

TECHNICAL AND DELIVERY CONDITIONS

Product :PINCH UNIT CHAIN ASSY

Document No:TDC:HMM1004 Rev No:00

Effective Date:21.03.2019

Page No:1-2

The technically suitable bidders would be informed about the tender opening date through e-mail. Clarifications if any required by BHEL for technical evaluation would be sought from bidders before opening of price bid. For any clarification the bidders may contact us through raju.d@bhel.in. Submit your offer in ABC procurement website only.

The bidders along with its associate/collaborators/sub – contractors/sub – vendors/ consultants/service providers shall strictly adhere to BHEL fraud prevention policy displayed on BHEL website <http://www.bhel.com> and shall immediately bring to the notice of BHEL management about any fraud or suspected fraud as soon as it comes to their notice.

Supply of pinch roller assembly as per drawings. Vendor should make a visit to BHEL, SSTP/Trichy works for an on the spot study of the requirements of BHEL prior to submitting the technical offer. The offer submitted without a visit and assessment shall not be considered for technical evaluation.

Vendor qualifying criteria: Only those vendors who satisfy the following conditions will get qualified to participate in the tender:

1. Vendor should have minimum 3 years of experience in this field.
2. Previous PO details for supplying similar kind of items to BHEL and/or any other organization should be submitted along with offer. Otherwise offer will be rejected.
3. Company profile details has to be provided along with offer.
4. BHEL reserves the right to visit the vendors work for verifying the manufacturing facilities and any other credential furnished by the vendor. In case the information furnished with the offers found to be false/incorrect, the offer shall be rejected.
5. Supply of bearings should be of SKF, FAG, NTN, TIMKEN, INA, IKO & NSK make only acceptable.
6. Bearings shall be Genuine, sealed at Factory and supported by Manufacturer's Inspection/Test Certificates in original.
7. Bearing Dealership certificate should be provided from the authorized manufacturer's.

1)TEST CERTIFICATE

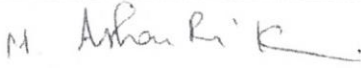
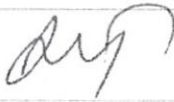
Test certificate shall be furnished by the supplier giving the details of the test results of the product as per material specification shown in the drawings.

2)INSPECTION AT SUPPLIER'S WORKS

- 1.The material shall be marked with PO No, and supplier name, which shall be non- erasable.
- 2.The material shall be coated with rust preventive oil
3. Before assembling the bearings EP-2 Grease to be packed.
- 4.After packing the grease nipple to be provided.

