

Ref: 1.Tender for 8000T Press  
 2. NIT No 3158  
 3. Enquiry No 2620700050 dt 01.08.07

Further to the pre-bid discussions held on 28<sup>th</sup> & 29<sup>th</sup> Aug 2007 following clarification is issued:

Sl.No	CLARIFICATION SOUGHT	BHEL REPLY
<b>PART-A of TENDER</b>		
<b>1</b>	<b>Clause 1.0:</b> In the absence of experience of having supplied handling facility, whether the vendor can use their customer's expertise in this field to meet the qualifying requirement	No change in Clause 1.0
<b>2</b>	<b>Clause 8.0:</b> Customer may not part with proprietary information. What is expected in the Performance Certificate	Performance Certificate is required with respect to supply and satisfactory functioning of hot forming press of min 6000T capacity for hot pressing of steel plate of minimum 10000mm x 100mm (length x thickness) as mentioned in Clause 1.0. The Performance Certificate need not contain any proprietary information with respect to products of the customer.
<b>PART-B</b>		
<b>1</b>	<b>Clause 1.2.1.9:</b> Whether it is acceptable if accuracy specification is not proved	Accuracy specification against this clause has to be proved. However it is clarified that this accuracy need not be proved in the hot forming stage, but can be proved in the final stage after cold calibration of hot formed shell
<b>2</b>	<b>Clause 1.2.2.8 &amp; 1.2.3.7:</b> Whether it is acceptable if accuracy specification is not proved	No change. Accuracy required as specified
<b>3</b>	<b>Clause 2.1.1:</b> Whether separate press can be supplied-one for dished end and another for U-Shell forming	A single press is required for U-Shell forming and Dished End Pressing
<b>4</b>	<b>Clause 2.1.1:</b> Whether it is a single press or a series of presses	It should be a single press
<b>5</b>	<b>Clause 2.2.8 to 2.2.13:</b> Whether approximate values can be furnished for reference	2.2.8. Daylight - 4900mm 2.2.9. Stroke of ram - 2700 mm 2.2.10. Stroke control accuracy +/- 1 mm 2.2.11. Fast approach down stroke speed - 12000 mm/min.

		<p>2.2.12. Return Speed - 7500 mm/min.</p> <p>2.2.13. Clear distance between columns:</p> <p>a) Between front &amp; back column - 7000 mm</p> <p>b) Between right &amp; left column - 6000 mm.</p> <p>However vendors have to furnish the exact values based on the job specification and their design</p>
6	<b>Clause 3.0 and 4.0:</b> Makes for items specified under clause 3.0 and 4.0 may please be furnished	NEEL / AEI / DELTA / POWER AID, or equivalent reputed make

In addition to the above, the following clarification is also issued

Sl.No	CLAUSE	BHEL CLARIFICATION / CHANGE
<b>PART-B</b>		
1	<b>Clause 1.2.2.1: Plate thickness Range (Cold Pressing):</b>	No Change: 25 to 100mm. However please note that for the higher plate thickness in the range above, the Internal diameter can go above that specified in Clause 1.2.2.4, if required, to maintain permitted outer fiber elongation within 3.5% mentioned in Clause 1.2.2
2	<b>Clause 2.2.33:</b>	It should be possible to adjust the deflection compensation, tilt, bending stroke etc during pressing operation <b>(however, not when pressing force is being applied)</b>
3	<b>Clause 2.6: Job Manipulator:</b>	The following may be noted: Job manipulator may be mounted on the press or close to it. Any proposal with a overhead crane that can be mounted on BHEL shop columns or on BHEL crane girders, is not acceptable.
4	<b>Clause 2.7: Tooling:</b>	The following may be noted: A single tool shall be provided for hot forming, cold forming, and cold calibration of U-Shell
5	<b>Clause 17.1:</b>	The following is added: "One additional plate each, for U-Shell formation and hemispherical / dished end forming, shall be provided by BHEL free of charge at BHEL for trial and initial setting of press