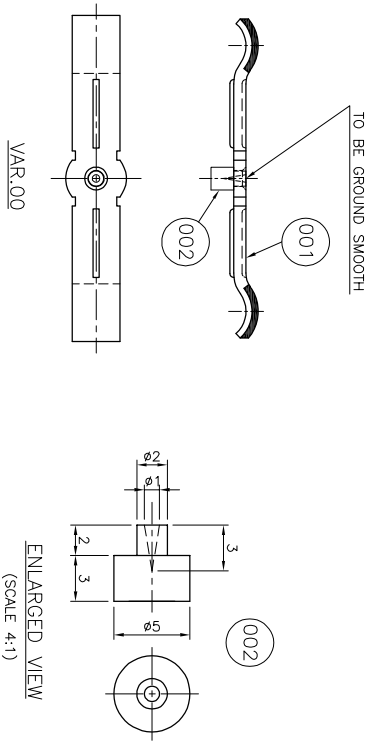


FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm.)

L001 1 13 185 3 NO. 01
DRAWING NO.

STYLE LIST			
STYLE NO.	ITEM INCLUDED	DESCRIPTION OR REMARKS	RECORDED SIGN DATE
BP 9078098317	VAR.00	SPECIAL MOVING CONTACT	Sd/- 28.09.88





CORPORATE PURCHASING SPECIFICATION

AA10112

Rev No. 07

PAGE 1 of 4

BRIGHT STEEL BARS AND SECTIONS (STANDARD QUALITY)

1 GENERAL:

This specification governs the quality requirements of Bright Steel Bars and Sections of standard quality, such as I-beams and equal angles required in very small sections.

2 APPLICATION:

Bars are used in the manufacture of threaded and machined components for general engineering purposes. Sections are used as stator spacer plate vents in generators.

3 CONDITION OF DELIVERY:

3.1 Round Bars - Class 4, surface quality.

Up to 50 mm diameter - Cold drawn.

Above 50mm diameter - Cold drawn or Hot rolled, turned and polished

3.2 Rectangular/Square/Hexagonal Bars - Class 3, surface quality.

All sizes - Cold drawn.

3.3 Sections - Class 4, surface quality.

All sizes - Cold drawn

3.4 Bars and sections shall be straight, with their ends sheared, square and true and shall have a smooth surface.

3.5 The bars and sections shall be given a clear temporary rust preventive (TRP) coating to avoid corrosion during transit and storage.

Black TRP coating is not acceptable.

Clear TRP used shall be free from pungent smell.

The following clear TRP's are suggested:

- Servo RP 150 - M/s Indian Oil Corporation
- HE - 1612 - M/s. BHEL, Bhopal
- Rustilo DW-901 - M/s. Indrol Lubricants and Specialties Ltd.
- Rustpro Special - M/s. Tide water oil co.
- Any other clear TRP conforming to IS: 1154

4 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply with the requirements of the following National standards and also meet the requirements of this specification.

IS: 9550-2001 : Bright steel bars

Revisions:

CI 27.2.d of MOM of MRC-S&GPS

APPROVED:

INTERPLANT MATERIAL RATIONALISATION
COMMITTEE – MRC(S&GPS)

Rev No.07

Amd No.

Reaffirmed

Prepared
HEP, Bhopal

Issued
Corp.R&D

Dt. of 1st Issue
September 1976

Dt:15-06-2005

Dt:

Year:2019

**5 DIMENSIONS AND TOLERANCES:****5.1 Sizes:**

Bars shall be supplied to the dimensions specified in BHEL order.

5.2 Tolerances:**5.2.1 Rectangular/Square/Hexagonal/Flat Bars:**

Unless otherwise specified, tolerances on dimensions shall be as follows:

For drawn round bars and turned bars h10 to table 2 of IS:9550

For hexagonal and square drawn bars upto and including 80mm h11 and above 80mm h12 according to table 2 of IS:9550

For drawn flats in accordance with table 3 and 4 of IS:9550

For ground products in accordance with table 1 and 2 of IS:9550

5.2.2 Sections:

As specified in BHEL order/drawing.

