



ISO 9001:2008, 14001:2004,  
50001:2011 & OHSAS 18000  
MAHARATNA COMPANY

**MATERIAL MANAGEMENT (PURCHASE)**  
**CENTRAL FOUNDRY FORGE PLANT, BHEL HARDWAR**  
RANIPUR, HARIDWAR (INDIA) - 249403  
Phone No. +91-1334-281277/281299, FAX No. 225892  
e-mail : [vinaysingh@bhel.in](mailto:vinaysingh@bhel.in); [anuragkk@bhel.in](mailto:anuragkk@bhel.in)

**Sub: Tender Enquiry for Spare for Milling Cutter**

Dear Sir,  
We are pleased to invite offer in **E-Tender** as per enclosed specifications & terms and conditions for the under mentioned items.

| SI No | Tender No                        | Description of Material                                                                                                                           | Qty    | Date & Time Of Opening  |
|-------|----------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------|--------|-------------------------|
| 01    | 201902071,<br>Event ID:<br>32743 | Material Code: FF6289989014<br>SPARE FOR MILLING CUTTER AS PER SPECIFICATION NO. AA6289902<br>R02.SIZE: AXIAL SUPPORT RH-73 084 718<br>DIM.: S    | 300 No | 24.08.2019<br>(2.00 PM) |
| 02    |                                  | Material Code: FF6289990039<br>SPARE FOR MILLING CUTTER AS PER SPECIFICATION NO. AA6289902<br>R02.SIZE: WEDGE FOR INSERT RH 73 084 724<br>DIM.: S | 500 No |                         |

**Delivery Schedule: 90 days from PO date, early delivery is acceptable.**  
**Offer to be submitted in compliance with Specification & PQC.**

**For New Vendor who are not registered with CFFP:**

New Vendor who are not registered with CFFP are required to fill the Supplier Registration Form (SRF). The SRF can be filled online through <https://supplier.bhel.in/>. Please ensure to fill the SRF and it is requested to submit the Acknowledgement No./ Application no. of filled SRF along with the offer. Kindly read terms and conditions, offer not in accordance with the instructions is liable to be disqualified or ignored.

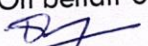
Please send the following along with the Offer:

1. Company Name and Address Proof.
  2. GST Number (Scan Copy of Acknowledgement)
  3. PAN Copy
  4. MSME Certificate (if Any)
- All the above documents should be signed and stamped.

Please visit <https://bhel.abcprocure.com/EPROC/>; [www.bhel.com](http://www.bhel.com) or [www.bhelhwr.co.in](http://www.bhelhwr.co.in) for more details & corrigendum if any for the tender enquiry. **Offers are to be submitted online in E-tender portal at <https://bhel.abcprocure.com/EPROC/>**

**Offer to be submitted only on e-procurement portal. Hard copy of offer is not required to be submitted to CFFP. Any offers received in Hard copy shall not be accepted and straightaway rejected by CFFP.** Before proceeding for submitting quotation in e-portal, supplier to ensure that they are having a valid Digital Signature Certificate (DSC). Valid DSC refers to an Active Signing and Encryption Certificate (both), with specification Class III SHA2 2048 bit

Thanking You,  
Yours Faithfully,  
For & On behalf of CFFP, BHEL, Hardwar

  
(Vinay K Singh)  
Sr. Engineer (Purchase)

**Note:** Corrigendum if any shall not be published, kindly refer <https://bhel.abcprocure.com/EPROC/> for any changes.



**ANNEXURE'A' 'REV 01'**

**ITEM:-SPARES FOR MILLING CUTTER**

| POINT NO. | BHEL REQUIREMENT                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
|-----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1         | NO PQC REQUIRED.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
| 2         | VENDORS NEED TO SUBMIT MINIMUM 2 NOS.OF SAMPLES OF EACH ITEM AS PER TENDER ENQUIRY, ALONG WITH OFFER . VENDORS FAILING TO SUBMIT SAMPLES ALONG WITH OFFER, WILL NOT BE CONSIDERED TECHNICALLY SUITABLE. SUBMITTED SAMPLES SHOULD BE IN LINE WITH ATTACHED SPECIFICATION NO. AA6289902                                                                                                                                                                                                                                         |
| 3         | VENDORS WHO HAVE EARLIER SUPPLIED TENDER ENQUIRY ITEMS TO BHEL CFFP AND SUPLIED ITEMS BEING ACCEPTED; NEED NOT TO SUBMIT ANY SAMPLES.                                                                                                                                                                                                                                                                                                                                                                                         |
| 4         | ACCEPTANCE CRITERIA:- ITEM NO. 1,2 WILL BE MOUNTED ON CUTTER STYLE AS PER DETAILS SPECIFIED AT PAGE NO. 3-4 OF CORPORATE STANDARD AA6289902 IN CONJUNCTION WITH OTHER SPECIFIED SPARES AS PER CORPORATE STANDARD. OFFERED ITEM SHOULD ALLOW PROPER FITMENT OF INSERTS IN CUTTER POCKETS TO BE USED WITH OTHER SPECIFIED CUTTER SPARES SUCH THAT ALL INSERTS ARE UNIFORMLY CLAMPED SUITABLE FOR SMOOTH MACHINING. FAILING OF ITEM TO SUPPORT PROPER CLAMPING OF INSERT IN CUTTER POCKET WILL LEAD TO REJECTION OF OFFERED ITEM |

