



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

MATERIAL MANAGEMENT (PURCHASE)
CENTRAL FOUNDRY FORGE PLANT, BHEL HARDWAR
RANIPUR, HARIDWAR (INDIA) – 249403
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Sub: Tender Enquiry 201902201, Event ID: 34727 for Inserts

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	Delivery Schedule	
					Indigenous Vendor (FOR Delivery)	Foreign Vendor (FOB Delivery)
01	201902201, Event ID: 34727	Material Code: FF6267394026, INSERT SNMM 250724 GRADE: P40 FOR ROUGHING APPLICATION. N.STD: ISO STANDARD SIZE: SNMM 250724, GRADE: P40, DIM.: S	1800 No.	09/10/2019 at 2.00 PM	60 days from PO date	30 days from PO/LC date, whichever is earlier
02		Material Code: FF7158000419 INSERT SPAN 1504 EDR GRADE P40 CVD COATED. N.STD: ISO STANDARD	3500 No		1 st Lot: 30 days from PO date. 2 nd Lot: 60 days from PO date	1 st Lot: 15 days from PO/LC date, whichever is earlier. 2 nd Lot: 30 days from PO/LC date, whichever is earlier.
03		Material Code: FF7158000486 TPAN 22 T3AER P-40, INSERT CVD COATED. N.STD: ISO STANDARD	1000 No		1 st Lot: 30 days from PO date. 2 nd Lot: 60 days from PO date	1 st Lot: 15 days from PO/LC date, whichever is earlier. 2 nd Lot: 30 days from PO/LC date, whichever is earlier.
04		Material Code: FF6287394013 MILLING INSERT SDMT 1506 PDR-MH TN 7525 SIZE: TN 7525	1500 No		60 days from PO date	30 days from PO/LC date, whichever is earlier
05		Material Code: FF7158000885 INSERT SNMG 190612. SIZE: GRADE P30, DIM.: S	100 No		90 days from PO date	60 days from PO/LC date, whichever is earlier

Early delivery is acceptable.

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.

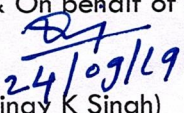
Please visit <https://bhel.abcpurchase.com/EPROC/>; www.bhel.com or www.bhelhwr.co.in for more details & corrigendum if any for the tender enquiry. **Offers are to be submitted online in E-tender portal at <https://bhel.abcpurchase.com/EPROC/>**

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.abcpurchase.com/EPROC/> for any changes.

Pre- Qualifying Conditions:-

SL.NO.	REQUIREMENT TO BE COMPLIED	
1	Only those vendors to quote who are Original tool manufacturer(OEM) or authorized dealer/distributor of Original Tool manufacturer. Authorization certificate from Original Tool manufacturer to be furnished by the vendor with the offer, in case the vendor is dealer/distributor/channel partner of Original Tool manufacturer.	VENDOR TO CONFIRM AND SUBMIT NECESSARY DOCUMENTS
2	Vendor should be competent to supply offered items against tender requirement.	VENDOR TO NOTE
3	BHEL reserves the right to verify the information provided by vendor. In case the information provided by vendor is found to be false/ incorrect, the offer shall be rejected.	VENDOR TO NOTE

ITEM:- INSERTS

POINT NO.	REQUIREMENT TO BE COMPLIED			VENDOR TO NOTE
1	The vendor to offer inserts for rough machining operation without coolant (Dry machining) with item acceptance criteria as specified at point no. 4.			VENDOR TO NOTE
2	Quantity as per following details:-			
	ITEM NO.	ITEM PARTS DETAIL	Qty.(Nos)	VENDOR TO NOTE
	1	SNMM 250724 grade P40 for roughing operation	1800	VENDOR TO NOTE
	2	SPAN 1504 EDR GRADE P40 PVD COATED	3500	VENDOR TO NOTE
	3	TPAN 22T3AER P40 CVD Coated	1000	VENDOR TO NOTE
	4	Milling insert SDMT 1506 PDR-MH	1500	VENDOR TO NOTE
	5	SNMG 190612 Grade P30	100	VENDOR TO NOTE
3	Vendor to submit offer in line with requirement along with samples(minimum 10 nos.each) for item no. 2,3,4 and minimum 2 Nos. each for item no. 1,5. Vendors failing to provide sample will be considered technically not suitable. Supplied sample should be same as per item offered in technical bid. However, vendors who have supplied required item to BHEL CFFP HARIDWAR in past and item being accepted; need not to submit samples.			VENDOR TO NOTE
4	Vendor may also visit machine shop, CFFP, BHEL before bid submission for their understanding of Jobs and facility available. Vendor's sample will be tested in Machine Shop, CFFP on conventional Plano Milling Machine with ISO-60 Taper(for item no. 2,3,4) with Cutter Widia Make of 160mm Diameter. Sample trial will be done at following Parameters for item no. 2,3,4:- Table Feed—60-90 mm/min RPM- 80-100 Rev/Min Depth of cut- 5-7 mm At parameters as mentioned above, Minimum Insert life- 4 hours continuously with single cutting edge needs to be obtained for technical acceptance. Vendor's whose sample performance achieves minimum life as mentioned above, at specified parameters; will be considered technically qualified. Trial Will be done On Alloy Steel Casting with following Details:- Chemical Composition(in %):- C-0.15-0.2; Si ≤ 0.6; Mn- 0.5-0.9; S ≤ 0.015; P ≤ 0.02; Mo- 0.9-1.1; Cr- 1.2-1.5; Ni ≤ 0.7; V 0.2-0.3; Cu ≤ 0.3; Al ≤ 0.04; Ti ≤ 0.025; Sb ≤ 0.01; Sn ≤ 0.025 Mechanical Properties:- 0.2% Yield Strength-440 N/mm²; Tensile Strength-590-780 N/mm²; Elongation(=5d)%(min)-15; Reduction in area%(min)-40; Impact energy J(min)-27. For item no. 1,5; Vendor's sample will be tested on conventional Lathe Machine with tool Post supporting 50x50X300 MM shank tool Holder. Sample trial will be done at following Parameters:- Feed—0.75-1 mm/rev cutting speed- 35-50 Mtr/Min Depth of cut- 7-10 mm At parameters as mentioned above, Minimum insert life- 4 hours continuously with single cutting edge needs to be obtained for technical acceptance. Vendor's whose sample performance achieves minimum life as mentioned above, at specified parameters; will be considered technically qualified. Trial Will be done On En24 Alloy Steel Forging(for item no. 1,5).			VENDOR TO NOTE
5	No payment will be made to vendor for Sample insert. Vendor to submit samples along with bid without any financial implication to BHEL			VENDOR TO NOTE
6	Offered Item should be suitably designed to withstand rough machining operations as Jobs to be machined may have black surface, hard spots, sand inclusion, cracks etc and may be subjected to interrupted cutting & sudden impact loading during operation .			VENDOR TO NOTE
7	Vendor to provide Guarantee Certificate with minimum guaranty period of 12 months.			VENDOR TO NOTE