

**BHARAT HEAVY ELECTRICALS LTD.  
MM-SUB CONTRACTING DEPTT.  
HEEP, HARIDWAR**

**SUBJECT : EXPRESSION OF INTEREST FOR MACHINING AND ASSEMBLY OF S.T.  
COMPONENTS/SUB ASSEMBLIES**

Bharat Heavy Electricals Limited, HEEP, Haridwar , a leading Power Generating Equipment manufacturing organization, is looking for reputed vendors for and machining of Steam Turbine major components like ESV and IVCV Casings, Longitudinal Girders, LP Outer Casing, LP Inner Inner Casing, LP Inner Outer Casing, LP Front/Rear Wall, HP/IP Inner and Outer Casings, HP/IP Rotors, Pedestals, Stellite Components (Machining with Stellite), Governing Servo Motors(Complete machining of its components and assembly) etc., weighing 10 to 60 Tons.

SL	DESCRIPTION	BROAD PARAMETERS OF CRITICAL FACILITY	REMARKS
1	IV & CV CASING	CNC H. BORING – ROTARY TABLE – 3.5M X 4M (LOAD CAPACITY – 50T APROX.) & WITH BORING HEAD 2.5M	
2	ESV CASING	CNC H. BORING – ROTARY TABLE – 3M X 3M (LOAD CAPACITY – 40T APROX.) & WITH BORING HEAD 1.7M	
3	MACHINING AND HARD COATING STL-6/NICRO 82	SPECIAL STELLITE COATING PROCESS. AS PER BHEL SPECIFICATIONS	
4	MACHINING AND COATING OF POWDER HS 75-25	SPECIAL STELLITE COATING PROCESS AS PER BHEL SPECIFICATIONS	
5	LP INNER INNER CASING	CNC H. BORING 4M X 4M X 2M, (LOAD CAPACITY – 20T APROX.), CNC VTL – TABLE DIA 6.5M X HEIGHT – 4M	
6	LP INNER OUTER CASING	CNC H. BORING 10M X 5M X 2M, (LOAD CAPACITY – 50T APROX.), CNC VTL – TABLE DIA 10M X HEIGHT – 5M	
7	LP FRONT WALL	CNC H. BORING 11M X 5M X 1M, (LOAD CAPACITY – 20T APROX.), BED SIZE 11M X 6M	
8	LPC OUTER CASING	CNC H. BORING 11M X 5M X 1M, (LOAD CAPACITY – 20T APROX.), BED SIZE 11M X 6M	
9	LONG. BEAM	CNC H. BORING 11M X 5M X 1M, (LOAD CAPACITY – 20T APROX.), BED SIZE 11M X 6M	
10	HP/IP INNER CASING	CNC H. BORING ROTARY TABLE (3M X 3M) X 4M(Y AXIS) X 2M(Z AXIS), (LOAD CAPACITY – 50T APROX.), CNC VTL – TABLE DIA 4M X HEIGHT – 4M(LOAD CAPACITY – 50T APROX.)	

11	HP OUTER CASING	CNC H. BORING ROTARY TABLE (4M X 4M) X 4M(Y AXIS) X 2M(Z AXIS), (LOAD CAPACITY – 80T APROX.), CNC VTL – TABLE DIA 5M X HEIGHT – 4M(LOAD CAPACITY – 60T APROX.)	
12	IP OUTER CASING	CNC H. BORING ROTARY TABLE (4M X 4M) X 5M(Y AXIS) X 2M(Z AXIS), (LOAD CAPACITY – 80T APROX.), CNC VTL – TABLE DIA 7.5M X HEIGHT – 5M(LOAD CAPACITY – 60T APROX.)	
13	HP ROTOR	CNC LATHE – SWING OVER BED 1.3M, LENGTH – 5M, STEADY REST ESSENTIAL, DIM. ACCURACY WITH IN 0.01MM, LOAD CAPACITY – 30T APROX	
14	IP ROTOR	CNC LATHE – SWING OVER BED 1.3M, LENGTH – 5M, STEADY REST ESSENTIAL, DIM. ACCURACY WITH IN 0.01MM, LOAD CAPACITY – 30T APROX	
15	GOVERNING SERVO MOTOR ASSEMBLY	MEDIUM SIZE PRECISION MACHINE TOOLS WITH SIMILAR ASSEMBLY EXPERIENCE.	
16	PEDESTALS	H. BORING 4M X 3M X 2M, (LOAD CAPACITY – 20T APROX.) WITH ROTARY TABLE	
17	STEAM STRAINERS (MS, HRH)	MEDIUM SIZE PRECISION MACHINE TOOLS WITH SIMILAR ASSEMBLY EXPERIENCE.	
18	PLATING (Mn Phos.)	RELEVANT EXPERIENCE REQUIRED	
19	PLATING (HARD CHROME)	RELEVANT EXPERIENCE REQUIRED	
20	INDUCTION HARDENING	RELEVANT EXPERIENCE REQUIRED	
21	TUBE BENDING	RELEVANT EXPERIENCE REQUIRED	

In addition to above, the supplier should have sufficient other facilities, handling facilities EOT etc and relevant experience and capability to carry out such job works as per customer's specific requirements (Drawing, Quality Plan, Third Party CHPs etc.).

Interested vendors, having such competent facilities, may please send their Organizational, Technical and Quality System details along with various fabrication/ machining and quality control facilities for our consideration to AGM(IDX), MM DEPARTMENT, 4<sup>TH</sup> FLOOR, MAIN ADMINISTRATION BUILDING, BHEL, HEERWAR, 249403.

The details may be submitted latest by 30.07.2010.

Name and address of the contact persons are as below:

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