



<div><div>A-FORM</div><div></div><div>FORM NO BP-0021</div></div>	<div>BHARAT HEAVY ELECTRICALS LIMITED - BHOPAL</div> <div>MM DEPARTMENT</div> <div>ESTIMATE SHEET FOR ISSUE OF MATERIAL/COMPONENTS FROM BHEL</div> <div>CHECKLIST</div>	<div>A-FORM NO : A217A30</div> <div>REV NO : 0</div> <div>A-FORM DATE 25-APR-25</div> <div>PRINT DATE : 25-APR-25</div> <div>PAGE : 1 / 2</div>																																														
<div>DEPARTMENT : 217PROJECT : AdaniPower_2x8PO NO : A217A30END PRODUCT : LEM</div> <div>INDENT NO : 221750008WORK ORDER NO : 43192A42311PO DATE :DELY REQD : 30072025</div> <div>INDENT DATE : 24042025MATERIAL ISSUE DIV : 217SUPP CODE :SUPP NAME :</div>																																																
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1 MATERIAL TO BE ISSUED ON :-	FREE ISSUE BASIS	SIGNATURE OF INDENTOR	SIGNATURE OF ASC EXECUTIVE
2.TRANSPORT TO BE PROVIDED BY :-	SUPPLIER	NAME	NAME
3.EXCISE DUTY ON ISSUE MATL TO BE BORNE BY :-	SUPPLIER	DESIGNATION	DESIGNATION
4.SCRAP TO BE RETURNED :-	NO	TELEPHONE	TELEPHONE
5 INVARIABLY ISSUE WT. TO BE RECORDED ON SMIV/PMIV		4	

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5051.000 NO217217217									
M/CND OF STATOR FRAME - 14027140929									
AM44408810171.0000 NO700000.0001.00NO WIP700000.0001.0000									
STATOR FRAME FAB DRG NO - 14027140928									
R/M WT (kg) PER UNIT: 7000F/M WT (kg) PER UNIT: 6350Scrap Rate (Rs/kg): 32.6									
REMARKS R/M WT IN KG : #1-11500, #2- 10200, #3- 13000, #4- 15000, #5- 7000 AND F/M WT IN KG #1- 10900 #2- 9700, #3 - 12400, #4- 13400, #5- 6350						AFORM TOTAL			11160000.000
TOTAL NO OF CANCEL ITEM 0									

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Pre-Qualification Requirements for Machining of Fabricated Stator Frames
(Labour basis) as per BHEL Drawings and other specifications


Ref.: AME/PQR/Frame Machining-01

Date : 24.04.2025

Sl. NO	Description of Pre-Qualification Requirements (Only manufacturers are eligible. Traders / agents etc. will not be considered)	Vendor response	
		Complied / Not Complied	Bidders to submit following documents in compliance to PQR
1	Manufacturers must have successfully supplied at least 03 Machined Stator Frames for Industrial / Power plant Motors or Generators application in the last 10 years, as calculated from Tender Opening Date (TOD). Out of these Stator Frames, at least one Frame must have :- 1. Stator Bore $\geq 2800mm$. 2. Frame Outer Dimensions $\geq 3800mm$ 3. Frame Height $\geq 3000 mm$ 4. Weight of frame $\geq 15000 kg$	YES / NO	a. Vendor has to furnish details of at least 3 Machined Stator Frames supplied, i.e..PO Copy and Proof of Supply (like Completion Certificate/ Invoice copy / third party inspection report etc.) to be provided. b. In case of BHEL Bhopal supply, vendor has to furnish only BHEL PO.
2	The design features, dimensions, machining tolerances (including parameters like Perpendicularity, Run-out, Surface finish etc.), QA Plan and technical requirements shall be strictly as per BHEL drawings, specifications and annexure.	YES / NO	Supplier to provide specific confirmation.
3	Vendors must accept the Technical Requirements (Annexure-T)	YES / NO	Vendors to provide their confirmation to Technical Requirement (Annexure-T) on each page with seal and signed by authorised signatory.
4	Vendor must have in house manufacturing facilities to execute the order as per BHEL drawings, QAP and technical annexure -T	YES / NO	Compliance to be provided by submitting details of manufacturing facilities available.

NOTE :- Stator Frame Machining is a critical process. Hence, NO RELAXATION in PQR shall be provided for MSE Vendors or MII Start-ups.


(Nidhi Gupta)
DGM / AME


(Vaibhav Panchbhair)
Manager / AME

(Seal and Sign of Authorized signatory of Supplier)

ANNEXURE – T

TECHNICAL REQUIREMENTS FOR MACHINING OF FABRICATED STATOR FRAMES ON LABOUR BASIS AS PER BHEL DRAWINGS & OTHER SPECIFICATIONS

Complete Machined Stator Frames to be supplied on LABOUR basis as per BHEL drawings as mentioned in enquiry and QA plan as applicable.

01. The raw material /sub-assemblies shall be issued as Free Issue Material (FIM) by BHEL.
02. Supplier to use only latest revision of the drawings. Before start of job, supplier should obtain the concurrence from concerned engineering division regarding the drawing version to be referred.
03. Proof-marking to be carried out by the supplier both on NDE side and DE side (or TOP side and BOTTOM side) compulsorily before final machining.
04. Following identification marks (by hard punch) to be punched as well as by white paint by supplier on every job at Non-Drive End (Top Corner).
 - (a) Supplier's Name
 - (b) PO No. & PO Date
 - (c) Drawing No./Rev./Var.
 - (d) W.O No. / M.O. No
05. Supplier to submit Guarantee / Test certificate and other required documents as per QA Plan and drawing along with material supply.
06. Tools, jigs & fixtures will not be provided by BHEL.
07. While machining, vendor has to maintain critical dimensions all geometrical and linear tolerances, viz. concentricity, parallelism, perpendicularity, run out etc. as mentioned in the drawing and technical requirements. All dimensions which are critical to quality (CTQ) must be complied by Vendor.
08. Inspection at supplier's works will be done by Third Party inspection agency (TPIA) / BHEL as per QA plan QA/MT/BOI/202, Rev.00 after Final Stator Frame machining.
09. Supplier to submit critical dimensions' data along with and prior to each supply of Machined Stator Frame.
10. BHEL reserves the right to reject any Machined Stator Frame subject to unsatisfactory Assembly / Performance of motor on account of the Machined Stator Frame.
11. TRP shall be applied on all machined surfaces.


