

[illegible]

## ANNEXURE – II

PI.NO.220240094

## Job Description -Machining of Discharge Ring

Qty- 01

Job Specification:

Fabricated Assy. Weight- 17940 KG

Diameter- 4980 mm

Height- 832

## SCOPE OF WORK:

- Fabricated pivot ring will be issued by BHEL Bhopal. To and Fro transportation is in the scope of vendor.
- Stage 1- First stage machining to be done as per detail shown as Stage1 in the attached drawing. (1st stage machining before fixing of Liner plate and SS Lining, Drawing Zone F-10). All Diameter to be made as per drawing. Top and bottom faces to be machined as per drawing. Flange face to be machined as per drawing. Height to be maintained as per drawing. Drilling is not in the scope of vendor.
- Any checking gauge/measuring gauge will be arranged by supplier.
- Inspection and other conditions i.e transporting, payment etc. as per BHEL practice.
- After inspection only rust preventive to be applied on machined surface only. Final painting will be done at BHEL works.

हर्षल त्रिवेदी / HARSHAL TRIVEDI  
 उप प्रबंधक / Dy. Manager  
 जल टांकरी विभाग / Water Tank Division  
 बी.एच.ई.ए.सी., भोपाल / BHEL, BHOPAL

PI.NO.220240094

## ANNEXURE - B

**PRE QUALIFICATION CRITERIA for DISCHARGE RING MACHINING:-Vendor should have below mentioned facilities in order to qualify:**

1) **For vertical boring operation-** Vertical Borer (VTL) machine having minimum boring dia 05 mtr. with minimum height 0.9 mtr. In case vendor is having equivalent machining facility to accommodate the Pivot ring for vertical boring operation, vendor to clearly specify type of machine along with detail specification and step wise procedure to carry out operations. In either of above conditions vendor to submit documents related to machine make with detail specification & photos.

2) **Crane facility-**For lifting of job vendor should have overhead crane of capacity 18 Ton or higher. Vendor to submit documents related to crane make with detail specification/catalogue and photos. Vendor to clearly specify lifting capacity of crane.

3) Vendor should have experience of machining similar items having dia more than 4 mtr. Vendor to submit PO copy of same along with co-related unpriced copy of invoice. Provide complete details of quoted machining experience such as name, postal address of company/customer and year. The PO and completion certificate should be within three year from tender opening date (Techno-commercial). However in case of partial completion of PO, Lot completion certificate is required.

4) BHEL reserve the right to verify information provided by the vendor. In case information provided by vendor is found to be false/incorrect, suitable punitive action may be taken in case of BHEL registered supplier as per BHEL norms. BHEL has right to reject the technical bid of the vendor.

**GENERAL POINTS**

1) QA Plan is applicable. Inspection will be carried out as per QAP.


2) Inspection will be carried out by BHEL / BHEL appointed third party as per QA plan.

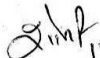
3) Required mcg tool, jig/fixture, clamping items, measuring instrument for ID/OD/Height & any other facility required for complete machining of stay ring to be arranged by vendor.


4) All checking instruments along with gauges required for complete inspection shall be arranged by vendor.

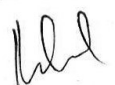
5) Transportation to & fro from BHEL Bhopal will be in the vendor's scope.


6) Scrap wt 1935 kg shall be retained by vendor free of cost and only GST on scrap shall be deducted from vendor.

