



An ISO 9001
Company

Bharat Heavy Electricals Limited

(High Pressure Boiler Plant)

Tiruchirappalli – 620014, TAMIL NADU, INDIA

CAPITAL EQUIPMENT / MATERIALS MANAGEMENT

ENQUIRY

NOTICE INVITING TENDER

Phone: +91 431 257 76 53

Email : skaruna@bheltry.co.in

spsy@bheltry.co.in

Web : www.bhel.com

TWO PART BID	Enquiry Number:	Enquiry Date:	Due date for submission of quotation:
Tender to be submitted in two Parts	2601700038	06.07.2017	28.07.2017

You are requested to quote the Enquiry number date and due date in all your correspondence. This is only a request for quotation and not an order.

Please note that under any circumstances both delayed offer and late offers will not be considered. Hence vendors are requested to ensure that the offer should reach physically on or before 14.00 Hrs(IST) on the Date of tender opening. Tenders received after 14.00Hrs (IST) will not be considered for evaluation.

Item	Description	Quantity	(Indigenous Vendors) Matl. Will be Delivered to
10	CNC Wire Cut Electric Discharge Machine as per the technical specification & commercial conditions applicable(To be downloaded from web site www.bhel.com or http://tenders.gov.in)	1.00 No.	FOR, BHEL,Stores, High Pressure Boiler Plant, Trichirappalli - 620014

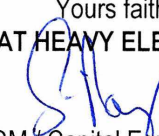
Important points to be taken care during submission of offer

- 1) Material shall be delivered to(By Indigenous vendors): As stated above.
- 2) By Foreign Vendors: CFR Chennai Seaport / Airport
- 3) Delivery required 20 weeks from the date of purchase order.
- 4) Erection & Commissioning period required 3 Weeks from the date of intimation by BHEL to vendor for deputation of their Engineers for E&C.
- 5) EMD for this Tender will be (INR) : 1,50,000.00
- 6) Compliance Forms. TRY/IMP/02 & TRY/IND/02A to be filled and enclosed along with the offer failing which, the offer will not be considered for evaluation.
- 7) All updates, amendments, corrigenda, etc., (if any), for each tender will be posted only on the above websites from time to time, as and when required, until each tender is opened. There will be no publication of such updates, amendments, corrigenda, etc., through newspapers or any other media.

BHEL's General guidelines / instructions (refer MM / CE / GENL / GENL / 001 - EMD) including bank guarantee formats and list of consortium banks, commercial terms check-list can be downloaded from BHEL web site <http://www.bhel.com> or from the Government tender website <http://tenders.gov.in> (public sector units > Bharat Heavy Electricals Limited page) under Enquiry reference .

Tenders should be submitted before 14.00Hrs (IST) on the due date
Tenders will be opened online at 14:30 hours on the due date
Tenders would be opened in presence of the tenderers who have submitted their offers and who may like to be present.

Yours faithfully,
For BHARAT HEAVY ELECTRICALS LIMITED


DGM / Capital Equipment / MM

S.PARTHASARATHY
MANAGER
CAPITAL EQUIPMENT / MM
BHEL, TRICHY-620014.

TECHNICAL SPECIFICATIONS FOR CNC WIRE CUT ELECTRIC DISCHARGE MACHINE (EDM)

PART- A

QUALIFYING CRITERIA FOR THE DESIGN & SUPPLY OF CNC WIRE CUT EDM

SECTION – I

The BIDDER/OEM (Original Equipment Manufacturer) is expected to give complete details against each clause in the table given below and wherever necessary an additional sheet may be attached (giving clear reference number) to cover the required details, asked for .

S.No.	PARTICULARS	BIDDER's RESPONSE
1	Number of Years of Experience, the BIDDER/OEM has in the field of design, manufacture and supply of 'CNC WIRE CUT ELECTRIC DISCHARGE MACHINES' for dedicated high precision machining applications.	
2	YEAR of LAUNCH of the MODEL quoted against this BHEL TENDER / ENQUIRY	
3	BIDDER to indicate the Country of Origin for the supply of the offered 'CNC Wire Cut Electric Discharge Machines'.	
4	Number of 'CNC Wire Cut Electric Discharge Machine'. supplied to High Precision Component Manufacturing Industries, across the globe and in INDIA - till date and the technical details on such systems, to ascertain the competency.	
5	Details on International Standards followed in Design, Manufacture and Testing of the subject model of 'CNC Wire Cut Electric Discharge Machines'. – copies of the relevant standards (IEC/EN/ISO) are to be furnished with the TECHNICAL BID compulsorily.	
6	The Machine Manufacturing Firm/OEM should have an ISO 9001:2008 certificate issued by internationally reputed QMS auditing organization.	