(Seal and Sign of Authorized signatory of Supplier)

ANNEXURE-A**TERMS & CONDITIONS FOR OPEN TENDER FOR COMPLETE MACHINING OF FABRICATED STATOR FRAMES****PI- 221750008**

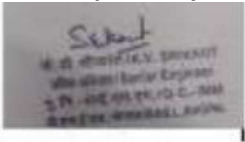

1. **Price Basis for PO:** PO to be placed on Individual item L1 basis on firm rates offered for each item.
2. **Splitting of quantity:** Splitting of quantity among lowest two vendors at L1 rates shall be as follows:

PI # NO	Item name and Drg	PI QTY	Distribution Ratio	
			L1	L2
1	Complete machining of stator frame Drg no 14027140926 V00 Except 40 holes M12 x 16 Deep on Both Sides	4	3	1
2	Complete machining of stator frame Drg no 14027140866 V00 Except 40 holes M12 x 16 Deep on Both Sides	3	2	1
3	Complete machining of stator frame Drg no 14027140829 V00 Except 40 holes M12 x 16 Deep on Both Sides	1	1	0
4	Complete machining of stator frame Drg no 14027140797 V00 Except 40 holes M12 x 16 Deep on Both Sides	1	1	0
5	Complete machining of stator frame Drg no 14027140929 V00	1	1	0
	TOTAL	10	8	2

3. **Scrap / Swarf:** Scrap generated during machining of job to be retained by Vendor and cost of scrap along with applicable GST and other taxes (if any) shall be recovered from Vendors invoice in lieu of scrap retained by them as per BHEL Norms prevailing at the time of incidence. Latest Scrap rate applicable as of now is Rs. 32.6 / Kg (Finance e-mail copy is attached).
4. **Transportation:** Both To & Fro transportation of Fabricated Stator Frame transportation from BHEL Bhopal to Vendor's works and finish material transportation from Vendor's works to BHEL Bhopal is in Vendor's scope. Material should be lifted within 5 Working Days from date of intimation. If Fabricated Stator Frame is not lifted in above mentioned time frame, then BHEL reserves the right to cancel / divert the PO to other vendors and for same any claim will not be entertained by BHEL.
5. **Packing for Delivery:** Delivery of Fully Machined Stator Frames is required to be suitably packed to avoid transport damages of all machined surfaces and duly coated with TRP coating for preventing rust formation / deposition.
6. **Delivery Schedule:** Delivery of Fully Machined Stator Frames as per relevant applicable drawings shall be as per following details from date of receipt of BHEL's Fabricated Stator Frames at vendor works:
 - a. Upto issue of 2 Stator Frames at a time - Delivery will be within 30 days for both the Stator Frames.
 - b. Upto issue of 3 Stator Frames at a time - Delivery will be within 30 days for first 2 Stator Frames and within 45 days for 3rd Stator Frame.
 - c. Upto issue of 4 Stator Frames at a time - Delivery will be within 30 days for first 2 Stator Frames and within 60 days for 3rd Stator Frame and 4th Shaft.
 - d. For more than 4 Stator Frame at a time - Delivery will be in same ratio as above to be followed.
 - e. In case of non-compliance to the specified delivery schedule, BHEL reserves the right to divert the quantity to meet urgent need of production schedule to other supplier and no claim / correspondence in this regard will be entertained.
 - f. In case of rejection of Machined Stator Frame, it is to be ensured by vendor that Machined Stator Frame is to be taken back within maximum five working days after communication for rectification and supply back the same to BHEL Bhopal within fifteen working days from rejection. To & Fro Transportation on account of Rejection / Re-work shall be in scope of Vendor. In the event of non-lifting of rejected material by vendor, BHEL will not be responsible for any / all loss incurred to the supplier in any case.
 - g. In the event of the Stator Frame becoming un-useful to BHEL on account of wrong machining or any other reason attributed to Vendor, recovery of total cost of the Stator Frame (s) will be decided by BHEL Bhopal and will be recovered from Vendor as per BHEL's norms / guidelines for recovery.
 - h. All other terms & conditions as stipulated in the Tender will be binding and has to be strictly adhered-to.

	<div><div>BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL</div><div>QUALITY ASSURANCE PLAN FOR 1TC STATOR FRAME MACHINING</div></div> <div><div>QUALITY PLAN NO. –QA/MT/BOI/202</div><div>DATE: 24.04.2025 Page: 1 of 1</div></div>
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SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
01		Final Dimension	Dimensional check	100%	Drawing	Drawing	Inspection Report	BHEL/TPIA	Witness.
02		Run out, Parallelity, Perpendicularity, PCD Visual & Surface Finish (As per drawing)	Measurement	100%	Drawing	Drawing	Inspection Report	BHEL/TPIA	Witness

<div><div>Prepared By</div><div></div><div>(KV Srikant)</div></div>	<div><div>Approved By</div><div></div><div>(Ashish Mohan Telgote)</div></div>
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