
 BHEL GOINDWAL	TECHNICAL SPECIFICATIONS OF LAPPING MACHINE ϕ 1800 mm TENDER ENQUIRY NO. 67039 DATED 29-09-2006
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Technical specifications for ϕ 1800 mm Lapping Machine

Sr. No.	Parameter/Feature of machine	Description	Requirement	Remarks
T1.	Horizontal Lap Plate dia, ϕ mm	Effective size available for lapping	1800 mm	
T2.	Facing of plate	Serrated	Radially outward serrated	
T3.	Material of plate		High density Cast Iron	
T4.	Conditional rings	Rings placed on lapping plate so that each ring accommodate different size jobs	Four conditional rings.	
		Internal dia of each conditional ring	To easily accommodate and lap jobs of dia upto ϕ 675 mm	
		Material of rings	High density cast iron serrated	


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T5.	Workpiece	Machined hardfaced surface having max 40 HRC	Surface finish 0.4 Ra	Uniform surface finish
T6.	Work table		Adjustable to maintain lap plate flatness and uniform wear	
T7.	Abrasive Supply	Lap slurry to be fed	Arrangement for continuous feed from a storage tank with flow control with separate waste tank.	
		Capacity	40 Ltrs	
T8.	Cycle time control		Automatic variable range time setting from 3 to 60 min to select any time with one min step	
T9.	Control Panel		Control panel with On/Off switches, Time setting switch and slurry feed control with proper indications.	

General Technical	
GT1	All motors and pumps used shall be any of GE / Siemens/ Crompton Greaves /Kirloskar/Rajamane/Bharat Bijlee/Bonfiglioli
GT2	All gearings used shall be any of Sudarshan Gears/Shanthi Gears/Elecon/Greaves.
GT3	The machine structure should be of stress relieved steel, ensuring rigidity and vibration less operation.
GT4	Height of working table should not exceed 1.5 mtrs from floor.
GT5	Tool kit for general maintenance shall be supplied

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General
Bidder to furnish complete details in separate techno-commercial and price bids.
Bidder to furnish reference list of customers to similar machines have been supplied.
Machine to be offered for inspection before dispatch.
Machine to be guaranteed for a minimum period of 12 months from date of commissioning
Commissioning of machine at IVP Goindwal works to be done by supplier.
Three sets of Operation & Instruction manual shall be supplied.
List of recommended spares and accessories to be supplied.

IMPORTANT:

Bidder should furnish technical bid STRICTLY as per the format below.

BHEL Specification	Bidder's offer	Compliance with BHEL specification (Yes/No)	Deviation, if any (Description of deviation)	Bidder's Comments on deviation
Tx				
GTx				

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