

Technical Delivery Conditions for the Supply of Woods used as Spacers and for Stacking of tubes and Pipes.

1.0 S C O P E :

1.1 This TDC specifies the Quality requirements of woods to be used as Spacers and stacking of tubes and pipes in SSTP.

1.2 The species shall be of Rubber wood - seasoned and chemically treated rubber wood in converted form and it should be confirmed.

2.0 D I M E N S I O N S :

2.1 Dimensions and descriptions shall be given by indenting department and the same shall be reproduced in the purchase order.

3.0 Tolerance for Dimensions :

3.1 Dimensional tolerance shall be as follows:-

Length	: + 10mm, - 0mm
Width	: + 5mm, - 0mm
Thickness	: + 5mm, - 0mm
Bow tolerance	: 5mm per 500mm subject to maximum of 10mm/metre

3.2 Twist in the woods is not permitted

4.0 Freedom from defects:

4.1 Woods shall be free from common timber defects like cracks, knots etc

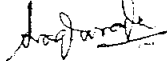
5.0 CHEMICAL TREATMENT :

5.1 Supplies shall be subjected to chemical treatment complying with IS 401/1982 - Code of practice for Preservation of timber'.


5.2 For chemical treatment, the preservative chemicals used shall be copper, chrome, boron composition (CCB).

5.3 Chemical penetration depth shall be not less than 3mm when tested as per method given in IS 401/1982.

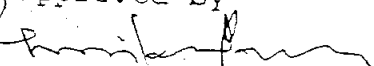
Prepared by

  
S. NAGARAJAN  
General foreman/QC

Reviewed by

  
R. VENKATARAMAN  
Manager/QC/IGI

Approved by

  
S. GOVINDASANKARAN  
D G M / Quality

BHEL  
SSTP  
Tiruchy-14

TDC/WOOD/02  
Rev. : 00 dt 070893  
Page 2 of 2

6.0 IDENTIFICATION:

6.1 Supplier shall give a specific colour code on one end of the cross section as specified in the purchase order for identity of supplier.

6.2 Species shall be indentified by microscopical examination of different cut section (viz, cross sectional, longitudinal and radial).

7.0 Sampling plan for testing :

7.1 Samples shall be drawn at random for testing the lot for chemical treatment and species identification. Quantity for sampling shall be 2% of the lot or 2 piece whichever is lower.

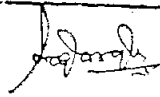
8.0 INSPECTION:

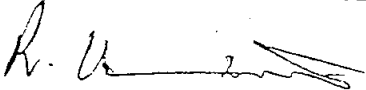
8.1 Inspection shall be done at SSTP for compliance with TDC

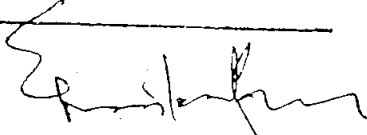
8.2 BHEL, if so desire shall check the species of wood for confirmation and also shall verify the process at suppliers work if needed.

9.0 CERTIFICATE

9.10 Certificate confirming the above TDC points shall accompany the supplies.

  
S. NAGARAJAN  
GENERAL FOREMAN/QC

  
R. VENKATRAMAN  
MANAGER/QC/IGI&RM

  
S. GOWRISHANKARAN  
D.G.M./QUALITY