SECTION – II

The BIDDER / OEM has to compulsorily meet the following requirements to get qualified for submitting an offer for the "CNC Wire Cut Electric Discharge Machines" :

S.No.	PARTICULARS	BIDDER's RESPONSE
7	The BIDDER / OEM shall have a minimum of FIVE Years of Continuous Experience in the Design, Manufacturing and Supplying of 'CNC Wire Cut Electric Discharge Machines'	
8	Number of 'CNC WIRE CUT ELECTRIC DISCHARGE MACHINES' supplied, till date in the QUOTED MODEL / NEAR TO QUOTED MODEL, to Premium Class Industries shall be NOT LESS THAN two in the last FIVE years. To furnish the list of those customers with contact details for reference.	

S.No.	PARTICULARS	BIDDER's RESPONSE
9	BIDDER / OEM has to provide Performance Certificate with full contact details of CONTACT PERSON, who are the End Users of the QUOTED MODEL of "CNC Wire Cut Electric Discharge Machines" – (in the suggestive format as given in the ANNEXURE-A on Page No.3).	
10	Details on SERVICE-AFTER-SALES Set-Up in India including the Address of Agents / Service Centres, for providing technical assistance / spares supply.	
11	BHEL reserves the right to verify the information / data provided by the BIDDER / OEM. In case the information provided by BIDDER / OEM is found to be false / incorrect, the offer shall be summarily rejected.	

SECTION – III

The BIDDER / OEM has to comply with the following, for accepting the Technical Offer for scrutiny by the Purchaser:

S.No.	PARTICULARS	VENDOR's COMPLIANCE
12	The BIDDER / OEM shall submit the offer in TWO PARTS - Technical [with PART A & PART B] & Commercial Terms and Price Bid.	
13	The Offer shall contain a comparative statement of Technical Specifications given by BHEL and the Offer Details submitted by the BIDDER / OEM, against each clause. A just 'CONFIRMED' or 'COMPLIES' or 'YES' or 'NO-DEVIATION' or similar words in the technical offer may lead to disqualification of the Technical Offer	
14	The BIDDER / OEM shall assure a continuous support for SPARES and SERVICE for TEN Years, from the date of commissioning of the equipment at BHEL Works. This will be an undertaking by the OEM at the time of release of Purchase Order on the successful bidder.	
15	The Technical Offer shall be supported by Product Catalogue and Data Sheets in ORIGINAL and complete technical details / literature on the QUOTED MODEL of "CNC Wire Cut Electric Discharge Machines"	
16	The Commercial Offer (given with the Technical Offer) shall contain the Scope of Supply and the Un-Priced Part of the Price-Bid, for confirmation for the scope of supply – with UNIT RATE.	
17	The expected delivery period (including the time for Pre-Dispatch Inspection clearance by BHEL) for the "CNC Wire Cut Electric Discharge Machines" is not more than 20 weeks from the date of issue of BHEL Purchase Order.	

Enclosure : ANNEXURE – A (Performance Certificate)

ANNEXURE-A**PERFORMANCE CERTIFICATE**

The Performance of the subject model ‘CNC Wire Cut Electric Discharge Machines’ should be certified by the customer of the OEM/BIDDER on Customer's Letter Head, in the following pattern/format and submitted along with the TECHNICAL OFFER positively.

- 1.0 Name of the Machine Supplier (OEM) :
- 2.0 MODEL/MAKE, Serial No. ‘CNC Wire Cut E D M’ :
- 3.0 Month & Year of Commissioning of the Equipment :
- 4.0 Details on the Application/Use of the ‘CNC Wire Cut E D M’:

- 5.0 Performance of the ‘CNC Wire Cut E D M’ stated above : Very Good /
Satisfactory /
Not Good
- 6.0 Availability of the ‘CNC Wire Cut E D M’ stated above : Good / Poor
- 7.0 Service After Sales support given by the OEM /
Indian Representative, including spares supply : Satisfactory /
Not Satisfactory
- 8.0 Special Remarks / Recommendations :

Date:

