

TECHNICAL SPECIFICATIONS
CAST IRON BED PLATES , SIZE 3M * 1.5M

1.0 PURPOSE :

Cast iron bed plates with T-slots shall be used for mounting , clamping , marking and inspection of various Steam turbine components during machining and assembly .

2.0 TECHNICAL SPECIFICATIONS :

- 2.1 Cast iron floor plates shall conform to IS:10602-1983 (Edition 1.1) . It shall be made from plain grey iron castings conforming to grade FG:220 of IS:210-1978 . Material test certificates as required by the Indian standard shall be submitted along with the supply.
- 2.2 Designation of the Floor plates shall be :
Floor plate 3000 x 1500 x 300 - 22H12 -I IS:10602
- 2.3 T-slots shall conform to IS:2013-1995 .
- 2.4 Details of wall thickness , ribbing pattern , leveling pockets and method to join the plates shall be informed by the supplier.
- 2.5 The access holes for leveling shall be suitably closed , to avoid entry of coolants,dust,chips etc. in to the pockets.
- 2.6 Load bearing capacity of the floor plate shall be specified by the supplier.
- 2.7 The surface plates shall be finish machined on their top working surface as well as four sides at their periphery . Top surface may be hand scrapped to achieve the specified flatness accuracy.
- 2.8 THE FLATNESS ACCURACY OF EACH FLOOR PLATE SHALL BE WITHIN 0.075 AS PER GRADE-I , IS:10602 . Inspection certificates with traceability shall be furnished by the supplier along with the Floor plates.
- 2.9 Machined and unmachined surfaces shall be suitably preserved .
- 2.10 Foundation details shall be informed by the Supplier. Civil work as per the details given by the supplier shall be done by BHEL. All fasteners , clamping elements etc. required for grouting , leveling and joining of each plate on all the four sides , shall be included in the offer but quoted separately.
- 2.11 Supplier shall mention and explain in detail , the method to be adopted for checking and recording the flatness accuracy during manufacture and during pre-despatch inspection by BHEL at their works .
- 2.12 To facilitate proper evaluation of the offer , Sketches / Drawings / Catalogues etc. shall be submitted by the supplier .

3.0 PRE-DESPATCH INSPECTION AND ACCEPTANCE :

- 3.1 Provisional acceptance of the Floor plates shall be made by BHEL at supplier's work prior to despatch . Test certificates , Specification compliance and flatness accuracies of the individual floor plates shall be checked and verified .

3.2 Final acceptance shall be done at BHEL .

4.0 GUARANTEE :

Supplier shall provide full and complete Warranty / Guarantee for two years trouble free performance after successful commissioning .

5.0 QUALIFYING CONDITIONS :

- 5.1 The supplier should be a reputed original Cast iron Floor plates manufacturer .
- 5.2 The supplier should have experience of manufacturing similar size Floor plates and should provide reference list of customers to whom plates of similar sizes have been supplied in the past five years, mentioning contact person of the customer, broad specification, flatness accuracies achieved & year of supply .
- 5.3 The supplier shall also indicate their max.production capacity of finished floor plates / annum in the last ten years , by providing relevant documents .