5.3 Length:

Bar and sections shall be supplied in lengths of 2.5 to 4.5 meters with maximum 10% of shorts of not less than 1.5 meters.

5.4 Straightness:

Unless otherwise agreed to, the permissible deviation shall not exceed 1.5mm in any one meter length. Bars and sections shall be free from twists and bends.

6 MATERIAL:

The rolled bars used for purpose of producing the bright bars shall be such, so as to ensure freedom from segregation, piping and other harmful defects.

7 MANUFACTURE:

Steel shall be manufactured by the open-hearth, electric, basic oxygen or a combination of these processes.

8 FREEDOM FROM DEFECTS:

All finished steel bars and section shall be sound and free from internal and surface defects. They shall be bright and clean.

9 SURFACE CONDITION:**9.1 Round Bars and Sections:**

Shall be entirely free from cracks and other surface defects.

9.2 Rectangular/Square/Hexagonal Bar-Type '3' Finish:

Shall comply with IS: 9550, Class 3 of table 5.

10 CHEMICAL COMPOSITION:

The melt analysis of steel and the permissible variation in the composition of the material from the melt analysis shall be as follows:



CORPORATE PURCHASING SPECIFICATION

AA10112

Rev No. 07

PAGE 3 of 4

Element	Melt analysis percent, max	Permissible variation percent
Carbon	0.25	± 0.02
Sulphur	0.040	+ 0.005
Phosphorus	0.040	+ 0.005

11 TEST SAMPLES:

One sample for chemical and tensile test shall be selected from finished steel for every 20,000 kg or part thereof, with a minimum one per heat.

12 MECHANICAL PROPERTIES:

When tested in accordance with IS:1608, the test pieces shall show the following properties:

12.1 Rectangular/Square/Hexagonal/Section - Cold Drawn:

Tensile Strength : 440 N/mm², min

Elongation on $5.65\sqrt{S_0}$ gauge length : 8 – 20%

12.2 Round Bars:

12.2.1 Bars upto 50mm Diameter – Cold Drawn

Tensile Strength : 440 N/mm², min

Elongation on $5.65\sqrt{S_0}$ gauge length : 8 – 20%

12.2.2 Bars above 50mm Diameter:

Cold drawn or hot rolled, turned and polished.

Property	Hot rolled, turned and polished		Cold drawn
Tensile strength, min.	: 410 N/mm ²	OR	440 N/mm ²
Elongation on $5.65\sqrt{S_0}$ gauge length	: 23%, min		8-20%

13 TEST CERTIFICATES:

Three copies of test certificates shall be supplied, unless otherwise stated on the order.

In addition, to the above, the supplier shall ensure to enclose one copy of the test certificate along with their despatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information:

AA10112; Rev. No. 07 :

BHEL order No,

Supplier's Reference:

Name

Identification No.

Melt No.

Results of Tests:

Dimensional inspection.

Results of Chemical analysis and mechanical tests.

**14 PACKING AND MARKING**

The material shall be suitably packed in bundles – polythene wrapped to prevent sagging, corrosion and damage during transit. A suitable clear temporary rust preventive shall be applied all the bars as per clause 3.5 above and finally dispatched in wooden boxes.

Each bar over 50mm shall be stamped at one end with 'AA10112'. Bars 50mm and below shall be bundle together and tied with wire at 3 to 4 places along the length of the bar.

A metal label shall be securely attached to each bundle and shall bear the following information:

AA10112: BRIGHT STEEL BARS AND SECTIONS (STANDARD QUALITY)

BHEL Order No.

Consignment/Identification No.

Melt No.

Size and Weight.

Supplier's Name.

15 REFERRED STANDARDS (Latest Publications Including Amendments):

- 1) IS: 1154 2) IS: 1608 3) IS: 9550



CORPORATE PURCHASING SPECIFICATION

AA 120 03

Rev. No. 04

PAGE 1 OF 5

COPPER STRIP – HARD

1.0 GENERAL:

This specification governs the quality requirements of bright annealed bare Copper strip of thickness over 0.15 mm and upto 10 mm and widths upto 800 mm with radiused edges.

2.0 APPLICATION:

Used for general electrical purposes such as bus bars, transformers, switchgears etc.

