify BHEL in advance about the readiness of the material for inspection and testing.

BHEL reserves the right to test the material at BHEL's work and the final acceptance of the material shall be based on these test results.

**9.0 TEST CERTIFICATES:**

Unless and otherwise stated, three copies of certificates shall be supplied along with each consignment giving the following information.

In addition the supplier shall ensure to enclose one copy of test certificate along with their despatch documents to facilitate quick clearance of the material.

AA 518 03 (Rev. No. 01) : Coal Dust

BHEL order no.

Manufacturer's / supplier's name.

Trade mark, if any.

Quantity supplied.

Test results of clause 6.0.

**10.0 PACKING AND MARKING:**

Material shall be supplied in water proof bags each of 50 kg capacity and each bag shall be legibly marked or labelled with the following information.

AA 518 03 : Coal Dust

BHEL Order No.

Manufacturer's / supplier's name.

Batch / lot No.

Trade mark, if any.

Quantity supplied

**11.0 REJECTION AND REPLACEMENT:**

If the material does not comply with the requirements of this specification during receipt inspection at BHEL or if any defect 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 undertake to replace the rejected material at his own cost and the rejected material shall be taken back by the supplier after fulfilling the commercial terms and conditions.

**12.0 REFERRED STANDARDS (Latest Publications Including Amendments):**

1. IS:1752