3

|                                                                                   |                           |  |             |
|-----------------------------------------------------------------------------------|---------------------------|--|-------------|
|  | <b>CORPORATE STANDARD</b> |  | AA6289902   |
|                                                                                   |                           |  | Rev. No. 02 |
|                                                                                   |                           |  | PAGE 1 of 5 |

## SPARES FOR MILLING CUTTERS (INDEXIBLE) OF M/S WIDIA

### 1 SCOPE

This standard covers the dimensions and other details of spares for milling cutters (Indexible) of M/S Wide

### 2 DESIGNATION

An axial support RH for inserts having catalogue No. 73.084-710 of M/S Wide shall be designed as

#### 2.1 On indents

Axial support RH 73.084-710 - AA6289902

#### 2.2 For issuing enquiries and on purchase orders

Delete BHEL standard number from the above designation and add the Information given under clause 3.

#### 2.3 Abbreviated Description

AXL SUPPORT RH 73.084-710.

### 3 COMPLIANCE WITH STANDARDS

#### 3.1 Marking and Packing

Appropriate spare part No. shall be marked and suitably packed in the containers

### 4 NOTE

Refer BHEL standard No. AA62899 01 for spares of M/S Sandvik milling cutters (Indexible type)

### 5 REFERRED STANDARDS (Latest Publications Including Amendments)

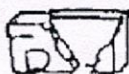
- 1) AA6289901

|                                                                                                         |          |            |                                                                                |                     |                                            |
|---------------------------------------------------------------------------------------------------------|----------|------------|--------------------------------------------------------------------------------|---------------------|--------------------------------------------|
| Revisions: As per clause 32.6.38 of MOM of MRC-Tools Reinstated as per HEP – Bhopal request dt.06.05.16 |          |            | <b>APPROVED:</b><br>INTERPLANT MATERIAL RATIONALISATION<br>COMMITTEE – MRC (T) |                     |                                            |
| Rev. No. 02                                                                                             | Amd. No. | Reaffirmed | Prepared<br>HEP, Bhopal                                                        | Issued<br>Corp. R&D | Dt. of 1 <sup>st</sup> Issue<br>01-06-1987 |
| Dt: 15-12-2005                                                                                          | Dt:      | Year: 2017 |                                                                                |                     |                                            |

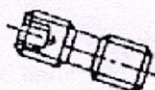
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DRC-RA5081

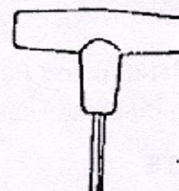
## CORPORATE STANDARD

SPARES FOR SQUARE SHOULDER AND FACE MILLING CUTTERS (M20)  
(SHELL TYPE)Grub screw  
73 085 964Anvil  
73 084 765Clamp screw  
73 085 739Retaining screw  
73 498 687Allen key  
73 386 122

## SPARES FOR SQUARE SHOULDER AND FACE MILLING CUTTERS (M40)

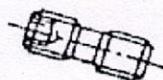
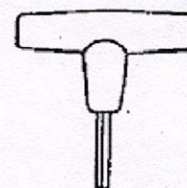
AXIAL  
SUPORTWEDGE FOR  
AXIAL SUPPORTWEDGE FOR  
INSERT

WEDGE SCREW



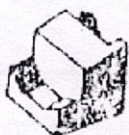
ALLEN KEY

## SPARES FOR HIGH-SHEAR FACE MILLING CUTTERS (M60)

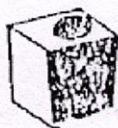
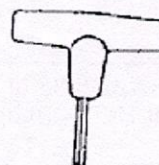
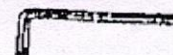
Axial  
supportwedge for  
axial supportwedge for  
insertwedge  
screw