3.0 CONDITION OF DELIVERY:

The strip shall be supplied in annealed condition, in coils or straight lengths as specified in BHEL order. The strips shall be supplied with their edges radiused as per clause 5.3.

4.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply with the requirements of the following national standard and also meet the requirements of this specification.

IS: 1897 – 2008 : Copper strips - for Electrical Purposes.

Gr.HD – Hard

5.0 DIMENSIONS AND TOLERANCES:

5.1 Sizes: Copper Strips shall be supplied to the dimensions specified in BHEL order:

5.2 Tolerances:

Tolerances on width, thickness, length and straightness shall be as per IS:3052, reproduced below.

5.2.1 Width:

5.2.1.1 Tolerance on width for rotary sheared strip upto 4mm thickness shall be as follows:

Width, mm			Tolerance, ±mm			
Over	upto and incl.	upto and incl. 0.25 thick	over 0.25 upto & incl. 0.55 thick	over 0.55 upto & incl. 1.0 thick	over 1.0 upto & incl. 2.0 thick	over 2. upto & incl. 4.0 thick
-	10	-	By agreement			
10	50	0.10	0.15	0.2	0.3	-
50	100	0.15	0.20	0.3	0.5	0.6

Revisions :

CI: 24.1 of MOM of MRC-NFCW+HE

APPROVED :

INTERPLANT MATERIAL RATIONALISATION
COMMITTEE-MRC (NFCW+HE)

Rev. No. 04

Amd.No.

Reaffirmed

Prepared

Issued

Dt. of 1 st Issue

Dt: 06.06.2012

Dt :

Year :

BHOPAL

Corp. R&D

December, 1978

CORPORATE PURCHASING SPECIFICATION



100	200	0.20	0.30	0.5	0.6	0.8
200	400	0.30	0.50	0.6	0.8	1.0
400	600	0.50	0.60	0.8	1.0	1.4
600	800	0.60	0.80	1.0	1.4	1.6

5.2.1.2 Tolerance on width for guillotine sheared strip above 4 mm thick shall be as follows:

Width, mm		Tolerance, $\pm$ mm	
Over	upto & Incl.	over 4.0 upto & incl. 5.0 thick	over 5.0 upto & incl. 10.0 thick
---	500	2	3
500	800	3	4

5.2.2 Thickness:
Tolerance on thickness shall be as follows:

Thickness, mm			Tolerance, $\pm$ mm			
Over	upto and incl.	upto and incl. 160 wide	over 160 upto & incl. 300 wide	over 300 upto & incl. 450 wide	over 450 upto & incl. 630 wide	over 630 upto & incl. 800 wide
0.16	0.20	0.015	0.020	0.025	0.03	0.04
0.20	0.63	0.020	0.025	0.03	0.04	0.05
0.63	0.90	0.025	0.030	0.04	0.05	0.06
0.90	1.20	0.030	0.04	0.05	0.06	0.07
1.20	2.00	0.040	0.05	0.06	0.07	0.09
2.00	2.80	0.050	0.05	0.07	0.09	0.11
2.80	3.50	0.060	0.07	0.09	0.11	0.14
3.50	4.50	0.070	0.09	0.11	0.14	0.17
4.50	6.00	0.090	0.11	0.14	0.17	0.20
6.00	8.00	0.110	0.14	0.17	0.20	0.25
8.00	10.0	0.140	0.17	0.20	0.25	0.30

5.2.3 Length (Rotary Sheared):

Length, mm		Tolerance, $\pm$ mm
Over	upto & incl.	
160	1000	3
1000	2000	6
2000	4000	9

5.2.4 Straightness:
The edges of strips supplied in straight lengths shall not vary from a straight line by more than 3 mm in any 1000 mm length.



CORPORATE PURCHASING SPECIFICATION

AA 120 03

Rev. No. 04

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5.3 Radius on Edges:

The strip shall be supplied with edges radiused as per IS:1897, reproduced below:

Thickness, mm		Nominal radius on edge, mm	Tolerance on radius, mm
Over	up to & incld.		
--	1.00	semi-circular	± 0.06
1.0	1.60	0.60	$+ 0.15$ $- 0.10$
1.6	2.25	0.80	± 0.15
2.25	3.55	1.00	± 0.20
3.55	10.00	1.25	± 0.25

6.0 MANUFACTURE:

The material shall be manufactured from copper of ETP grade conform to IS:191.