Signature & Seal of the Authority
Issuing the Performance Certificate

PART - B**TECHNICAL SPECIFICATIONS FOR THE CNC WIRECUT ELECTRIC DISCHARGE MACHINE**

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION	VENDOR'S OFFER [with Complete Technical Details]
1.0	MACHINE CONFIGURATION	a) The CNC Wire Cut EDM Machine shall be with rigid machine bed and column. b) The machine shall have X, Y, U, V simultaneously controlled axes c) Integrated U & V axes are to be parallel to X & Y axes, d) To have e-pulse technology, CNC Pulse Generator, Part Programming Software, Dielectric Unit with Mineral Bed and Precision LM Guide ways for all axes e) To have an Isolation Transformer & Servo Stabilizer (can be sourced from INDIA through OEM's LOCAL Representative of the OEM/BIDDER)	[Bidder to give details, how these requirements are met with and to substantiate the claim.]
2.0	MACHINE TOOL SPECIFICATIONS		
2.1	Type of Machine and Design	Fixed column and moving table	
2.2	X axis Traverse	500 - 600 mm	
2.3	Y axis Traverse	400 - 450 mm	
2.4	Table size (X-axis)	800 - 900 mm	
2.5	Table size (Y-axis)	500 - 700 mm	
2.6	U axis Traverse	100 – 120 mm	
2.7	V axis Traverse	100 – 120 mm	
2.8	Work piece height (Min.)	350 mm	
2.9	Work piece weight (Min.)	500 kg	
2.10	U – V axis taper	+/- 35 deg. per 50 mm thick	
2.11	Wire spool capacity	>5 kg	
2.12	Electrode Wire diameter	0.15 - 0.25mm in steps of 0.05	

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION	VENDOR'S OFFER [with Complete Technical Details]
2.13	Surface Finish (Maximum)	after machining < 0.8 micron Ra	
2.14	Resolution of all axis	0.0005 mm	
2.15	Wire feed rate	0-15 m/min	
2.16	Jog Speed, (Minimum)	900 mm/min	
2.17	Metal Cutting Speed	150-200 mm ² /min on 50 mm thick steel with 0.25mm dia. Brass wire	
2.18	Least input increment	0.001 mm	
2.19	Controlled axis Z	Independent	
2.20	Ball screw dia. minimum for X and Y axis	25 mm	
2.21	Ball screw dia. minimum for U& V axis	20 mm	
3.0	PULSE GENERATOR		
3.1	Pulse Generator Type	MOSFET or equivalent or latest version	
3.2	Controlled axes	X, Y, U, V Simultaneous and Independent	
3.3	Interpolation	Linear & Circular	
3.4	Max. programmable dimension	+/- 99999.999 mm	
3.5	Data input/output	RS232 interface OR EQUIVALENT, Special function sealed ASCII keyboard & USB port	
3.6	Pulse peak current	24 steps (Min)	
3.7	Pulse ON time	32 steps (Min)	
3.8	Pulse OFF Time	64 steps (Min)	
3.9	Servo System & Closed Loop type	Close loop A.C or D.C servo system with encoder feedback. ; X,Y,U ,V axes with Servo Drive	
3.10	CNC Controller	Siemens 810D or EMT100W-5 or FANUC (Latest Version)	
3.11	Monitor type	Colour 15" LCD monitor	

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION	VENDOR'S OFFER [with Complete Technical Details]
4.0	CNC FUNCTIONS		
4.1	NC Operational Functions desired to be provided	a. 6 work co-ordinate b. Auto reference c. Auto wire verticality d. Edge & centre finding e. On line edit facility f. Rotation of program, mirror image of programme g. Backlash and pitch error compensation h. Wire Diameter compensation and corner control for accuracy. i. Pre-spark & no man function j. Auto alignment of the work piece k. 3 point centre finding l. Monitoring of consumables m. On screen maintenance Check	
4.2	Part Programming Software Features	a. Windows based editor b. Power full path generation c. Function such as move, rotate, copy, mirror, scale d. Icon based tool bars e. Multi-cut programme generation. f. Programming CAD Tools g. 3D graphic simulation of complex profiles h. Taper or offset change i. DXF interface j. Program generation for coreless machining	
4.3	Programs suitable for the Job Materials listed	Inconel, Nimonic, Niobium, Titanium, High Alloy Steels, Copper, Tungsten, Aluminium Alloys, etc.	