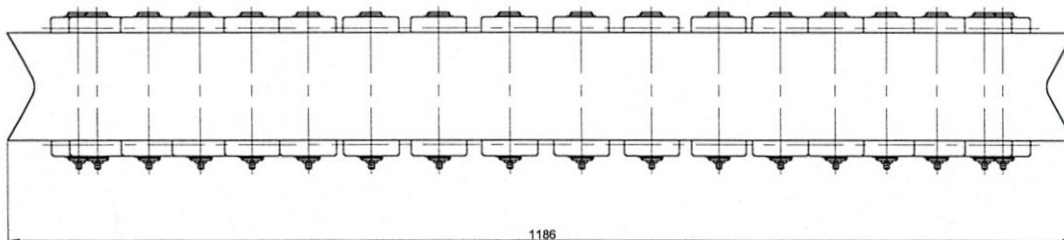
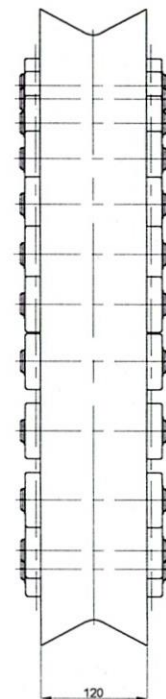
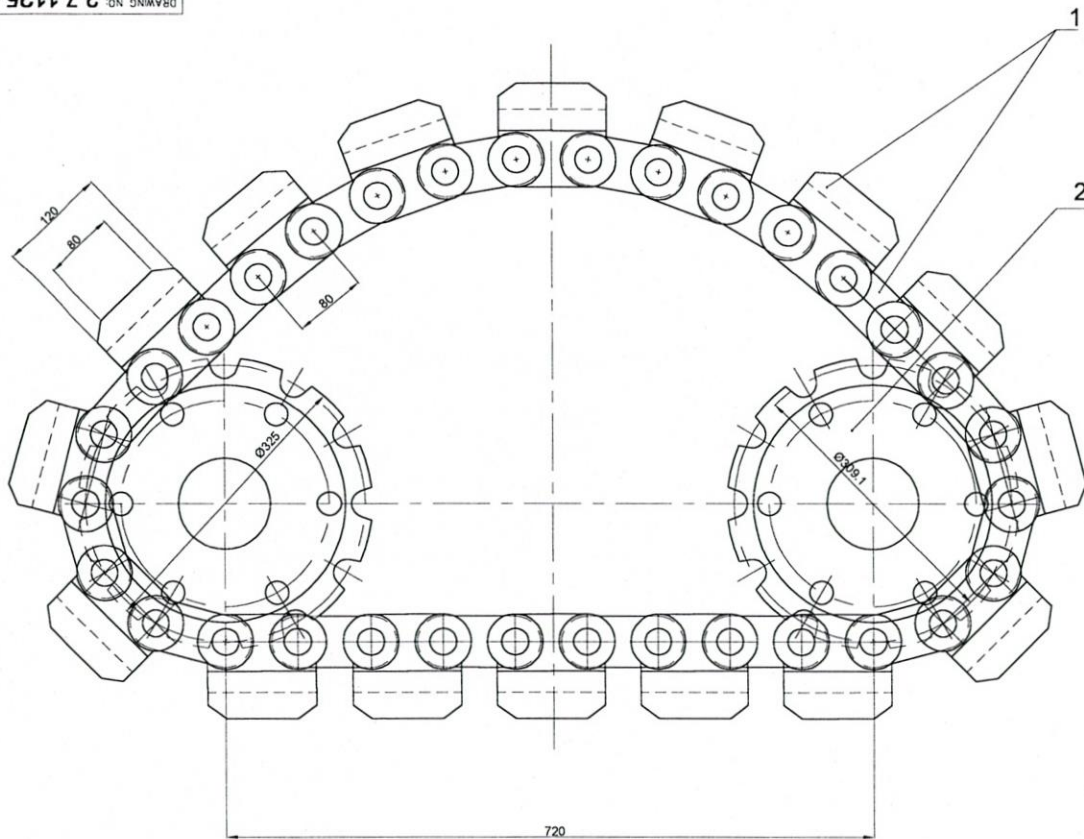
3)Dispatch condition

1. Chain assembly to be tightly packed in wooden box before dispatch.
2. Chain should be supplied in assembled condition.

	
M.Ashok raja Kumar	D. RAJU
PREPARED BY	REVIEWED & APPROVED BY

DRAWING NO: 2-7-1125-21-10104

ALL DIMENSIONS ARE IN MILLIMETERS



NOTE:
FOR TRANSFER CHAIN - PARTS REFER DRG. NO. : 2-7-1125-21-10103

2	CHAIN SPROCKET		45C8 IS 1875	28.60
1	TRANSFER CHAIN - PARTS	2-7-1125-21-10103		166.84
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY

EQPT: POSITIONING ROLLER CONVEYOR, CRIMPING LINE AND CRIMPING PRESS WITH FACILITIES

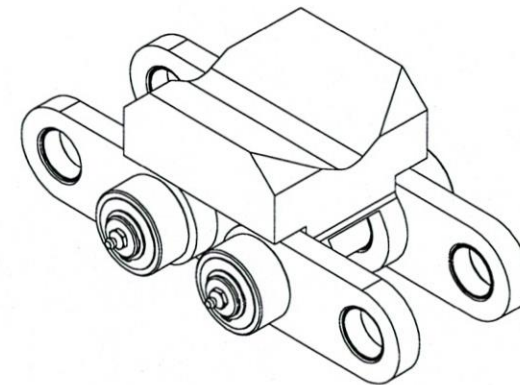
	Bharat Heavy Electricals Ltd		DRN	S.S.N.KUMAR / R.V	SIGNATURE	DATE
	SEAMLESS STEEL TUBE PLANT		CHD	C.LOCANATHAN	<i>C. Loganathan</i>	23.11.13
	TIRUCHIRAPALLI - 620014		APPD	M.CHANDRAKUMAR	<i>M. Chandrakumar</i>	23.11.13

DEPT	SSIP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO	ITEM
456		$\phi / M / F$ IS 2192	1:4	195.44	0.301511-21.000 - 02	
TITLE				CARD CODE	DRAWING NO :	REV
CRP - TRANSFER CHAIN ASSY				U 01	2-7-1125-21-10104	01

