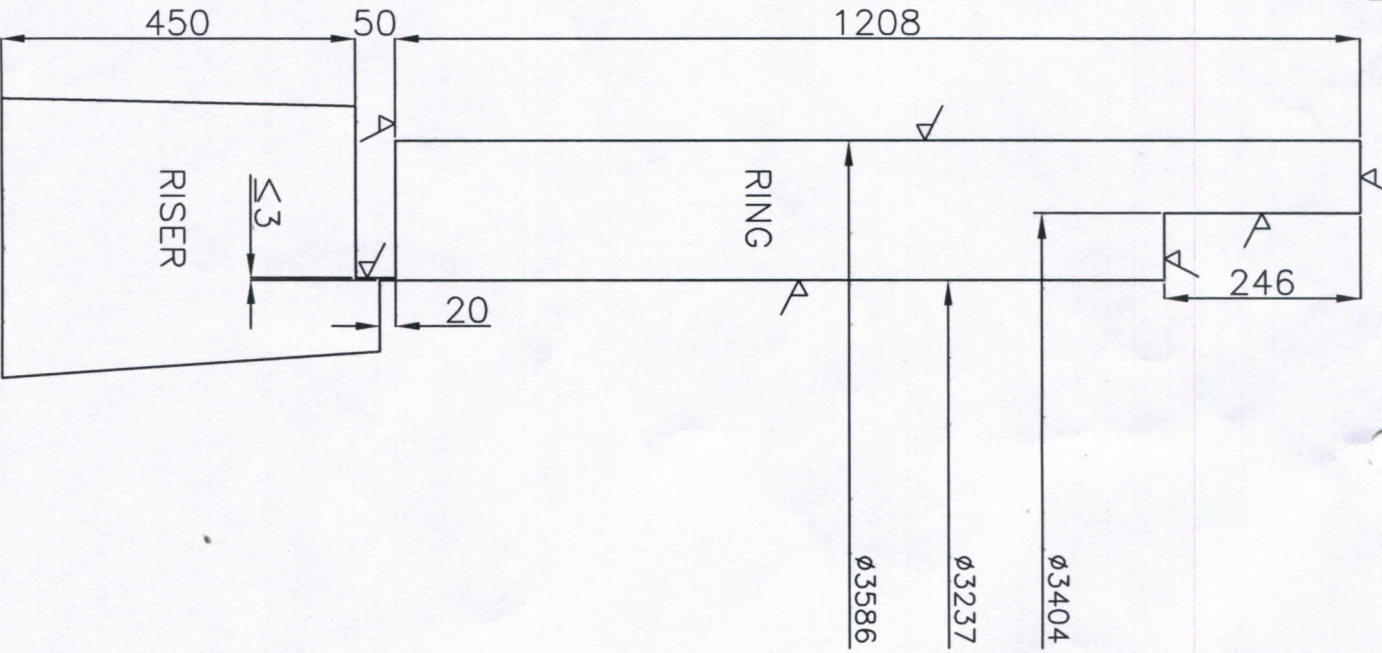




NOTES:

1. CASTING TO BE ROUGH MACHINED ON THE SURFACES MARKED ∇ TO DRG. DIMENSIONS AND SURFACE FINISH 12.5 MICRONS OR BETTER AND TO THE TOLERANCE OF +2/-0 ON OD & HT AND -2/+0 ON ID
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS. PLEASE REFER TO COMPONENT DRG
- 2-202-05-20202 AND PROPOSED SUPPLY SKETCH DRG. NO.- 2-202-05-20202-4N1/M/P
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 38868 KGS
4. ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 28439 KGS

CONTROLLED COPY
Foundry Technology
C.No. SF/ 146
Date 10 NOV 2021

		BHARAT HEAVY ELECTRICALS. LTD.	
CENTRAL FOUNDRY FORCE PLANT		RANPUR, BHARAT	
DEPT. F.DY. TECH.	SCALE N.T.S.	WEIGHT IN KGS	NAME
TITLE		DRN	DATE
ROUGH M/C DRG FOR		WRO	ING
LOWER STATIONARY LABYRINTH 4 IN1		CHD	JAVIN
PROJECT AND CUSTOMER NAME		APPD	AN SUDHAKAR
PALAMURU RANGAREDDY		DRAWING NO	
BHOVAL		2-202-05-20202/M2	
23601B		SHEET NO.-1	
		NO. OF SHEETS-1	

MACHINING OF LABYRINTH RING

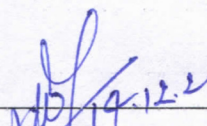
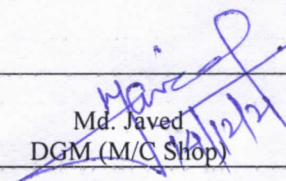
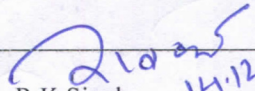
INDENT NO: 20210364

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. 3800 mm, and weight 39MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 39MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-202-05-20202/M2: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: 6 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:- a) Details of the Organization b) 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 Bibhuti 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

सी.एफ.एफ.पी/बी.एच.ई.एल., हरिद्वार