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION	VENDOR'S OFFER [with Complete Technical Details]
4.0	CNC FUNCTIONS		
4.4	Control Features	To compulsorily have the following facilities : a) shall be user friendly b) back edit facility c) move, rotate, copy, mirror, scale, reverse mirror etc., d) rotation of programmed by 90 deg. e) Trim cut facility f) Built-in utility packages for gears and curves etc	
5.0	DIELECTRIC UNIT		
5.1	Dielectric Fluid	Deionised Water	
5.2	Dielectric Tank Capacity	1000 ltrs. (minimum.)	
5.3	Cooling System Capacity	2000 kcal (minimum.)	
5.4	Filtration	Mineral bed as a standard scope	
5.5	Dielectric Maintenance	a) Dielectric shall have Automatic deionising, filtration and flushing through separate pumps. b) Automation of Dielectric conductivity monitoring. c) Dielectric Cooling unit with temperature control.	[BIDDER to give complete technical details to meet the requirements.]
5.6	Tank Construction	a. Dielectric unit shall be Stainless Steel Construction. b. All the piping and filters valves shall be of SS	
6.0	ACCURACIES		
6.1	Repeatability	< 5 micron	
6.2	Position Accuracy	< 5 micron	
6.3	Circularity	< 6 micron	
6.4	Alignment Checks	Machine Geometrical Checks as per IMTMA-8 - 1989 chart	
6.5	Positioning accuracies	As per IMTMA-81989 Chart based on ISO 230 Part I&II detail test chart to be furnished	

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION	VENDOR'S OFFER [with Complete Technical Details]
7.0	ACCESSORIES		
7.1	Essential Accessories	The following shall be offered :- 1) Wire Guides for 0.25 mm, 0.15 and 0.2 mm dia. 2) Vertical Block, 3) Flushing Nozzles, 4) set of current pickup carbides, 5) ion exchange resin 6) standard job holders.	
8.0	ISOLATION TRANSFORMER		
8.1	Model	--	Double Wound, Isolation Transformer
8.2	Type and Cooling		Closed, Dry Type Vacuum Pressure Impregnated (VPI) Transformer, Natural Air Cooled.
8.3	Phases	No.	3 Phases
8.4	Rated Capacity	kVA	60 kVA or 20% more than the power rating of the suggested model whichever is HIGHER.
8.5	Voltage		
8.5.1	Input	V	415 ± 10%
8.5.2	Output	V	415 ± 10%
8.5.3	Tappings	V	Nil
8.6	Frequency	Hz	50 Hz ± 2 %

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION		VENDOR'S OFFER [with Complete Technical Details]
8.7	Vector Group		Dyn 11	
8.8	Insulation resistance			
8.8.1	Primary to Secondary	MΩ	> 1000	
8.8.2	Primary to Core	MΩ	> 1000	
8.8.3	Secondary to Core	MΩ	> 1000	
8.9	HV Test			
8.9.1	Primary to Secondary	kV rms	2.5 kV/ 1min	
8.9.2	Primary to Core	kV rms	2.5 kV/ 1min	
8.9.3	Secondary to Core	kV rms	2.5 kV/ 1min	
8.10	Core Material		CRGO Mitered Core M6 Grade	
8.11	Winding Material	Copper	99.9 % Electrolytic Grade Super Enamelled Class H insulation	
8.12	Noise Level – CMNR	dB	< 80 dB (Transients, Spikes & Surges)	
8.13	Coupling Capacitance	F	0.1 pF	
8.14	Leakage Current	A	< 20 μA	
8.15	Shielding		Aluminium foil Electrostatic Shield	
8.16	Temperature Rise		Ambient Temperature is 20 °C to 45°C	
8.17	Core (at No Load)	°C	70°C including ambient temperature	
8.18	Winding (at full load)	°C	< 115 °C over and above ambient temperature	

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION		VENDOR'S OFFER [with Complete Technical Details]
8.19	Losses			
8.19.1	No Load Losses	W	< 350 W	
8.19.2	Load Loss	W	< 1100 W	
8.20	Impedance Voltage	%	< 3.75 %	
8.21	Percentage Reactance	%	< 3.20 %	
8.22	Percentage Resistance	%	< 1.95 %	
8.23	Regulation			
8.23.1	@ 0.8 PF	%	< 3.35 %	
8.23.1	@ 1.0 PF	%	< 2.00 %	
8.24	Efficiency			
8.24.1	@ 100 % Load	%	➤ 97.55 %	
8.24.2	@ 75% Load	%	➤ 97.8 %	
8.25	Maximum Efficiency	%	Vendor to specify	
8.26	Load at Maximum	kVA	Vendor to specify (at peak efficiency)	
8.27	Terminal Arrangement	HV and LV	Termination Board with bolts and nuts	
8.28	Enclosure		Sheet Metal Enclosure IP 32 compliant	
8.29	General	a. Tolerances in all values are to be with respect to IS clauses b. Applicable reference standards are IS 2026 and IS 11171. c. Two years onsite warranty from the date the successful commissioning at BHEL, Trichy. d. Any spares that are required for first two years of operation is be quoted mandatorily		

