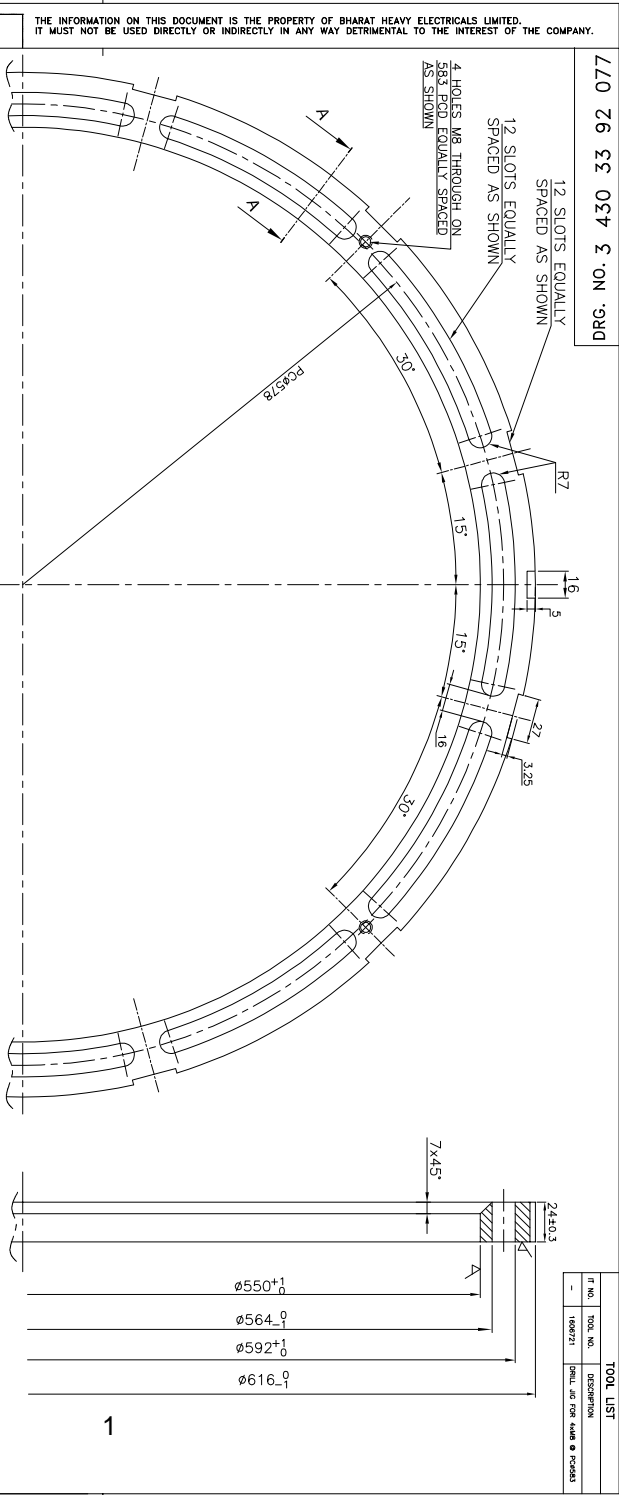


FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



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SECTION-AA

1

- NOTES:-
1. REFERENCE SLOT IS FIRST SLOT FLAME CUT ON END PLATE WITH RESPECT TO STATOR SLOT ON PUNCHING.
 2. END PLATE SHALL BE STRAIGHTENED WITHIN 0.5MM.
 3. SHARP EDGES & EXTRA MATERIAL TO BE REMOVED AFTER FLAME CUTTING.

REV.	DATE	ALTERED BY	REV.	DATE	ALTERED BY
05	04.11.22	APPD. R.C. 25/3	04	09.06.20	APPD. AS
NOTE-2 MODIFIED.					

VAR NO.	REMARKS	VAR NO.	REMARKS
00		01	

VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NO.
00			

VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NO.
00			

VAR NO.	ITEM NO.	DESCRIPTION	DRAWING NO.
00			

STATUS OF DRAWING

ADDITIONAL INFORMATION

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

DTG UNDER-SLING TRACTION ALTERNATOR

DISTRIBUTION OF PRINTS

TME - 1 TAM - 4

TXN - 1

DEPT. GRADE OF UN.TOL. SCALE WEIGHT(K.G.) REF. TO ASSY.DWG. ITEM NO. NO. OF

01 05.04.19 APPD. SDB 11/10/19 APPD. AS 06.10.18 VAR.



BHARAT HEAVY ELECTRICALS LTD. BHOPAL

SCALE

7.0

34303392077


REV.	DATE	ALTERED BY	REV.	DATE	ALTERED BY
03	03.06.20	APPD. KD	02	17.10.19	APPD. KD
HOLES SHIFTED ON 583 PCD.					