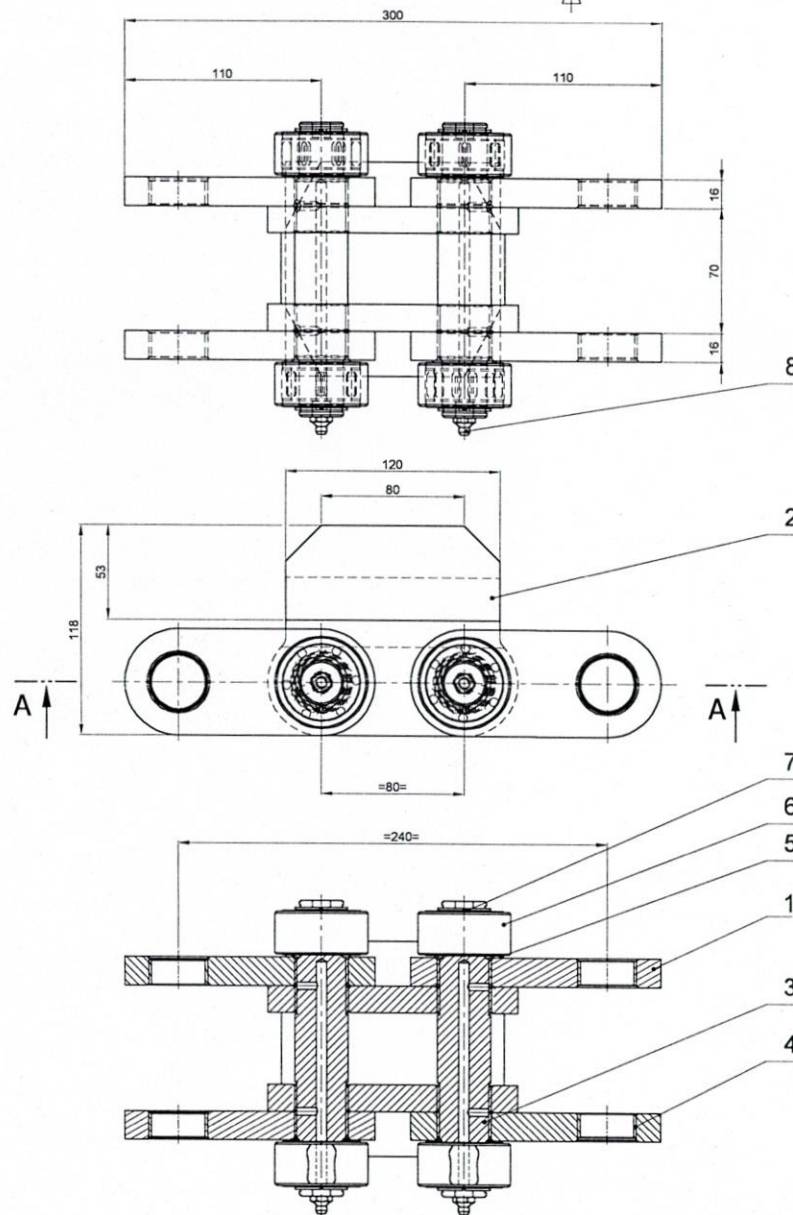
REV 01 DATE 25.03.19 ALTERED BY S.S.N.Kumar/R.V CHECKED BY S.S.N.Kumar/R.V APPROVED BY S. Loganathan
BACK SIDE GREASE NIPPLES ARE REMOVED AS PER USER'S REQUEST

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A2-SIZE



NOTE:
FOR TRANSFER CHAIN ASSY REFER DRG. NO. : 2-7-1125-21-10104



SECTION A-A

REV	DATE	ALTERED	BY	REV	DATE	ALTERED	BY
02	25.03.19	CHECKED	S.S.N. Kumar/M.B.	01	02.11.15	CHECKED	S.S.N. Kumar/M.B.
		APPROVED	S. S. S. Kumar			APPROVED	S. S. S. Kumar

1/4" BSP WAS G 1/4 REVISED AS PER USER'S REQUEST

ITEM NO 7 HEAVY DUTY CIRCLIP A25x2 IS 30 (PART-1)-1986 WAS CIRCLIP 25x1 5N IS 3075 REVISED AS PER USER'S REQUEST.

