

747210/2022/HEP-WTM20207

Water Turbine Manufacturing QAP for Tooling Items				
Indent no	:	820210034		
	Sl. No.	Description		
	1	Holder (RH) 40mm X 40 mm X Lg 250mm To 300 mm Having Approach Length Up To 30 Mm To 40mm As Per Sketch-1, For 10 mm Insert. Hardness Of Tool Holder Must Have Sufficient Hardness So That It Cannot Be Bend Or Deflect During Machining At The Depth More Than 100 mm. There Should Be Proper Arrangement For Insert Sitting In Tool Holder.		
	2	Holder (LH) 40 mm X 40 mm X Lg 250 mm To 300 mm Having Approach Length Up To 30 mm To 40 mm As Per Sketch-1, For 10 mm Insert. Hardness Of Tool Holder Must Have Sufficient Hardness So That It Cannot Be Bend Or Deflect During Machining At The Depth More Than 100 mm. There Should Be Proper Arrangement For Insert Sitting In Tool Holder.		
	3	Inserts 10 mm Width Suited To Item #1 & #2. Insert Must Be Coated CVD/PVD Sothat To Achive Desire Finish In Seal Groove.		
	4	Screws Suited To Item #1, #2 & #3. Screw's Length Must Be Sufficiant To Hold The Insert In To The Tool Holder.		
	Note:	(1) All Items #1, #2,#3 & #4 shall be purchased from same make/single source. (2) Above items must be suitable for machining different grade of S.S material such as ASTM A240, ASTM A743 CA6NM. (3) There is no coolant provision in machines on which these tools shall be used. (4) Parameters Used On Machine are: (a) RPM = 1 to 2 & (b) FEED = 0.2 mm/Revolution to 0.3 mm/Revolution. (5) These grooving tool are required for job dia range 3 meter to 6 meter.		
Check List	:	FOR ITEM SL NO. #01, #02, #03 & #04	-	TC & GC required.
			-	Item to be checked as per Description.
			-	Final acceptance of all items shall be given after successful trial at WTM,BHEL,Bhopal.
			-	Assembly of all items with respect to package must be checked before clearence of material.

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21/3/22
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