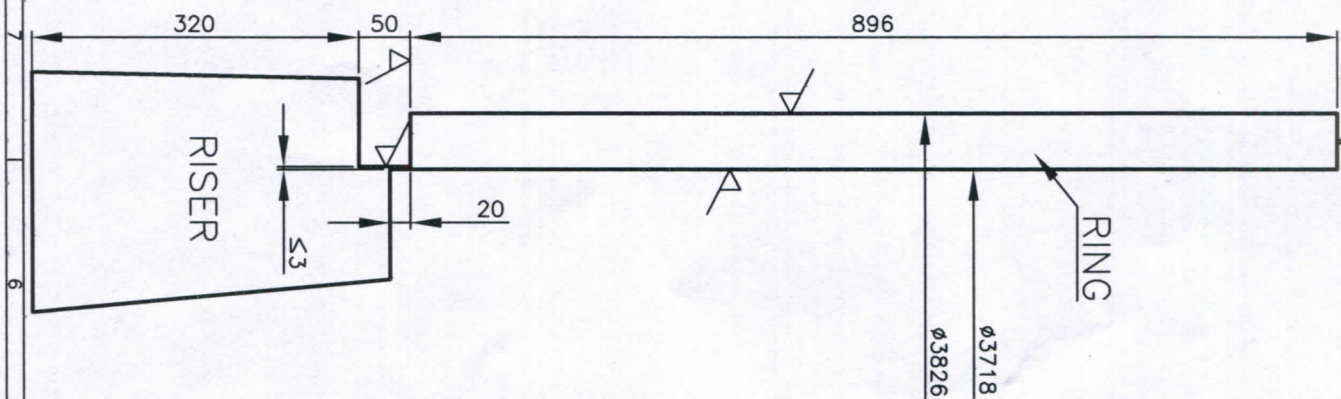




NOTE

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 +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. 3-204-07-18402 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18402 REV 01.

3. WEIGHT OF CASTING BEFORE MACHINING: 18874 KGS
WEIGHT OF CASTING AFTER MACHINING: 10997 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SFI/148
Date 10 NOV 2021

REV	DATE	ALTERED	CHECKED
ZONE			
BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORCE PLANT RAIPUR HARDVAR			
DEPT.	FDY. TECH.	SCALE	N.T.S.
TITLE	ROUGH M/C DRG. FOR (4 IN 1) LOWER ROTATING LABYRINTH		
PROJECT AND CUSTOMER NAME	PRANANTA-M/ KALSHIVARAM 12P2 BHEL, BHOPAL		
TECHNOLOGY NO	23504B	DRAWING NO	3-204-07-18402 /M3
DRN	123/04/ESH/MS/AM 12P2/23504B	NAME	SKH
WKO	MS	DATE	
CHD	L. AGRAWAL		
APPD	AN SUDHAKAR		
SHEET NO.-1	NO. OF SHEETS-1		

MACHINING OF LABYRINTH RING

INDENT NO: 20210360

i) 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. 4000 mm, and weight 19MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 19MT	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18402/M3: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 Bishnuthi 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
1-5-12-21.....
स.स.स.सी/बी.एच.ई.एल. हरिद्वार