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION		VENDOR'S OFFER [with Complete Technical Details]
9.0	SERVO STABILIZER			
9.1	Input Voltage range	V	360 V – 460 V	
9.2	Output Voltage	V	415 V ± 1%	
9.3	Rated Supply Frequency	Hz	50 Hz	
9.4	Reference Ambient Temperature	C	20 - 50° C	
9.5	Temperature Rise	C	< 110°C over and above the ambient temperature	
9.6	No load losses	W	< 500 W	
9.7	Full Load Losses	W	<1800 W	
9.8	Maximum Efficiency	%	> 97%	
9.9	Indication Meters			
9.10	Voltmeter	V	LCD display to read both input and output voltages	
9.11	Ammeter	A	LCD display to read output current	
9.12	Indications	--	Pilot LEDs for each Phase with indications for 3 Phase ON, Phase reversal, Overload, Menu, Start and Stop indications. In addition, all operational requirements for the suggested model should be made available on the indication panel.	

S. No.	PARTICULARS	SPECIFICATIONS/DESCRIPTION		VENDOR'S OFFER [with Complete Technical Details]
9.13	Voltage Sensing	No.	Voltage sensing transformers for each phase - 03 Nos.	
9.14	Power Rating	KVA	60 KVA or 20% more than the power rating of the suggested model whichever is HIGHER.	
9.15	Input MCCB		200 A 3 Pole MCCB of ABB/Schneider/L&T make only.	
9.16	Output Contactor	A	150 A, of ABB/Schneider/L&T make only.	
9.17	Input Changeover Switch		160 A 3 pole of reputed make	
9.18	Variac		35 A 1 PH – 03 Nos. The winding material is to be copper wound.	
9.19	Enclosure		Steel metal enclosure IP32 compliant	
9.20	General Requirements		1. Single Phase Inverter should be included. 2. Waveform Distortion: Nil 3. Detailed catalogue should be attached with the offer. 4. Two years onsite warranty from the date the successful commissioning at BHEL, Trichy. 5. The applicable standard for reference is IS 9815. 6. Any spares that are required for first two years of operation are to be quoted mandatorily.	

S. No	SPECIFICATIONS / DESCRIPTION		VENDOR'S OFFER / CONFIRMATION [with Complete Technical Details]
10.0	PNEUMATIC SYSTEM		
10.1	The pneumatic operated elements of the machine shall work efficiently with BHEL compressed air supply at a pressure of 4.5 to 5.0 kg/cm ² in ¾ inch line.	Bidder to Confirm	
10.2	If higher air pressure is required for efficient operation of the machine, Bidder shall furnish the information for Air Compressor/Booster of suitable capacity.	Bidder to Specify	
10.3	Bidder to Specify the total air volume required for efficient operation of the complete machine.	Bidder to Confirm	
10.4	Refrigerated Air Drier to be provided to eliminate moisture content from the compressed air at the designed flow and pressure rating.	Bidder to Confirm	
10.5	BHEL will provide compressed air at only one point near / on the machine. Bidder shall provide suitable filter-regulator-lubrication (FRL) unit and in addition a hand wheel valve at this point	Bidder to Confirm	
10.6	Hydraulic, Pneumatic & Lubricating oil piping should be preferably metallic except places where flexible piping is essential. All the pipes required for the same shall be included in the standard scope of the machine.	Bidder to Confirm	
10.7	Pneumatic components shall be of FESTO/SMC/PARKER.	Bidder to Specify	
11.0	ELECTRICAL & ELECTRONICS SYSTEMS		
11.1	415 V with a voltage fluctuation of +/- 10%, 50HZ with a fluctuation of +/-2%, 3 Phase AC (3 wire system without neutral) power supply will be provided by BHEL at a single point near the machine, as per layout recommended by Bidder. All cables, connections, circuit breakers etc. required for connecting BHEL's power supply to the machine shall be in the scope of Bidder.	Bidder to Confirm	
11.2	Tropicalization : All electrical / electronic equipment shall be tropicalized.	Bidder to Confirm	

