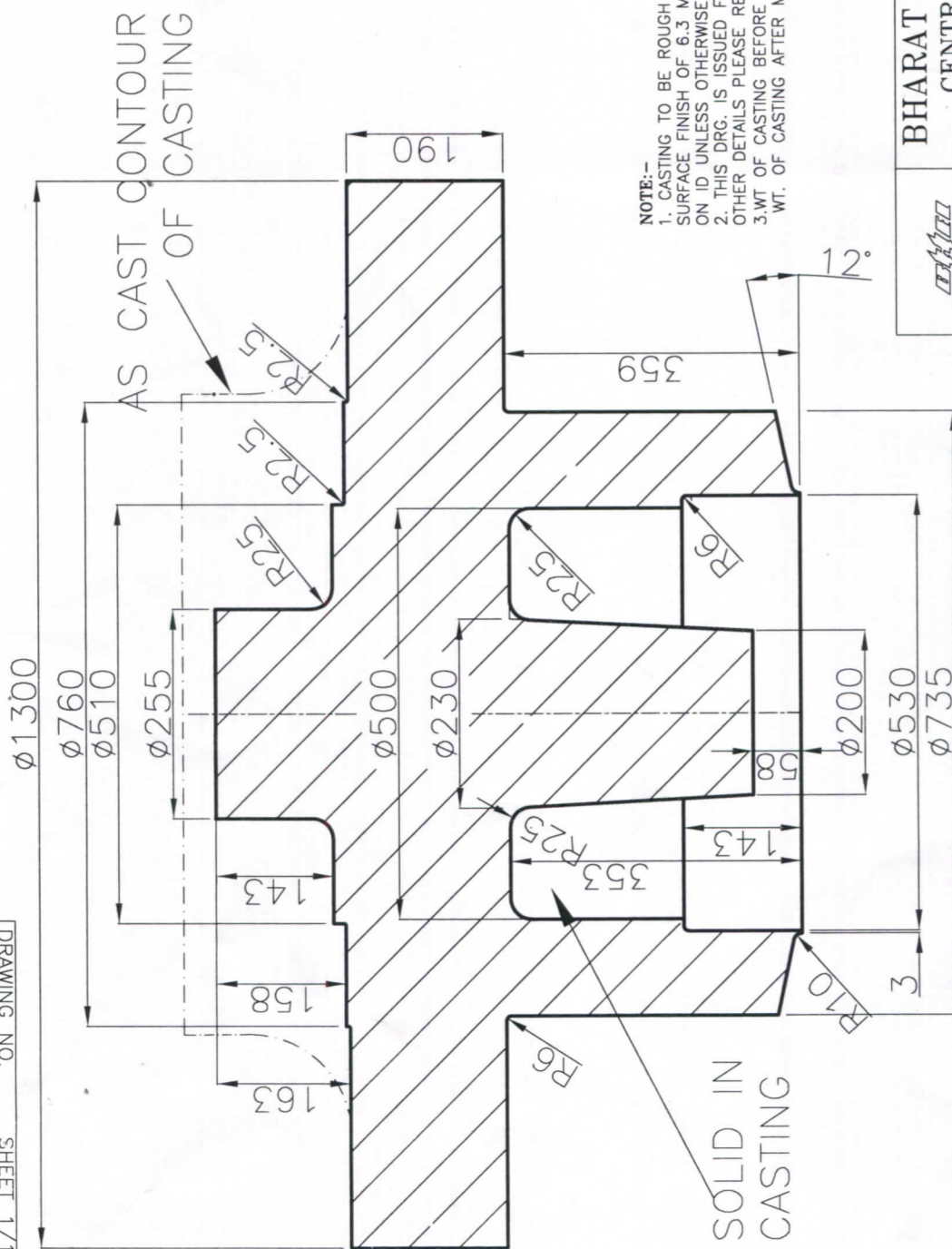


ALL OVER



NOTE:—

1. CASTING TO BE ROUGH MACHINED ALL OVER TO THE DRG. DIMENSIONS TO A SURFACE FINISH OF 6.3 MICRONS AND TOLERANCE OF +2 ON OD & HT AND -2 ON ID UNLESS OTHERWISE SPECIFIED.
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 2-113-22-56901 REV 00
3. WT. OF CASTING BEFORE M/C: 4450 KG
4. WT. OF CASTING AFTER MACHINING: 2735 KG

CONTROLLED COPY
Foundry Techno
C.No. LF/47
Date 15 JUL

BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORGE PLANT

[illegible]

MACHINING OF IP VALVE COVER (BODY)**i) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 1360 mm, height 800 mm and weight 5.0MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 5.0MT	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-113-22-56901/M1:Rev-00	Vendor to confirm
2	Vendor to arrange all tools & instruments required for machining of the job	Vendor to confirm
3	BHEL reserves the right to visit vendor for stage inspection during job machining to assess the progress and technical aspects and further processing shall be done accordingly.	Vendor to confirm
4	Final Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
5	Delivery requirement: 4-6 weeks/pc from the date of lifting	Vendor to confirm
6	Identification details on the casting to be maintained	Vendor to confirm
7	Vendor to submit following with the offer:- a) Details of the Organization b) Details of the machine tools and other facilities installed in the company	Vendor to submit
8	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
9	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bithuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K. Singh AGM (M/C Shop)
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