The conductor shall be manufactured from ETP grade copper conforming to BHEL specification: AA 12024: Electrolytic Tough Pitch Copper Wire/Bars/Ingots/Continuously cast wire rods.

NOTE: It is preferable to manufacture conductor from continuously cast copper rods provided all other parameters and conditions remain same.

7.0 FREEDOM FROM DEFECTS:

The material shall be clean, bright, smooth and free from harmful defects.

8.0 CHEMICAL COMPOSITION:

The analysis of copper when analysed in accordance with IS: 440 or any other conventional/instrumental methods shall be as follows:

Element	Percent, min.	Percent, max.
Copper and Silver	99.90	--
Bismuth*	--	0.001
Lead*	--	0.005
Total of all impurities excluding silver and oxygen excl. silver and oxygen	--	0.030

* These elements need not be determined when the material supplied conforms with mechanical and electrical properties specified in this specification. However, the supplier shall ensure that the composition of the material lies within the limits specified above.

9.0 TEST SAMPLES:

One sampling per size per melt per consignment of 3 tonnes or part thereof shall be taken for chemical, mechanical and electrical tests.

The sample shall be cut off cold and shall receive no further treatment before being tested.

CORPORATE PURCHASING SPECIFICATION



10.0 MECHANICAL PROPERTIES:

10.1 Tensile strength (For sizes over 0.5mm to 10mm thick):

The test samples, when tested in accordance with IS:1608 shall show the following properties:
IS:1608 , shall show the following properties:

Thickness mm		Tensile Strength, N/mm ² Minimum	
		For widths	
Over	upto & incl.	Upto & incl.3000 mm	Over 300 mm & Upto & Incl. 800 mm.
0.50	2.50	310	285
2.50	10.00	295	275

10.2 Bend Test:

The strip shall not be subjected to transverse bend test.where this is not possible, it shall be subjected to a longitudinal bend test. The strip when tested in accordance with IS: 1897 shall withstand a close bend test, through an angle of 1800, without showing any sign of cracks or failures upon the convex surface of the bend.

10.3 Hardness (Vickers):

When tested in accordance with IS:1501, the strips shall have a Vickers hardness not exceeding
90 HV, min.

11.0 ELECTRICAL RESISTIVITY (AS RECEIVED):

When measured in accordance with IS: 3635, the electrical resistivity at 20⁰ C shall not be greater than 0.01777 ohm-mm²/metre, which is equivalent to an electrical conductivity of 97%, minimum of IACS standard.(Refer Appendix B of IS: 613 for temperature correction factor).

Alternatively, the method of measurement employing eddy current probes as per ASTM E 1004 is also acceptable.

12.0 INSPECTION AT SUPPLIER'S WORKS:

Whenever specified, tests and inspection are to be conducted in the presence of BHEL'S representative.

The supplier shall offer BHEL'S representative all reasonable facilities, without charge to satisfy the latter that the material is being furnished in accordance with this specification.



CORPORATE PURCHASING SPECIFICATION

AA 120 03

Rev. No. 04

PAGE 5 OF 5

The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his carrying out the prescribed tests elsewhere. The supplier shall notify BHEL in advance about the readiness of the material for inspection and BHEL reserves the right to test the material at BHEL'S works and the final acceptance of the testing.

BHEL reserves the right to test the material at BHEL's works and the final acceptance of the material shall be based on these test results.

13.0 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied along with each consignment.

In addition, the supplier shall ensure to enclose one copy of the test certificate along with their despatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information:

AA 120 03, Rev 04: Copper strip – Hard

BHEL Order No,

Manufacturer's/Supplier's Name :

Lot/Identification/Batch/Melt No.

Sizes and Quantity Supplied

Results of dimensional inspection, chemical analysis, mechanical and electrical tests called for in this specification.

14.0 PACKING AND MARKING:

The material shall be supplied in coils or drums or in straight length as ordered. The minimum eye of coil or barrel diameter of drums shall be 250 mm.