S. No	SPECIFICATIONS / DESCRIPTION	VENDOR'S OFFER / CONFIRMATION [with Complete Technical Details]
11.3	Control circuit voltage shall not exceed 24V DC	Bidder to Confirm
11.4	All electrical components in the cabinets should be mounted on DIN Rail	Bidder to Confirm
11.5	All electrical and electronic panels including operator's panel should be provided with fluorescent lamps for sufficient illumination and power receptacles of 220Volts, 5/15 Amp AC. All adapters /receptacles should have compatibility with Indian equivalents.	Bidder to Confirm
11.6	All cables moving with traversing axes should be installed in Caterpillar / Drag chain. Additionally, all the cable trays required for laying of cables should be included in the offer.	Bidder to Confirm
11.7	Bidder should ensure the proper earthing for the machine and its peripherals.	Bidder to Confirm
11.8	Cables shall be routed through totally enclosed cable trays. There shall not be cable trenches.	Bidder to Confirm
11.9	All electrical & electronic control cabinets & panels should be vermin and dust proof. All Electric enclosures shall have IP 54 protection	Bidder to Confirm
11.10	Motors and drives shall be of Fanuc / Siemens / Allen Bradley / ABB / Indramat / SEW or any other reputed makes acceptable to BHEL conforming to IS / IEC Standards (Bidder should indicate make and type in the offer- Energy Efficient Motor)	Bidder to Confirm
11.11	All electrical items shall be of from SEW / ROCKWELL Allen Bradley/ Telemecanique/Siemens/L&T/ABB or reputed makes acceptable to BHEL.	Bidder to Confirm
11.12	All indication lamps should be provided with LED Indication Lamp.	Bidder to Confirm
11.13	All components/devices/terminals are to be incorporated with numbered ferrules.	Bidder to Confirm
11.14	External wiring from / to control panel, control desk, external motors etc shall be by means of screened multi-core cables.	Bidder to Confirm

S. No	SPECIFICATIONS / DESCRIPTION		VENDOR'S OFFER / CONFIRMATION [with Complete Technical Details]
11.15	All electrical motors, limit switches etc, on the machine shall be wired using PVC sheathed cable running in conduits and converging to common terminal block.	Bidder to Confirm	
11.16	All feedback systems & field sensors, limit switches, proximity switches, pressure switches, temperature controllers, should be for heavy duty application and wired up with flexible PVC insulated screened cables. All field elements shall have easy accessibility for maintenance.	Bidder to Confirm	
11.17	Air Conditioners with Dehumidifiers of suitable capacity to be provided for all Electrical / Electronic Panels / Cabinets including Operator's Panel considering specified ambient conditions. Make : Rittal / Warner & Finley or any other reputed make acceptable to BHEL. Detailed specifications are to be submitted with the offer.	Bidder to Specify	
12.0	MACHINE LIGHTS		
12.1	Machine Spot Lights and suitable fluorescent light or metal halide lamps to be provided for sufficient illumination in the machining zone.	Bidder to Confirm	
12.2	All light fittings, consumables, adapters/receptacles should have compatibility with Indian equivalents	Bidder to Confirm	
13.0	MACHINE FOUNDATION & DRAWING APPROVAL:		
13.1	GA drawings, Machine constructional drawings with dimensions, Civil Foundation layout drawings, Hydraulic / Pneumatic / Electrical / Electronic circuits with BOM, are to be submitted within 30 days from the date of ordering (in case of an order) for approval by BHEL.	Bidder to Confirm	
13.2	Bidder shall submit the preliminary layout drawing for getting BHEL's approval within one month from the date of Letter of Intent (LOI). Complete details like static and dynamic loads etc. required for foundation design shall be submitted by the Bidder within three months after getting BHEL's approval.	Bidder to Confirm	

S. No	SPECIFICATIONS / DESCRIPTION	VENDOR'S OFFER / CONFIRMATION [with Complete Technical Details]
13.3	BHEL shall design and construct complete foundation for the machine as per the Bidder's recommendation	Bidder to Confirm
13.4	Complete anchoring system including foundation bolts, anchoring materials, fixators, levelling shoes, chemical for anchoring etc should be supplied	Bidder to Specify
14.0	MACHINE SPARES	
14.1	List of spares with itemized break-up of mechanical, hydraulic, pneumatic, electrical and electronic spares used in the machine in sufficient quantity as per recommendation of Bidder for 2 years of trouble free operation on three shifts continuous running basis shall be furnished by Bidder along with offer. The list is to include following, in addition to other recommended spares: (Unit Price for each item of spare shall be offered)	Bidder to Confirm
14.2	Mechanical, Hydraulic, Pneumatic Spares: All types of Pumps, Valves, Pressure Switches, Transducers, Flow Switches, Filters, Seals, O-rings, Hydraulic Hoses, hoses, bearings, sprockets, chains etc.	Bidder to Confirm
14.3	Electrical / Electronic / PLC Spares: All types of Relays, Contactors, Proximity Switches, Push Buttons, Indicating Lamps, Semiconductor Fuses, Special Fuses, Circuit Breakers, Main Power Switch, Encoders, Spares for PLC, Servo Motors for Feed Drives, Power Module & Control Cards for Main Drive as well as Feed Drives etc.	Bidder to Confirm
14.4	A set of Service Tools for dismantling and assembling of machine components such as roller sets etc. may be quoted.	Bidder to Confirm
14.5	Bidder to Confirm that complete list of spares for machine and accessories, along with item part no / specification / type / model, and name & address of the spare supplier shall be furnished along with documentation to be supplied with the machine	Bidder to Confirm