4 HOLES M8 ADDED.

STATOR END CLAMPING RING

DRAWING NO. 3 430 33 92 077

REV. 05

	<h1 style="margin: 0;">CORPORATE PURCHASING SPECIFICATION</h1>	<div style="border-bottom: 1px solid black; padding: 2px;">AA10108</div> <div style="border-bottom: 1px solid black; padding: 2px;">Rev No. 11</div> <div style="padding: 2px;">PAGE 1 of 2</div>			
<h2 style="margin: 0;">STRUCTURAL STEEL-STANDARD QUALITY</h2> <h3 style="margin: 0;">(PLATES, SECTIONS, STRIPS, FLATS & BARS)</h3> <h3 style="margin: 0;">(ORDERING DESCRIPTION)</h3>					
<p>1.0 GENERAL:</p> <p>This specification governs the quality requirements of structural steel plates, strips, flats, bars and sections such as angles, beams, channels and tees etc. of IS: 2062 – 2011, Gr: E250, Quality A</p> <p>2.0 APPLICATION:</p> <p>For general engineering purpose.</p> <p>3.0 CONDITION OF DELIVERY:</p> <p>Plates, Bars & Sections: Hot rolled in straight lengths without twists & Bends</p> <p>4.0 COMPLIANCE WITH NATIONAL STANDARDS:</p> <p>Material shall comply with the requirements of IS: 2062 – 2011, Gr: E250, Quality A</p> <p>Material offered to EN 10025-2:2004 Gr. S275JR is also acceptable. The tolerance on dimensions for plates shall comply with EN 10029.</p> <p>5.0 DIMENSIONS AND TOLERANCES:</p> <p>5.1 DIMENSIONS:</p> <p>5.1.1 Sizes</p> <p>Material shall be supplied to the dimensions specified on BHEL Order.</p> <p>5.1.2 Length</p> <p>Unless otherwise specified, hot rolled bars and sections shall be supplied in 3 to 6 metres length.</p> <p>5.2 Tolerances:</p> <p>5.2.1 The tolerances on hot rolled material shall comply with IS: 1852. However, no plate shall be under the specified thickness at any point.</p>					
Revisions: As per Cl. No. 38.1 of MOM of MRC-S&GPS		APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(S&GPS)			
Rev No.11	Amd No.	Reaffirmed	Prepared	Issued	Dt. of 1 st Issue
Dt:22-02-2014	Dt:	Year:	2 HPEP, Hyderabad	Corp.R&D	July, 1976

AA10108	<h1 style="text-align: center;">CORPORATE PURCHASING SPECIFICATION</h1>	
Rev No. 11		
PAGE 2 of 2		

5.2.2 Straight for hot rolled bars:

Unless otherwise specified, the permissible deviation in straightness shall not exceed 5 mm in any 1000 mm length.

6.0 HARDNESS (BRINELL):

When tested in accordance with IS: 1500, the material shall show a brinell hardness in the range of 120-156 HB.

Note: Hardness test shall be conducted only when tensile test cannot be performed.

7.0 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied.

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

The test certificate shall bear the following information.

AA10108 Rev.11 / IS:2062 Grade: E250 Quality A / EN 10025-2 Gr. S275JR,

BHEL order no., Melt no. Size, Results of chemical analysis and Mechanical tests, Supplier's name, Identification no. TC no., Signature of competent authority etc.

8.0 PACKING AND MARKING:

Plates shall be transported suitably to avoid damage during transit.

For plates below 10 mm thick, each pile (preferably of 16 plates) and each plate 10 mm thick & over shall be marked with melt no. AA10108, BHEL order no., Supplier's name, Identification no., Size & weight on any one corner and encircled with paint preferably of white colour.

9.0 REFERRED STANDARDS (Latest publications including amendments):

1) IS: 1500 2) IS: 1852 3) EN 10029

3

Duly filled Technical Pre-Qualification Requirements to be submitted along with the offer by vendor

[For uploading with enquiry]

Ref No: TME/PQR/ Stator clamping ring /TA4502 rev.01

Dated: 12/12/2025

Technical Pre-Qualification Requirements (PQR) for “Stator clamping ring”

Vendor should comply with the following clauses in order to qualify for supply of Stator clamping ring (duly filled PQR shall be submitted along with the offer by vendor):

Cl. No.	Description	Vendor to comment	
		Complied / Not complied	Supporting relevant document to be submitted along with offer
1.	Vendor shall supply Stator clamping ring as per drawing no. & description mentioned in the enquiry.	Yes/No	Not Required
2.	Vendor should be a manufacturer and not a trader.	Manufacturer/ Trader	Not Required
3.	The vendor should have experience of successfully manufacturing & supplying any component involving turning of inner diameter of min. 550 mm , in preceding 5 years from enquiry opening date. Vendor to ensure that documents submitted for b) & c) shall correlate with the submitted P.O. copy.	Yes/No	a. PO copies. b. Drawing of supplied item. c. Supply proof i.e. invoice.
4.	For verification of information furnished by vendor, additional documents, proofs etc. may be required by BHEL. Vendor to confirm providing the same.	Yes/No	Not Required

Notes:

1. Compliance of all the points in above T-PQR is mandatory. In absence of compliance of above & non-submission of documents required against the T-PQR, the vendor's offer is liable to be rejected.
2. Information / compliance / documents submitted by vendor shall be authentic in all aspects. In case any deviation / false information / forged documents are observed, BHEL is free to initiate appropriate punitive proceeding against the supplier.

Important: This document is to be filled and submitted along with the offer. This document must be signed by authorized representative of the vendor and should contain the name of representative & seal of the company.



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

QUALITY ASSURANCE PLAN FOR STATOR END CLAMPING PLATE TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. – QAP/QTM/VENDOR QAP/2020-21/STATOR END CLAMPING PLATE DTD 31.08.2021 REV 00
Reference Document- PO DRAWING/SPECIFICATION

Page : 1 of 1

SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TP/A					
1)	Raw material	All tests	TC verification	100%	100%	AA10115	As per Specification	MTC	BHEL/TP/A	TEST LAB NABL/EQUIVALENT ACCREDITED/SOURCE MILL /Supplier to get the raw material TC correlated with material TC
2)	Dimension	Dimension	TC verified & Measurement	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	ALL CTQ dimension to be Witnessed
3)	Visual	Burr, Sharp edges, surface finish	visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	witness
4)	Identification vendor name, PO & job serial no.	Visual	Visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TP/A	Witness

Prepared By

U.S. Rathore
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B.H.E.L., BHOPAL

Approved By

U.S. Rathore