



# PLANT PURCHASING SPECIFICATION

HY 54762

Rev. No.00

Page 1 of 1

①  
②

## MOLASSES

### 1.0 SCOPE:

This specification covers the requirement of molasses for use in foundry.

### 2.0 COMPLIANCE WITH NATIONAL STANDARD:

This specification generally complies with I.S 1162-1958. Reaffirmed 1987.

### 3.0 REQUIREMENTS:

The material shall satisfy the following requirements.

- (a) DENSITY: 35-40<sup>0</sup> Balme at 30<sup>0</sup> c.
- (b) PRACTICAL TEST: Silica sand (medium grade) when mixed with 5% molasses, 8% cement & 1 to 5% water shall develop the following properties.
  - (i) Bench life .....30 - 45 Mts.
  - (ii) Compression Strength kg/cm<sup>2</sup>
    - at 4 hrs .....min.....10kg/cm<sup>2</sup>
    - at 24 hrs.....min .....20kg/cm<sup>2</sup>

Revisions:			Issued : STANDARDS ENGINEERING DEPARTMENT		
Rev No.	Amd No.	Reaffirmed	Prepared:	Approved:	Dt. of 1 <sup>st</sup> Issue
Dt	Dt.	Year.	DY.G.M., TECH. (F&P)	MANAGER, STDS. ENGG.	MAR. 2002.

This document is the property of HILAKATILAKA. It is not to be used directly in any way detrimental to the interest of the information.