The material not supplied in drums shall be hessian wrapped and tied with string and not with wire and shall be suitably protected to with wire and shall be suitably protected to avoid damage in transit. Each coil or drum or bundle shall be legibly marked or labeled with the following information.

Each coil or drum or bundle shall be legibly marked or labeled with the following information:

AA 12003 : Copper strip – Hard

BHEL Order No.

Manufacturer's/Supplier's Name :

Lot/Identification/Batch/Melt No.

Sizes and Quantity Supplied

15.0 REFERRED STADARDS (Latest Publications Including Amendments):

- | | | | |
|----------------|------------|------------|-------------|
| 1. IS:191 | 2. IS:440 | 3. IS:613 | 4. IS: 1501 |
| 5. IS:1897 | 6. IS:1608 | 7. IS:3052 | 8. IS:3635 |
| 9. ASTM E 1004 | | | |

Pre-Qualification requirements
for “MOVING CONTACT”

S. No	Description of requirement	Document to be attached
1	Quoted Items SL NO.	Mention SI No.
2	Bidder should submit a self-declaration stating that, “Offered item is same as per enquiry Specification and there is no deviation”.	Self-declaration on letterhead of firm
3	In case Bidder is not be OEM but its Reseller then bidder to submit valid authorisation certificate from OEM with the bid.	Valid authorisation letter from OEM.
4	Bidder should have supplied same or similar other assembly (which have involved manufacturing activities such as copper bending, machining, brazing etc.) items of minimum 10 nos in any one of last 15 years (To be reckoned from the Bid opening date) to BHEL or any Central / State Govt Organization /Private/ PSU or any other establishment of Indian Railways or/ through Rail System designer/manufacturer/Channel Partner/Supplier Bidder to furnish Purchase Order copy(s)/Invoice(s) as proof of supply.	PO Copy/Invoice Copy for other than BHEL BHOPAL PO (PO no for BHEL Bhopal PO)

Terms Other than PQR to be compiled during Bidding:

Terms	Complied/Not Complied
Tender Quoted item SL Nos.	
OEM Declaration/Authorization Certificate to be submitted by vendor	
Delivery accepted as per Tender	
Mobile no of concerned Person	
Email ID	

Note: Bidders providing above documents and not meeting above criteria essential for Offer Consideration

NO DEVIATION CERTIFICATE

Reference: Bid No. _____ Dated: _____

Subject: Self-Declaration for No Deviation

This is to certify that the items/services offered by us against the above-referred enquiry are **fully compliant** with the specifications, terms, and conditions mentioned in the bid document.

We hereby confirm that **there are no deviations** from the stipulated specifications, commercial terms, conditions, and other requirements of the enquiry.

For _____
(Authorized Signatory)

Date: _____

Seal:

OEM SELF-DECLARATION (FOR OEM)

Date: _____

Subject: **OEM Self-Declaration**

Ref: Bid No. _____

We certify that:

1. The bidder **M/s** _____ is the OEM** itself.
2. The product(s) offered are **new, genuine, and comply** with all specifications mentioned in the tender.
3. We shall provide full **warranty support, technical assistance, and spare parts** availability as required.

For **(Name of OEM)**

Authorized Signatory

Name: _____

Designation: _____

Seal:

OEM address:

**** OEM refers to (Original Equipment Manufacturer)**

B. OEM AUTHORIZATION CERTIFICATE (FOR BIDDER AS DEALER)

Date: _____

Subject: **OEM Authorization Certificate**

Ref: Bid No. _____

We, **(Name of Original Equipment Manufacturer – OEM)**, hereby authorize:

M/s _____

(Address: _____)

We confirm that:

1. Bidder is **authorized partner / dealer / distributor / bidder** for participating in the above-mentioned tender
2. The bidder is authorized to **quote, supply, install (if any), and support** our products.
3. The products offered will be **genuine, brand-new, and manufactured by us (OEM)**.
4. We will provide full **warranty support, technical support, and spare parts (wherever applicable)** for the supplied equipment throughout the warranty/AMC period.

For **(Name of OEM)**

Authorized Signatory

Name: _____

Designation: _____

Seal:

**** OEM refers to (Original Equipment Manufacturer)**