

NOTICE NO. WEX/NBS/SPDL/EOI-PUB/02 , DTD. 30.3.2011

SCOPE OF REPAIR OF HIGH SPEED MOTOR SPINDLE , MODEL : HX-151(M/S Starragheckert , Switzerland Make) & MODEL: MFW-2401/15 VC HSK A63 (M/S Fischer , Switzerland Make) THROUGH WORKS CONTRACT.

1) Scope of Work :

- 1.1 Complete dismantling of Spindle.
- 1.2 Identification of worn out/ damaged parts.
- 1.3 Repair /Replacement of the damaged parts.
- 1.4 Replacement of all the bearings, bushes, seals etc. Replaced parts shall be returned to BHEL.
- 1.5 Checking of the motor winding & re-varnishing
- 1.6 Assembly of the spindle.
- 1.7 Balancing of the spindle.
- 1.8 Testing of the spindle. (Test certificate is required)

2) Acceptance Criteria :

- 2.1 Vendor shall submit protocol for stage inspection and final inspection at the time of Submitting the offer.
- 2.2 Test Certificate of motor after re-varnishing & assembly.
- 2.3 Vendor shall submit the report of stage inspection done as per protocol. BHEL reserves the right to Cross check at any stage.

3) Warranty :

- 3.1 Vendor shall stand warranty of the repaired spindle for a working of Six months after Commissioning of the repaired spindle.
- 3.2 Vendor shall attend warranty calls within 24 Hrs. of communication from BHEL , Hardwar.

4) General Conditions :

- 4.1 After reconditioning the spindle , spindle shall be dispatched by the vendor to BHEL Hardwar after proper packing through BHEL approved transporter.
- 4.2 BHEL will deliver the defective spindle to the works of the vendor.
- 4.3 Vendor has to deposit Earnest Money (EMD) Approximately 2 % of the value of the work. EMD may be converted into SD.
EMD may be deposited in cash or Demand draft only in favour of Manager (F/ Works), BHEL, Hardwar. EMD shall not carry any interest.
- 4.4 Security Deposit @ 10 % of the value of work has to be deposited at the time of final Award of the work. Security Deposit on the completion of Warranty period with No interest.
- 4.5 Vendor shall submit a Bank Guarantee for about Rs. 2,25,000/= Per Spindle for the duration of the custody at their works. Vendor shall arrange insurance of spindle at their works themselves.
- 4.6 Insurance during transportation only, will be borne by BHEL.

1. HIGH SPEED MOTOR SPINDLE , MODEL: HX – 151 (M/S STARRAGHECKERT , SWITZERLAND- MAKE).

Sl. No.	Description	Data / Specification
1.	Maximum Spindle rated RPM	15,000 rpm.
2.	Runs at max.	15,000 rpm.
3.	Spindle Motor power	27 KW.
4.	Frequency	Variable with variable drive.
5.	No. of poles	Not Known
6.	Tool Clamp	Draw bar mechanism with disc springs.
7.	Coolant Through Spindle.	Yes
8.	Spindle is cooled by refrigerating coolant system.	Yes
9.	Spindle Taper	HSK A 63
10.	OTT Clamping device of Tool clamping system	7 segments of collet.
11.	ID of Collette Shaft	12 mm.
12.	In – Out of inner cyl. Of collet	11 mm.
13.	Spindle Torque	90 Nm
14.	Bearing used –	Ceramic Hybrid Bearings. (specifications not known)
15.	Water cooling	4 Bar & 10 LPM.
16.	Seal reference	Not Available.
17.	Lubrication	One time lubrication – Not known

- NOTE : 1) No Assembly drawing of the motor spindle is available.
 2) No part drawing or part list can be provided.
 3) No dismantling or assembly procedure is available.
 4) No test chart is available.

2. HIGH SPEED MOTOR SPINDLE , MODEL: MFW- 2401/15/3 VC (M/S FISCHER , SWITZERLAND- MAKE)

Sl. No.	Description	Data / Specification
1.	Maximum Spindle rated RPM	15,000 rpm.
2.	Runs at max. RPM	15,000 rpm.
3.	Spindle Motor power	20 KW.
4.	Frequency	Variable with variable drive.
5.	No. of poles	Not Known
6.	Tool Clamp	Draw bar mechanism with disc springs. De clamping by Hydraulic piston cylinder.
7.	Coolant Through Spindle.	Yes
8.	Spindle is cooled by refrigerating coolant system.	Yes
9.	Spindle Taper	HSK A 63
10.	OTT Clamping device of Tool clamping system	Yes. Details not available.
11.	ID of Collette Shaft	Not known
12.	In – Out of inner cyl. Of collet	Not known
13.	Spindle Torque	NA
14.	Bearing used –	Ceramic Hybrid Bearings. (specifications not known)
15.	Water cooling	Yes
16.	Seal reference	Not Available.
17.	Lubrication	One time lubrication- not known

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Format for Expression of Interest :

1. **Name of Party :**

2. **Address for Communications :**

3. **Company Profile :**

4. **Engineering Capability :** Please state if you have prior experience of repairing/
reconditioning a High speed motor spindle. If yes, please provide details.

5. **Financial Capability :** Please state your turnover for last three financial years.

Name , Signature & Contact Details of Authorized Signatory.