

ITEM:- SPAN 1504 EDR GARDE P40 PVD COATED

POINT NO.	REQUIREMENT TO BE COMPLIED		
1	The vendor to offer insert SPAN 1504 EDR Grade P40 PVD Coated for rough milling operation without coolant (Dry machining) on Jobs(Alloy Steel Castings with max Hardness 304 BHN) with item acceptance criteria as specified at point no. 4.		
2	Quantity as per following details:-		
	ITEM NO.	ITEM PARTS DETAIL	Qty.
	1	SPAN 1504 EDR GRADE P40 PVD COATED	4000 Nos.
3	Vendor to submit offer in line with requirement along with sample(minimum 10 nos.) . 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.		
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 and Cutter Widia Make of 160mm Diameter. Sample trial will be done at following Parameters:- 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 with single cutting edge needs to obtained for technical acceptance. Vendor's whose sample performance achieves minimum life as mentioned above, at specified parammmeters; 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(l=5d)%(min)-15; Reduction in area%(min)-40; Impact energy J(min)-27.		
5	No payment will be made to vendor for Sample insert. Vendor to submit samples along with bid without any financial implication to BHEL		
6	Offered Item should be suitably designed to withstand milling operations as Jobs(Alloy Steel Castings with max Hardness 304 BHN)) 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 .		
7	Vendor to provide Guarantee Certificate with minimum guaranty period of 12 months.		