1/4" BSP WAS G 1/4 REVISED AS PER USER'S REQUEST

ITEM NO 7 HEAVY DUTY CIRCLIP A25x2 IS 3075 (PART-1)-1986 WAS CIRCLIP 25x1 SN IS 3075 REVISED AS PER USER'S REQUEST

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	QTY
8	CONICAL GREASE NIPPLE 1/4" BSP IS 4009 / 2		St Gr 4.8 IS 1367	32	0.008
7	HEAVY DUTY CIRCLIP A25x2 IS :3075(PART-1)-1986			64	0.002
6	SUPPORT ROLLER WITH FLANGE RINGS (TRACK ROLLERS) PWTR 2562.2RS		SKF / INA	64	0.238
5	PLAIN WASHER 25 IS 2016		STEEL	64	0.004
4	BUSH FOR INNER / OUTER LINKS	4-7-1125-21-10244		96	0.018
3	LINKS CONNECTING SHAFT	3-7-1125-21-10114		32	0.771
2	V - BLOCK - INNER LINK	3-7-1125-21-10115		16	6.247
1	OUTER LINK	4-7-1125-21-10243		32	0.759

EQUIP: POSITIONING ROLLER CONVEYOR , CRMPING LINE AND CRIMPING PRESS WITH FACILITIES		NAME		SIGNATURE	DATE
Bharat Heavy Electricals Ltd		S.S.N.KUMAR/C.R		S.S.N. Kumar/C.R	26.11.13
SEAMLESS STEEL TUBE PLANT		CHD		C.LOCANATHAN	26.11.13
TIRUCHIRAPALLI - 620014		APPD		M.CHANDRAKUMAR	26.11.13
DEPT	35TH	GRADE OF UNCL. DIM	SCALE	WEIGHT (Kg)	ITEM
CODE	456	1:2	166.768	REF TO ASSY DWG NO	2-7-1125-21-10104
TITLE				DRAWING NO :	REV
CRP - TRANSFER CHAIN - PARTS				2-7-1125-21-10103	02

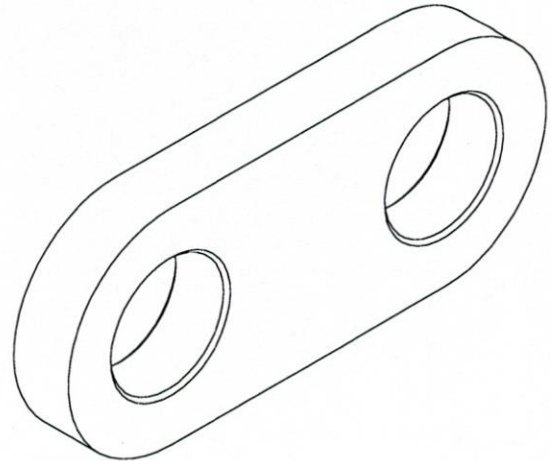
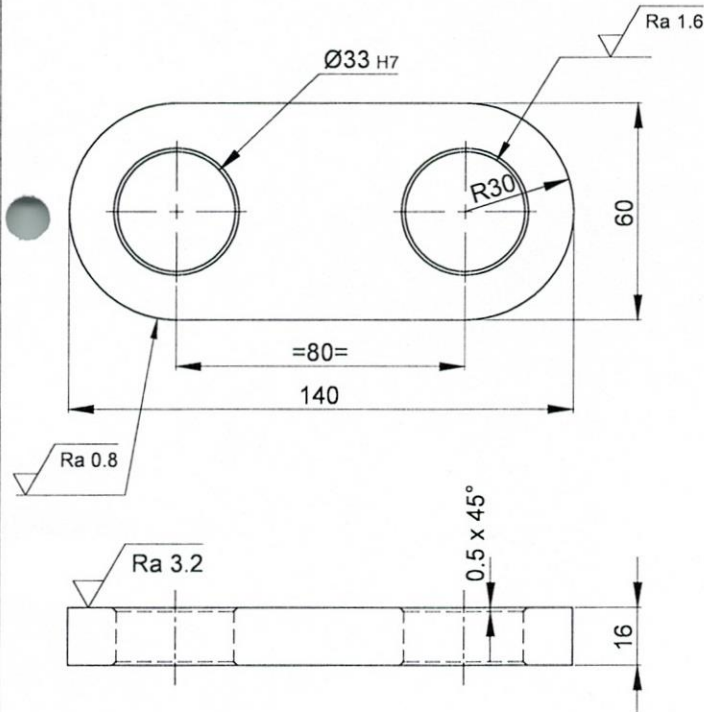
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ALL DIMENSIONS ARE IN MM

