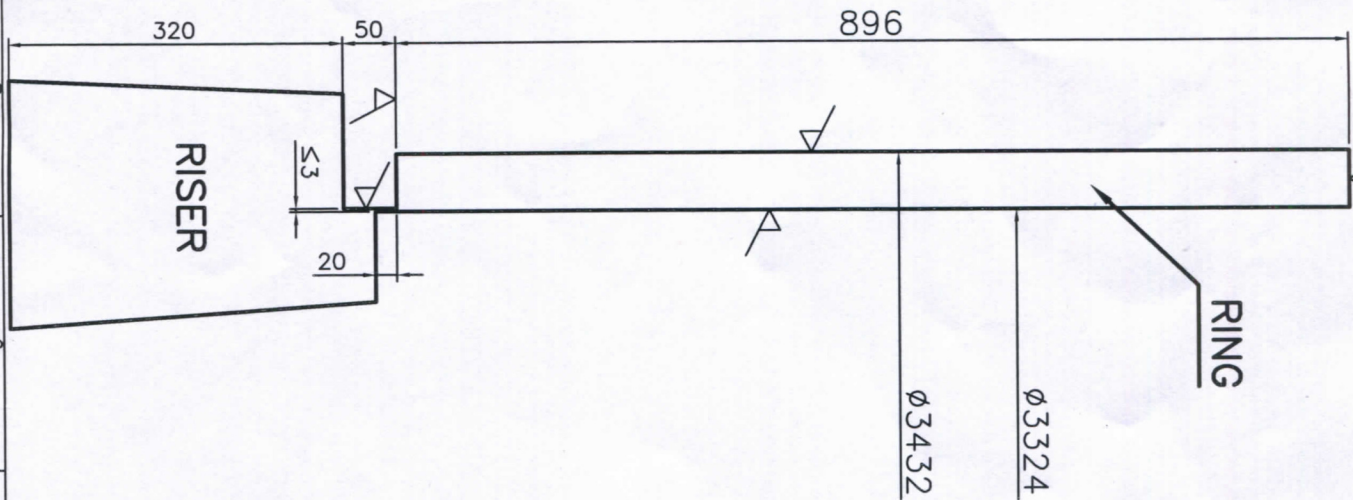




NOTE

1. CASTING TO BE ROUGH MACHINED ON THE SURFACE ∇ 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

+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. 3-203-07-20202-4N1/M/P AND COMPONENT DRG NO. 3-204-07-20202.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 17115 KGS.
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 9910 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SF/.....166.....
12 NOV 2021

REV	DATE	ALTERED	CHECKED
ZONE			

DEPT. / FDY. TECH.	SCALE	N.T.S.	WEIGHT IN Kgs	NAME	SIGN	DATE
ROUGH M/C DRG. FOR (4 in 1)						
LOWER ROTATING LABYRINTH						
PROJECT AND CUSTOMER NAME	TECHNOLOGY NO	DRAWING NO	3-204-07-20202/M2			
P/R LIS / KH2P1	23604A	SHEET NO - 1				
BHEL / BHOPAL						

DRN	23/PKAMURU	RE LIS	4/23604A
WDO	INRG		
CHD	ARGHANA		
APTD	IN SUDHAKAR		

NO. OFF SHEETS-1	
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RISER

RING

$\phi 3432$

$\phi 3324$

320

50

896

≤ 3

20

MACHINING OF LABYRINTH RING

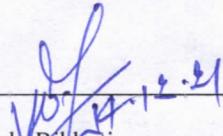
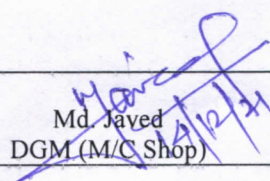
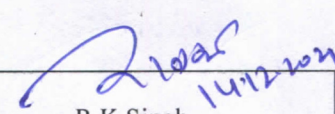
INDENT NO: 20210374

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. 3600 mm, and weight 18MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 18.0MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-20202/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: 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:- 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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सप सविदा विभाग

दिनांक 15/12/21.....

सी.एफ.एफ.पी/बी.एच.ई.एल. हरिद्वार