S. No	SPECIFICATIONS / DESCRIPTION	VENDOR'S OFFER / CONFIRMATION [with Complete Technical Details]
15.0	DOCUMENTATION:	
15.1	The following documents in English language should be supplied along with the machine: Hard Copies - 3 Sets Bidder to Confirm In CD form - 1 Set 1. GA Drawing of the complete EDM 2. GA Drawing of Individual Mechanisms 3. GA & Sub-Assembly Drawings for sub-systems for maintenance purpose. 4. Operating manuals of Machine & its CNC System 5. Programming manuals of Machine & its CNC System 6. Maintenance manuals with all drawings of machine assemblies / sub-assemblies with parts list 7. All Electrical circuit diagrams with bill of materials 8. Pneumatic circuit diagrams with bill of materials 9. Maintenance & Interface manuals for Machine Control System 10. Preventive Maintenance check list for Electrical and Mechanical System 11. Trouble shooting chart for Main and all sub systems 12. Complete PCB Schematics indicating check points for Electronic controls. 13. Catalogues, O&M manuals for all bought out items used in the machine. 14. Operating Manuals, Maintenance Manuals & Catalogues for all supplied Accessories. 15. Detailed specification of all rubber items /pneumatic / lubrication fittings 16. CNC program print-outs with comments in English 17. CNC program and data on CD, Flash Memory Card. 18. Complete back up of hard disk on GHOST CD and clear written Instructions (3 copies) to take back up and reloading of a new hard disk. 19. Complete list of Alarm log, Error code, error messages & remedies and on line fault diagnostics to be provided by the Bidder. 20. Complete list of spares for machine, along with item part no /specification / type / model and make & address of the sub-vendors. 21. Anything else recommended by the OEM for an effective utilization of the equipment.	

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16.0	MACHINE PRE-DISPATCH INSPECTION & ACCEPTANCE AT SUPPLIER'S WORKS		
16.1	Complete EDM with all sub-systems and accessories shall be assembled and offered for inspection by BHEL Engineers at supplier's works.	Bidder to Confirm	
16.2	All systems of the machine have to be operated and demonstrated to the BHEL Engineers in proper working condition.	Bidder to Confirm	
16.3	Supplier has to establish parameters for carrying out wire cut machining of components based on the mutually agreed pattern of job sizes, number and the material specifications – all falling within the operating domain of the finalised machine specifications given with the BHEL Purchase Order. - Machine accuracy test chart shall accompany the quotation. - Machine inspection will be as per the test chart, which includes Geometrical, accuracy, repeatability and performance tests. Positional accuracy test will be carried out with the Laser interferometer at the supplier's site. - Standard test specimen drawing shall be enclosed along with the quotation and Standard Test Specimen need to be produced.	Bidder to Confirm	
16.4	The wire cut jobs taken for the machine capability prove-out are to be given to BHEL along with the machine consignment.	Bidder to Confirm	
17.0	PROVE-OUT AND ACCEPTANCE AT BHEL WORKS		
17.1	After the machine Erection is completed and Energizing the machine at BHEL works, all systems of the machine have to be operated and demonstrated in proper working condition.	Bidder to Confirm	
17.2	Supplier has to carry out the machine performance prove-out at BHEL Works also on the components based on the mutually agreed pattern of job sizes, number and the material specifications – all falling within the operating domain of the finalised machine specifications given with the BHEL Purchase Order.		

