



CORPORATE PURCHASING SPECIFICATION

AA11302

Rev No.01

PREFACE SHEET

CHILLED IRON GRIT

FOR INTERNAL USE ONLY

REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS

Comparable Standards:

INDIAN : IS: 4683-1968, Chilled Iron shot and grit for use in foundries

Suggested/ Probable Suppliers and Grades

As per respective Plant's PMD

User Plant References:

1. HYDERABAD : --

Revisions:
Clause No. 25.03 of MOM of MRC – FN

APPROVED:
INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC(FN)

Rev No.01	Amd No.	Reaffirmed	Prepared HEP, Bhopal	Issued Corp.R&D	Dt. of 1 st Issue 01-07-1985
Dt:15-01-2004	Dt:	Year:2014			

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CHILLED IRON GRIT

1.0 GENERAL:

This specification governs the quality requirements of Chilled Iron Grit for the use in foundries.

2.0 APPLICATION:

Used as blasting material for cleaning the surfaces of iron and steel castings.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

This specification is generally based on the following national standard and also meet the requirements of this specification.

IS: 4683-1968, Gr.G-C1 40: Specification for chilled iron shot and grit for use in foundries

4.0 SHAPE:

The particles shall show good angularity of form with sharp cutting edges and shall be substantially free from half rounds (i.e. shot, split in half only).

5.0 SIZE:

The particle size shall be determined on a representative sample by testing with sleeves complying with IS: 460. The proportions retained and passed shall be as follows:

- Passed through 2 mm IS sleeve – All
- Retained on 1.4 mm IS sleeve – 80%, min.
- Passed through 1.4 mm IS sleeve – 10%, max.
- Fines-passed through 1 mm IS sleeve – 2%, max.

6.0 HARDNESS:

Vickers hardness test shall be carried out on representative samples by mounting particles in a suitable material like thermo setting plastic. The hardness of any particle shall be 750 HV, min.

7.0 SAMPLING:

A composite sample shall be prepared and tested for size, shape and hardness.

Revisions:
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**CORPORATE PURCHASING
SPECIFICATION****8.0 ACCEPTANCE CRITERIA:**

Each consignment shall be accepted on the basis of tests as per clause 4.0, 5.0 and 6.0.

9.0 INSPECTION DEVIATION AND REPLACEMENT:

9.1 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.

9.2 If the material received is not found suitable to our requirements, it shall be replaced free of charge by the supplier.

9.3 Final tests shall be carried out at BHEL and material will be accepted or rejected based on this result.

9.4 For any deviation demanded by the supplier from the specification, prior approval of BHEL must be obtained in writing.

10.0 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied along with each consignment.

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

The test certificates shall bear the following information:

AA11302, Rev No.01: CHILLED IRON GRIT

BHEL Order No.

Manufacturer's/ Supplier's Name.

Trade mark, if any

Batch No.

Grit Grade

Test Results of clauses 4.0, 5.0 and 6.0

11.0 PACKING AND MARKING:

The material shall be supplied in waterproof gunny bags of 50 kg. Each bag shall be marked as follows.

AA11302: CHILLED IRON GRIT

BHEL Order No.

Manufacturer's/ Supplier's Name.

Batch No.

Grain Grade.

Net Weight and gross weight

12.0 Referred Standards (Latest publications including amendments):

1) IS: 460