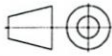
REV 01	DATE	ALTERED
		CHECKED
		APPROVED

✓ (✓ Ra 0.8 ✓ Ra 3.2 ✓ Ra 1.6)

Nominal size	Tolerance field	Deviation
Ø33	H7	+0.021 0



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1	PL 140 x 60 x 12		E 410C IS 2062	
ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT
			MATL SPEC	QTY
EQPT: POSITIONING ROLLER CONVEYOR, CRIMPING LINE AND CRIMPING PRESS WITH FACILITIES				
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		NAME	SIGNATURE	DATE
		DRN	S.S.N.KUMAR / R.V	<i>S.S.N.Kumar/R.V</i> 28.11.13
		CHD	G.LOGANATHAN	<i>G.Loganathan</i> 28.11.13
		APPD	M.CHANDRAKUMAR	<i>M.Chandrakumar</i> 28.11.13
DEPT SSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO
CODE 456	 IS: 2102	1:2	0.759	2-7-1125-21-10103
TITLE				REF TO OLD DWG NO
CRP - OUTER LINK				-
CARD CODE				DRAWING NO :
U 01				4-7-1125-21-10243
				ITEM 1
				REV 00

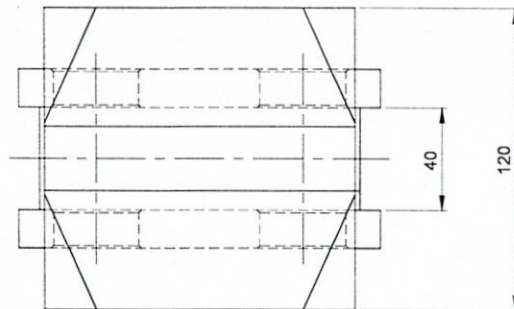
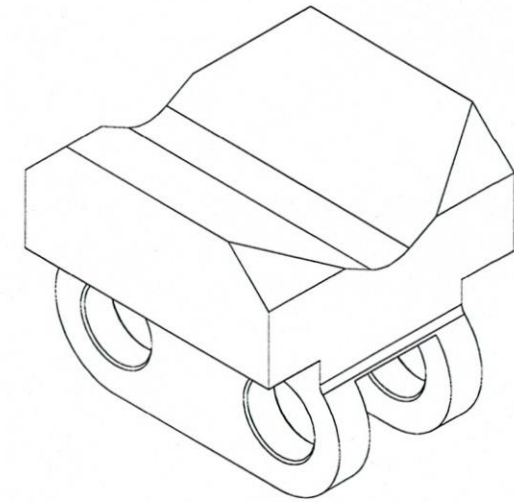
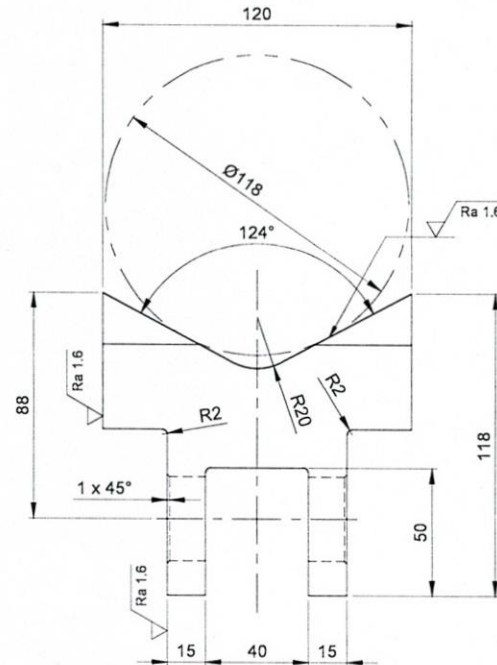
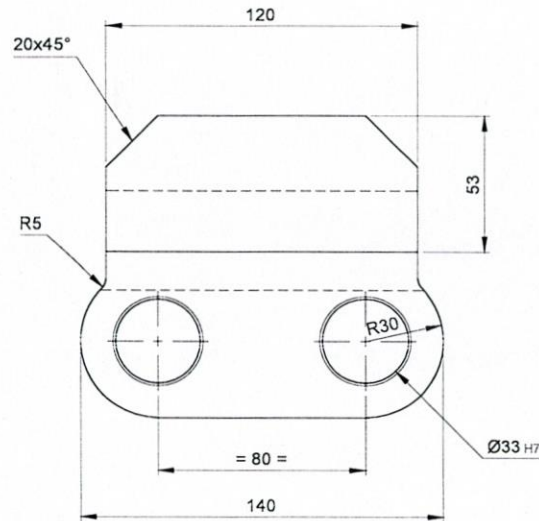
A4--SIZE

