

	<u>BHARAT HEAVY ELECTRICALS LIMITED</u> Heavy Power Equipment Plant, Ramachandrapuram		Enquiry No. :	
			Due Date :	
	Hyderabad – 502 032. INDIA Phone: 2318 2250/23020173		Supplier Qtn. No.:	
	Fax:: 040-2318 6173 E-mail: burre@bhelhyd.co.in		Date :	
ADDRESS OF THE SUPPLIER :				
TELEPHONE NOS.:				
FAX NOS.:				
E-MAIL ADDRESS :				
Sl. No.	Description for BHEL Requirement	Offered	Deviations	Remarks
1.0	Scope: supply, Erection & Commissioning of Automatic horizontal Band saw cutting machine			
2.0	Technical requirements			
2.1	Cutting Capacity: For jobs of sizes from 50mm to 350. This also includes other sizes covering this range			
2.2	Cutting speed: 20 to 100 meters/minute			
2.3	Saw motor: 7.5 HP (Minimum)			
2.4	Hydraulic Motor 2.0 HP (Minimum)			
2.5	Coolant tank with 140 Ltr (Minimum capacity) and shall be powered by a Coolant motor of 0.12 HP (Minimum)			
2.6	Machine shall have the Autosequencing operation with PLC			
2.7	Input supply: 415V +/-10%, 3Phase. 50Hz			

2.8	Machine shall have the following automatic hydraulically operated functions			
2.8.1	Cutting feed and rapid reverse of cutting arm			
2.8.2	Automatic clamping of jobs before cutting arm starts moving down for cutting			
2.8.3	Carrier vice release and clamps as the cycle is set and synchronized with length indexing table			
2.8.4	The machine shall stop automatically whenever the blade fails			
2.9	A part from fully automatic cycle, manual operational mode shall also be provided to facilitate initial setting and also using the machine in case of failure of PLC operation			
2.10	Overall machine dimensions: Overall machine dimensions shall not exceed the following size limits: Length = 3000mm (max): Width = 2500mm (max); Height = 2500mm (Max)			
3.0	Features: The machine shall have the following features			
3.1	Auto height adjustment for Saw frame			
3.2	Cutting head up-down movement shall be guided in vertical pair of Linear Motion Bearing for jerk free movement			
3.3	Feed control valve			
3.4	Electronically Automatic feed regulation			
3.5	Machine shall have cleaning wire brush rotated through Power driven V-belt mechanism.			
3.6	Hydraulic blade tensioning system			

3.7	Machine shall have Hydraulically operated Main and shuttle vice			
3.8	Auto indexing shuttle of stroke length of 450mm and synchronized with auto cycle			
3.9	Auto height stop on return stroke of cutting arm			
3.10	Cutting feed and upward-return movement shall be controlled by infinitely variable pressure controlled Hydraulic cylinders			
4.0	Contruactional features: The Machine shall have the following constructional features			
4.1	Heavy duty welded structure free of torsional stresses			
4.2	Electrical control panel with push button. Emergency stop button, main isolator, PLC, auxiliary contractor, cable connector and connector with fuses for solenoid coil to protect PLC			
4.3	Driver assembly with A.C.V.F.D			
4.4	Hydraulic bundle cutting attachment (Bundle hight range+50mm to 350mm). Small variations in bundle hight range can be considered depending upon suitability for BHEL requirements.			
4.5	Automatic removal of chips from the machine by a screw conveyor			
4.6	Roller table floating shuttle vice			
4.7	Column protection sleeves			

5.0	Additional requirements: Machine shall be supplied alongwith the following accessories/ spares/documents as mentioned below			
5.1	Hand lubrication pump			
5.2	Bimetallic blades – 10 Nos (of size: 4640mm X 41mm X1.3mm & 3 TO 4 teeth per inch) suitable for cutting alloy and stainless steel materials having hardness upto 42 HRC.			
5.3	Standard power cable of minimum 10 m length			
5.4	5 sets of operation & maintenance manuals along with electrical circuit drawings in hard copies and 3 CD's/DVD's of the same shall also be provided			
5.5	List of recommended spares (with break up of prices) shall be submitted which should be sufficient for two years of operation of the machine			
5.6	Supplier shall also submit the standard spare parts list alongwith their codification numbers and component drawings for future ease of procurement by BHEL			
6.0	Operators controls shall be provided at easily			
	Accessible location.			
7.0	Safety features shall be provided to prevent damages during job loading, Hydraulic failure, Power failure, Blade failure and Over load Protection.			

8.0	Qualification requirements: The supplier shall submit the following documents/evidences as a proof of their capability to manufacture and supply the band saw as per this specification			
8.1	The manufacturer of the machine shall have minimum five years of experience in the manufacture and supply of similar machines. Relevant evidences shall be submitted for same by the supplier.			
8.2	The model quoted by the supplier shall be a proven one and minimum two machines of the same model shall be working at their customers works from the past two years. Documentary evidence for the same shall be submitted along with the offer. The contact persons name and telephone number alongwith the email id of such customer shall also be informed to BHEL.			
8.3	The offers submitted by the manufacturers only will be accepted. The offers from the traders or intermediateries will not be considered.			
9.0	Supplier shall give the details of Local dealer/service engineers details along with quotation.			
10.00	Two BHEL engineers will inspect the equipment at suppliers works before dispatch. During pre-inspection proper training shall be given for BHEL engineers at suppliers works.			
11.0	Commissioning and Prove out of the equipment at BHEL works is supplier's responsibility. During proveout supplier service engineers will be required to prove the operations of the machine minimum two days under continous operation			
12.0	The quotation shall contain Point to point detail explanation for every point mentioned in this specification 'A' comparative statement clearly indicating conformance/non conformance shall also be included.			

13.0	The supplier shall explain in detail how the after sales service will be organized. Time taken for service engineers to reach the site upon receipt of breakdown call shall be indicated and assured.			
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