

BHEL Logo		MANUFACTURER'S NAME AND ADDRESS		MANUFACTURING QUALITY PLAN				PROJ: ARUN-III			
VENDOR'S NAME AND ADDRESS TO BE FILLED BY THE VENDOR		CHARACTERISTICS		CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REF. DOC. & ACCEPTANCE NORM	RECORD FORM	AGENCY	REMARKS	
SL. NO	COMPONENT & OPERATIONS	3.		4.	5.	6.	7.	8.	M	B	10.
MACHINING OF INDIVIDUAL QUADRANTS AND JOINING OF THE QUADRANTS											
1.0	FABRICATED DISCHARGE RING / PIVOT -RING	Marking of PCD lines		Major	Vis	100%	BHEL Drawing & Annexure	IR	P	W	
1.1		Marking of machining center line		Major	Vis	100%		IR	P	W	
Vertical Boring operations											
2.0		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
2.1	ROUGH MACHINED			Major	Meas / Vis	100%		IR	P	W	
2.2	OTC/PIVOT - RING IN	Check of machined Heights (individual)		Major	Meas / Vis	100%		IR	P	W	
2.3		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	All machined areas
LEGEND: M: MANUFACTURER/SUB-SUPPLIER, B: BHEL / BHEL APPOINTED THIRD PARTY P: PERFORM W: WITNESS, R: REVIEW OF RECORDS MEAS: MEASUREMENT				For Vendor's QC representative							

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PRE QUALIFICATION CRITERIA for PIVOT RING MACHINING:-Vendor should have below mentioned facilities in order to qualify: **PI. NO. 220240093**

- 1) **For vertical boring operation-** Vertical Borer (VTL) machine having minimum boring dia 06 mtr. with minimum height 01 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 24 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 4509 kg shall be retained by vendor free of cost and only GST on scrap shall be deducted from vendor.

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ANNEXURE - I**Job Description -Machining of Pivot Ring**

Qty- 01

Job Specification:


Fabricated Assy. Weight- 23340 KG

Diameter- 5970 mm

Height- 869.5

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 drawing no. 02030120504 Rev.04 (1st stage machining before fixing of Liner plate and SS Lining, Drawing Zone C-8). Diameter 5950, 5550, 4482, 4546 and 4960 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.
- Scrap wt. 4509 kg shall be retained by vendor free of cost and only GST on scrap shall be deducted from 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.


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