ALL DIMENSIONS ARE IN MILLIMETRES

DRAWING NO: 3-7-1125-21-10115

✓ (✓) Ra 1.6

Nominal size	Tolerance field	Deviation
Ø33	H7	+0.021 0



REV	DATE	ALTERED
01		CHECKED
		APPROVED

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ITEM NO		DESCRIPTION		DRAWING NO		E 410C IS 2062		UNIT WT	
						MATL CODE		QTY	
						MATL SPEC			
EQPT: POSITIONING ROLLER CONVEYOR , CRIMPING LINE AND CRIMPING PRESS WITH FACILITIES									
DEPT		GRADE OF UNTOL. DIM		SCALE		WEIGHT (Kg)		REF TO ASSY DWG NO	
SSTP		456		1:2		6.247		2-7-1125-21-10103	
CODE		456		1:2		6.247		REF TO OLD DWG NO	
TITLE		CRP - V - BLOCK - INNER LINK		CARD CODE		DRAWING NO :		REV	
				U 01		3-7-1125-21-10115		00	

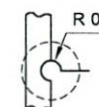
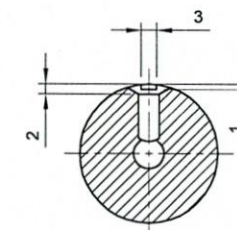
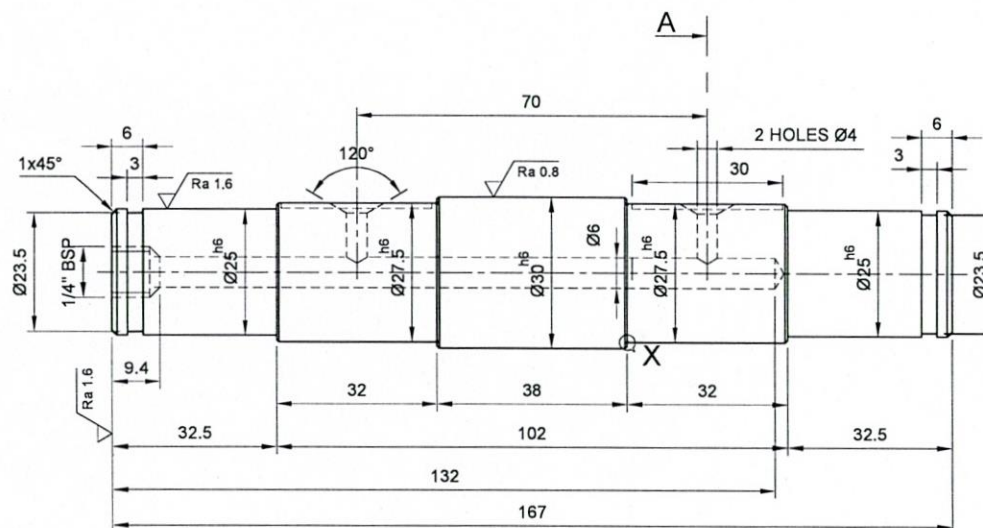
A3-SIZE

DRAWING NO: 3-7-1125-21-10114

ALL DIMENSIONS ARE IN MILLIMETRES

✓ Ra 3.2 (▽ Ra 0.8) (▽ Ra 1.6)

Nominal size	Tolerance field	Deviation
Ø25	h6	-0.000 -0.013
Ø27.5	h6	-0.000 -0.013
Ø30	h6	-0.000 -0.016



