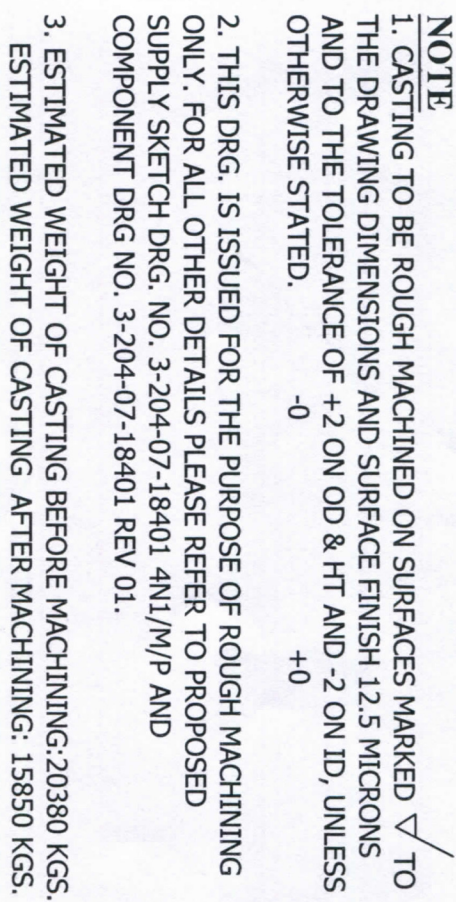




1. CASTING TO BE ROUGH MACHINED ON SURFACES MARKED ∇ TO THE DRAWING DIMENSIONS AND SURFACE FINISH 12.5 MICRONS AND TO THE TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE STATED.

$$0^+ \quad 0^-$$

2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO PROPOSED SUPPLY SKETCH DRG. NO. 3-204-07-18401 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18401 REV 01.

3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 20380 KGS.
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 15850 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SF/.....147
Date.....10/11/22

21088

MACHINING OF LABYRINTH RING

INDENT NO: 20210361

PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 4100 mm, and weight 20MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq 20.0\text{MT}$	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18401/M1:Rev-00	Vendor to confirm
2	Vendor to arrange all tools & instruments required for machining of the job	Vendor to confirm
3	BHEL reserves the right to visit vendor for stage inspection during job machining to assess the progress and technical aspects and further processing shall be done accordingly.	Vendor to confirm
4	Final Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
5	Delivery requirement: 5 weeks/pc from the date of lifting	Vendor to confirm
6	Identification details on the casting to be maintained	Vendor to confirm
7	Vendor to submit following with the offer:- c) Details of the Organization d) Details of the machine tools and other facilities installed in the company	Vendor to submit
8	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
9	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bishnuthi Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
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उप सचिवा विभाग
दिनांक: 15.12.21.....
सा.स.प.पी/बी.एच.ई.एच. हरिद्वार