

PSGSG/1 6-17/02	Product Specifications For Support Structure Assembly		Drg. No.	RD DG 4 35 0617 0080 RD DG 4 35 0617 0081 RD DG 4 35 0617 0082
			Date	26.11.16
			Product	GSM 420
1.0	Application : The MS Support Structure Assemblies pertaining to Drawing. No. RD DG 4 35 0617 0080, RD DG 4 35 0617 0081, RD DG 4 35 0617 0082 are used for supporting various GIS Modules. The Support Structure Assembly shall meet following Specifications.			
2.0	Drawings : Strucrure1: RD DG435 0617 0080 Structure2: RD DG435 0617 0081 Structure3: RD DG435 0617 0082			
3.0	SPECIFICATIONS:			
3.1	Material: Mild Steal Preferably Vizag Steel, Tata Steel, Jindal Steel.			
3.2	Standard seamless C Channel (ISMC 125X65), Angles (ISMA 40X40X5), Rods and Plate shall be used for fabrication as per drawings			
3.3	The welded sections shall be sized as per technique at all stages of welding. Inside edges/weld shall be fused to obtain near smooth weld surface.			
3.4	Component shall be sand blasted and powder coated (>80 microns, Green Color-shade RAL 6032)			
3.5	The dimensional checks carried out in presence of BHEL inspector. Supplier has to approve at least one sample of each kind from BHEL inspector for further manufacturing.			
3.6	The accepted component shall be packed with suitable PVC covers. Material shall not be accepted without covering.			
3.7	All Supplied items to be provided with warranty for 12 months from the date of dispatch.			
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3.6	Following certificates shall be furnished for acceptance of the component: 3.6.1 Material source certificate, 3.6.2 Material test certificate , 3.6.3 Sandblasting and powder coating schedule, 3.6.4 Warranty certificate A certified copy of above documents shall be sent along with the delivery		
4.0	The components shall be guaranteed against all manufacturing defects.		
5.0	In case of doubts in specifications, the supplier shall contact BHEL for clarifications.		
6.0	Qualification requirements: Supplier should have executed at least two jobs of similar nature in the past three years. Necessary references shall be submitted along with offer.		
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