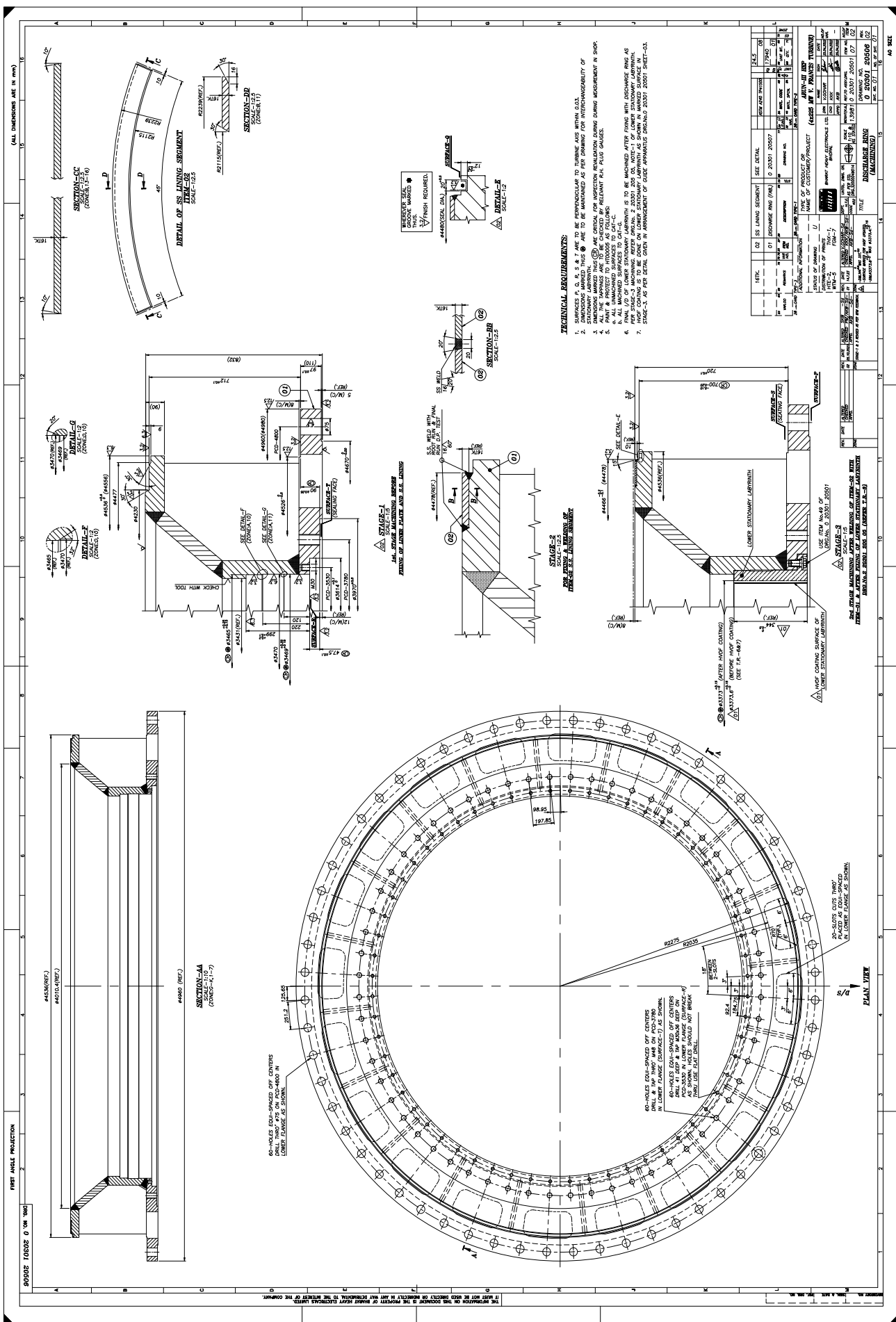
  
महेंद्र सिंह / Mahendra Singh  
प्रबंधक / Sr. Manager  
जल टरबाइन विभाग / WTM Division  
बी.एच.ई.एल., भोपाल / B.H.E.L., BHOPAL

  
महेंद्र सोनी / Mahendra Soni  
प्रबंधक / Manager  
ज. ट. वि. - प्रौद्योगिकी / WTM - Technology  
बी.एच.ई.एल., भोपाल / BHEL, BHOPAL

  
Abhishek Sharma  
Sr.Mgr. (WTM-SHOP)

  
पुष्पा म / Pushpa M  
वरि. प्रबंधक / Sr. Manager  
एच.टी.ई. विभाग / H.T.E. Division  
बी.एच.ई.एल., भोपाल / BHEL, BHOPAL

  
बृजेश दिवाकर / BRISHESH DIWAKAR  
प्रबंधक / Manager  
जल टरबाइन वि. विभाग / WTM Division  
बी.एच.ई.एल., भोपाल / B.H.E.L., BHOPAL



MANUFACTURER'S NAME AND ADDRESS	ITEM: ROUGH MACHINING OF DISCHARGE RING & PIVOT RING		DATE: 31.08.2024 REV.NO.: 00 QF NO.: Q4/HT/2209		PROJ. ARUN-III PACKAGE: ELECTROMECHANICAL	
	VENDOR'S NAME AND ADDRESS TO BE FILLED BY THE VENDOR					

SL. NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REF. DOC. & ACCEPTANCE NORM	RECORDED	AGENCY	REMARKS
1.	2.	3.	4.	5.	6.	7.	8.	9.	10.

1.1	FABRICATED DISCHARGE	Marking of PCD lines	Major	Vis	100%	BHEL Drawing & Annexure	IR	P	W	
1.2	RING / PIVOT-RING	Marking of machining center line	Major	Vis	100%	BHEL Drawing & Annexure	IR	P	W	

2.0	Vertical Boring operations									
2.1	ROUGH	Check of machined diameters (diameters having tolerance and not having tolerance, both must be checked)	Major	Meas / Vis	100%	BHEL Drawing & Annexure	IR	P	W	Refer Annexure with the purchase order, corresponding details and drawing TR
2.2	MACHINED	Check of machined Heights (individual)	Major	Meas / Vis	100%		IR	P	W	
2.3	RING IN	Check of chamfers (if any)	Major	Meas / Vis	100%	-do-	IR	P	W	
2.4		Surface finish check	Major	Meas / Vis	100%	-do-	IR	P	W	

<div>For BHEL</div> <div>LEGEND: M: MANUFACTURER/SUB-SUPPLIER, B: BHEL / BHEL APPOINTED THIRD PARTY P: PERFORM, W: WITNESS, R: REVIEW OF RECORDS MEAS: MEASUREMENT</div>										
For Vendor's QC representative										

**Note 1:** Compliance with this QAP does not absolve the vendor from their responsibility of design, manufacture and supply as per purchase specification so as to give satisfactory performance.

**Note 2:** In case of any discrepancy / interpretational issue, BHEL Specification and Drawing shall be binding.

**Note 3:** The QAP states bare minimum testing requirement, which vendor is expected to fulfill. Any test not mentioned in the QAP, but a part of drawing or specification, is to be carried out and internal documents for the same shall be submitted.

**Note 4:** Documentation to essentially include: (a) Dimension Reports (b) Guarantee Certificate (c) CIR