DETAIL - X
SCALE 1:10

REV 03		DATE 25.03.19	ALTERED CHECKED <i>S.S.N. Kuman</i> APPROVED <i>D. Abhinava</i>	REV 01		DATE 19.08.2015	ALTERED CHECKED <i>S.S.N. Kuman</i> APPROVED <i>S. Loganathan</i>	REV 02		DATE 28.03.16	ALTERED CHECKED <i>R. K. Singh</i> APPROVED <i>R. K. Singh</i>
1/4" BSP WAS G 1/4 REVISED AS PER USER'S REQUEST				MISSING DIMENSION OF CIRCLIP GROOVE Ø23.5 ADDED				Ø27.5 h6 WAS Ø30 h6 REVISED AS PER USER'S REQUEST			
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ITEM NO		DESCRIPTION		DRAWING NO		42CrMo4		MATERIAL CODE		UNIT WT	
								MATL SPEC		QTY	
EQPT: POSITIONING ROLLER CONVEYOR, CRIMPING LINE AND CRIMPING PRESS WITH FACILITIES											
DEPT		GRADE OF UNTOL. DIM		SCALE		WEIGHT (Kg)		REF TO ASSY DWG NO		ITEM	
SSTP		Ø / M / F		1:1		0.771		2-7-1125-21-10103		3	
CODE		IS: 2102						REF TO OLD DWG NO			
456											
TITLE								DRAWING NO :		REV	
CRP - LINKS CONNECTING SHAFT								3-7-1125-21-10114		03	
CARD CODE								U 01			

ALL DIMENSIONS ARE IN MM

REV 01	DATE	ALTERED	<i>S.P.N. Kumar / K.N.</i>
	19.08.2015	CHECKED	<i>R.K. Singh</i>
		APPROVED	<i>S. Loganathan</i>

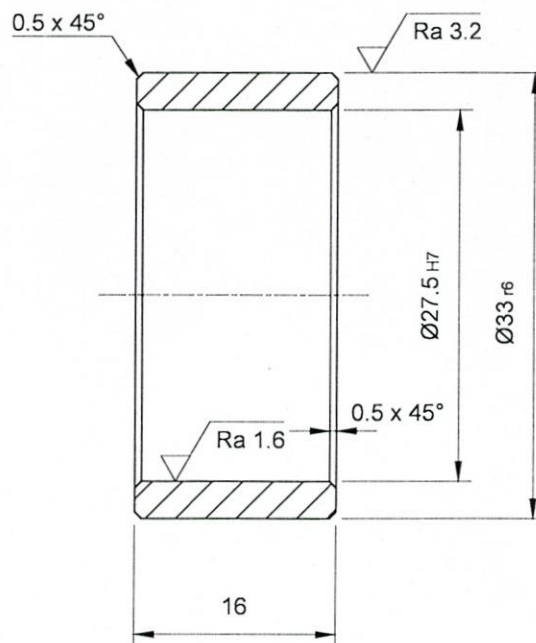
Ø27.5 H7 WAS Ø30 H7 REVISED AS PER
USER'S REQUEST

✓ (✓ Ra 1.6 ✓ Ra 3.2)

REV 02	DATE	ALTERED	<i>S.P.N. Kumar / V.P.M.</i>
	28.03.16	CHECKED	<i>R.K. Singh</i>
		APPROVED	<i>R.K. Singh</i>

MATL. SPEC. SS304 WAS CUSn8Zn4 IS 306
REVISED AS PER USER'S REQUEST.

Nominal size	Tolerance field	Deviation
Ø27.5	H7	+0.021 +0.000
Ø33	r6	+0.050 +0.034



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ITEM NO	DESCRIPTION	DRAWING NO	SS304	MATL CODE	UNIT WT
				MATL SPEC	QTY
EQPT: POSITIONING ROLLER CONVEYOR, CRIMPING LINE AND CRIMPING PRESS WITH FACILITIES					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME S.S.N.KUMAR / R.V	SIGNATURE <i>S.P.N. kumar / R.V</i>	DATE 28.11.13
		CHD	G.LOGANATHAN	<i>S. Loganathan</i>	28.11.13
		APPD	M.CHANDRAKUMAR	<i>M. Chandrakumar</i>	28.11.13
DEPT SSSTP	GRADE OF UNTOL. DIM	SCALE	WEIGHT (Kg)	REF TO ASSY DWG NO 2-7-1125-21-10103	ITEM 4
CODE 456	 IS: 2102	2:1	0.032	REF TO OLD DWG NO -	
TITLE CRP - BUSH FOR INNER / OUTER LINKS			CARD CODE U 01	DRAWING NO : 4-7-1125-21-10244	REV 02

A4-SIZE