Allen key

## SPARES FOR FULLS &amp; HALF SIDE AND FACE MILLING CUTTERS (M90)L

AXIAL SUPPORT  
RHT/L

SET SCREW

WEDGE  
RHT/LHWEDGE  
SCREWALLEN KEY FOR  
WEDGE SCREWALLEN KEY FOR  
SET SCREW



## CORPORATE STANDARD

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| NAME OF<br>SPARE PARTS                | CATALOGUE<br>REF.NO. | MILLING CUTTER<br>STYLE NO. | SUB-CODE |
|---------------------------------------|----------------------|-----------------------------|----------|
| 1                                     | 2                    | 3                           | 4        |
| AXIAL<br>SUPPORT<br>FOR INSETS<br>-RH | 73.084-704           | M40- P16                    | 016      |
|                                       | 73.084-706           | M40-TP22                    | 024      |
|                                       | 73.084-708           | M40- SP12                   | 032      |
|                                       | 73.084-710           | M40 -SP15                   | 040      |
|                                       | 73.084-716           | M60-TP16                    | 059      |
|                                       | 73.084-718           | M60-TP22                    | 067      |
|                                       | 73.084-774           | M90-TP11                    | 083      |
|                                       | 73.084-776           | M90-TP16                    | 091      |
|                                       | 73.331-328           | MP90-TP22                   | 105      |
| ANVIL                                 | 73.084-765           | MP20-TP16                   | 334      |
| AXIAL SUPPORT<br>FOR INSERTS<br>-LH   | 73.084-775           | MP90-TP11                   | 113      |
|                                       | 73.084-777           | MP90-TP16                   | 121      |
|                                       | 73.331-329           | MP90-TP22                   | 130      |
| WEDGE-RH                              | 73.084-778           | MP90-TP11                   | 148      |
|                                       | 73.084-780           | MP90-TP16                   | 156      |
|                                       | 73.331-180           | MP90-TP22                   | 342      |
| CLAMP                                 | 73.084-767           | M20-TP16                    | 350      |
| WEDGE - LH                            | 73.084-799           | MP90-TP11                   | 164      |
|                                       | 73.084-781           | MP90-TP16                   | 172      |
|                                       | 73.331.181           | MP90-TP22                   | 369      |
| WEDGE<br>FOR AXIAL SUPPORT            | 73.087-734           | M40-SP12                    | 180      |
|                                       |                      | M40-SP15                    |          |
|                                       |                      | M40-TP16                    |          |
|                                       |                      | M40-TP22                    |          |
|                                       | 73.084-738           | M60-TP16                    | 199      |
|                                       |                      | M60-TP22                    |          |

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| 1                             | 2          | 3          | 4        |     |
|-------------------------------|------------|------------|----------|-----|
| WEDGE FOR INSERTS             | 73.084-724 | M40- P16   | 202      |     |
|                               |            | M40-TP22   |          |     |
|                               | 73.84-726  | M40- SP12  | 210      |     |
|                               |            | M40 -SP15  |          |     |
|                               | 73.084-730 | M60-TP16   | 229      |     |
|                               | 73.084-186 | M60-TP22   | 237      |     |
|                               | 73.085-740 | M40-SP12   | 253      |     |
|                               |            | M40-SP15   |          |     |
|                               |            | M40-TP16   |          |     |
| ANVIL                         |            | M40-TP22   |          |     |
| AXIAL SUPPORT FOR INSERTS -LH |            | M60-TP16   |          |     |
|                               |            | M60-TP22   |          |     |
|                               |            | M90-TP16   |          |     |
| WEDGE-RH                      |            | M90-TP22   |          |     |
|                               |            | 73.085-741 | M90-TP11 | 263 |
|                               |            | 73.085-739 | M20-TP16 | 377 |
| CLAMP                         | 73.398-931 | M40-SP12   | 270      |     |
| WEDGE - LH                    |            | M40-TP15   |          |     |
|                               |            | M40-TP16   |          |     |
|                               |            | M40-TP22   |          |     |
|                               |            | M40-TP16   |          |     |
| WEDGE FOR AXIAL SUPPORT       |            | M60-SP22   |          |     |
|                               |            | M90-TP16   |          |     |
|                               |            | M90-TP22   |          |     |
|                               |            | 73.398-939 | M90-TP11 | 288 |
|                               | 73.498-687 | M20-TP16   | 385      |     |



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| 1                               | 2          | 3        | 4   |
|---------------------------------|------------|----------|-----|
| SET SCREWS                      | 73.085-742 | M90-TP16 | 296 |
|                                 |            | M90-TP22 |     |
|                                 | 73.085-743 | M90-TP11 | 300 |
|                                 | 73.085-964 | M20-TP16 | 393 |
| ALLEN KEYS<br>FOR SET<br>SCREWS | 73.398-917 | M90-TP16 | 318 |
|                                 |            | M90-TP22 |     |
|                                 | 73.3980938 | M90-TP11 | 326 |
|                                 | 73.386-122 | M90-TP16 | 407 |

### Note

- 1) Details of sizes Standardized at Corporate level only are shown in the table.
- 2) Corporate sub codes only are given in the table.
- 3) For complete corporate and plant codes refer code catalogue issued by the plant.