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17.3	a. Trial machining of components is to be based on the standard test drawing and pass the performance tests for ensuring the capability of the machine. b. Standard test specimen machining has to be done at BHEL Works. c. Positional accuracy tests have to be carried out with the VENDOR's Laser interferometer	
18.0	TRAINING	
18.1	The supplier shall train TWO BHEL Engineers in Operation and Maintenance (Mechanical, Electrical/ Electronics and Programming) of the Machine for a minimum period of FOUR working days at supplier's works after the pre-dispatch inspection.	Bidder to Confirm
18.2	Bidder to clearly mention whether the training is offered free of cost or chargeable. If chargeable, the Bidder has to quote on man-day basis.	Bidder to Specify
18.3	Airfare, board & lodging for the BHEL Engineers who will be visiting supplier's works for pre-dispatch inspection and training, will be borne by BHEL.	Bidder to note
18.4	The Supplier shall impart training to BHEL's Machine Operators and Maintenance crew in Operation and Maintenance (Mechanical, Electrical/ Electronics and PLC System) during commissioning of the Machine at BHEL works for FIVE working days.	Bidder to Confirm
18.5	The training shall include specialized coaching in i) Safety ii) Operation of the machine iii) PC based System & Operation, iv) Trouble-Shooting, v) Software Application vi) All special features of the machine vii) Electrical / Mechanical / Electronics systems	Bidder to Confirm

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19.0	ERECTION & COMMISSIONING		
19.1	Supplier to take full responsibility for Supervision and Skilled Labour for the erection and for startup, testing and commissioning of machine, its controls and accessories. Supplier shall send suitable qualified Engineers and Erection crew for the Erection and Commissioning at BHEL/TRICHY.	Bidder to Confirm	
19.2	Service requirement like power, air & water shall be provided by BHEL at only one point to be indicated by Bidder in their foundation/layout drawings. Other requirements like crane and helping personnel shall also be provided by BHEL.	Bidder to Confirm	
19.3	Successful proving of BHEL components by the Bidder shall be considered as part of commissioning. All tests, as mentioned (Machine Acceptance) shall form part of the commissioning activity.	Bidder to Confirm	
19.4	Commissioning spares, required for commissioning of the machine shall be supplied free of cost, by the Bidder / OEM.	Bidder to Confirm	
20.0	THERMAL STABILITY FOR AMBIENT CONDITIONS & ENVIRONMENTAL PERFORMANCE OF THE MACHINE		
20.1	The machine shall be suitable for an ambient temperature of +48 deg C and relative humidity of 85% respectively, but both do not occur at the same time / simultaneously.	Bidder to Confirm	
20.2	The Bidder should ensure trouble free operation of the machine with Thermal Stability of the complete machine and accuracy requirements of BHEL components, keeping in view of ambient conditions as mentioned above.	Bidder to Confirm	
20.3	The machine, including sub-systems, attachments and accessories, should be suitable for continuous operation on three shifts a day.	Bidder to Confirm	
20.4	If any safety / environmental protection enclosure is required it shall be built in the machine by the Bidder.	Bidder to Confirm	
20.5	Paint of the machine should be oil / coolant resistant and should not peel off – preferred to be polyurethane	Bidder to Confirm	
20.6	Maximum noise level shall be 80 dB (A) at normal load condition.	Bidder to Confirm	

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21.0	MACHINE PACKING		
21.1	Sea worthy & rigid packing for all items of complete machine, PLC System, all accessories and other supplied items to avoid any damage/loss in transit. When machine is dispatched in containers, all small loose items shall be suitably packed in boxes	Bidder to Confirm	
22.0	GUARANTEE		
22.1	Performance Guarantee to be given for 12 months from the date of commissioning OR 18 months from the date of dispatch whichever is earlier, for the total machine or any sub-systems, components forming part of the machine for rendering the prescribed performance / rating values.	Bidder to Confirm	
23.0	GENERAL POINTS		
23.1	Machine Model No.	Bidder to Specify	
23.2	Total connected load (KVA):	Bidder to Specify	
23.3	Total air volume in cu.m/min	Bidder to Specify	
23.4	Floor area required (Length, Width, Height) for complete machine & accessories	Bidder to Specify	
23.5	Total weight of the machine (approx)	Bidder to Specify	
23.6	The general arrangement drawing showing the machine & associated systems with salient dimensions shall be submitted along with the offer. The drawing should be clear and legible	Bidder to provide compulsorily	
24.0	ANNUAL MAINTENANCE CONTRACT (AMC)		
24.1	It is envisaged that the supplier has to offer the after sales maintenance of the machine for a period of THREE years (comprehensive maintenance) after the guarantee period of one year. The cost for the AMC shall be quoted year wise for three years after the warranty period. The AMC cost will also be considered for evaluation of the bid.		