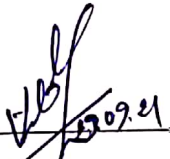
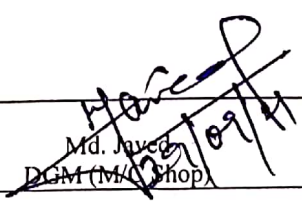
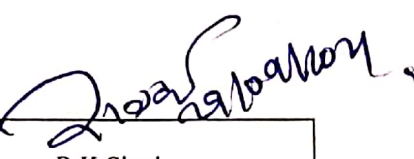


MACHINING OF VALVE CASING**i) PRE QUALIFICATION**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Vendor should have a Horizontal boring machine of Spindle Dia 100 mm or more	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity of 2.5MT or more	Vendor to Confirm and submit detail

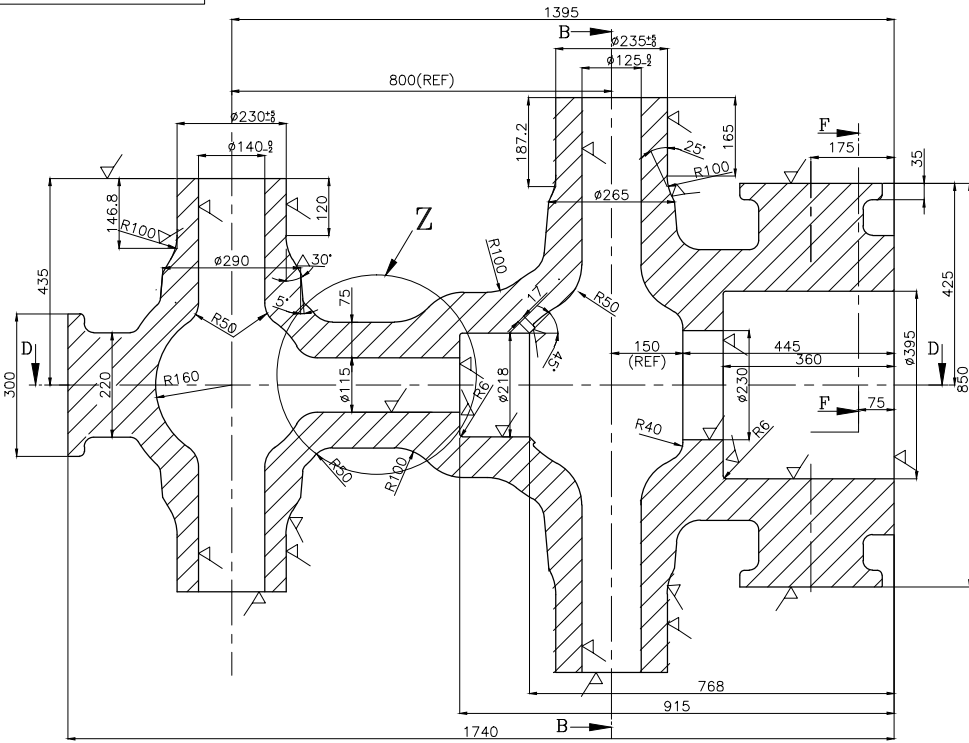
ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-112-33-56901/M:REV-A	Vendor to confirm
2	Vendor to arrange tools, instruments, template, jig, fixture, gauge etc. required for machining of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 4-6 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit Details of the Organization, Contact details, Facilities and Similar works carried out along with the offer.	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

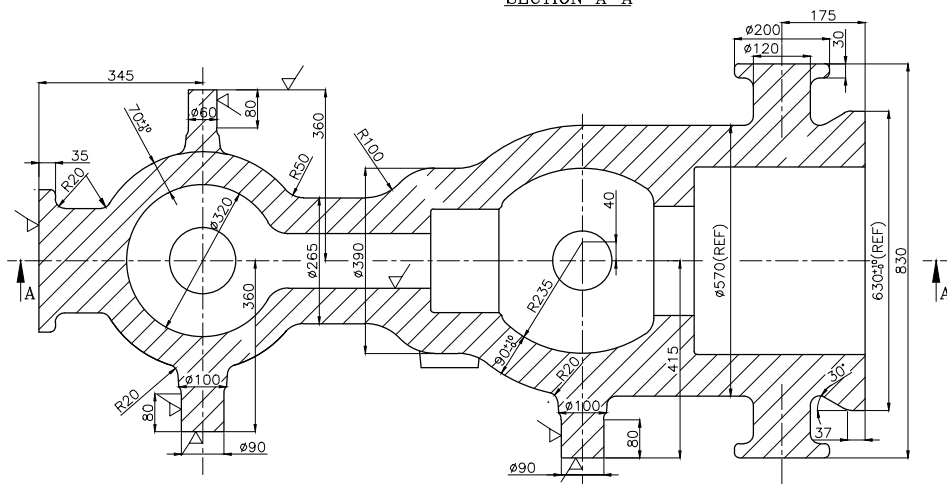
 Vikalp Bibhuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
---	--	---

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN M.M.)

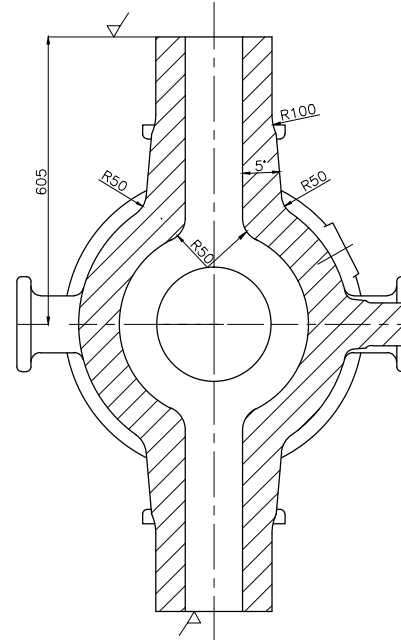
DRAWING NUMBER
0-112-41-59901/M



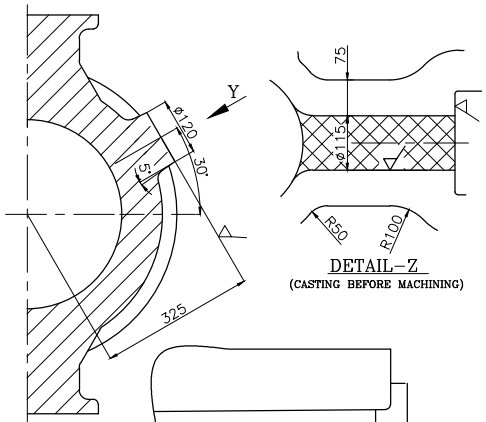
SECTION A-A



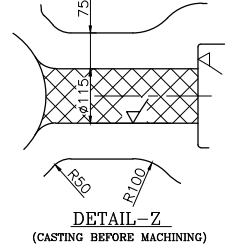
SECTION D-D



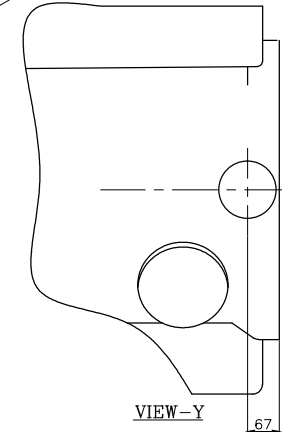
SECTION B-B



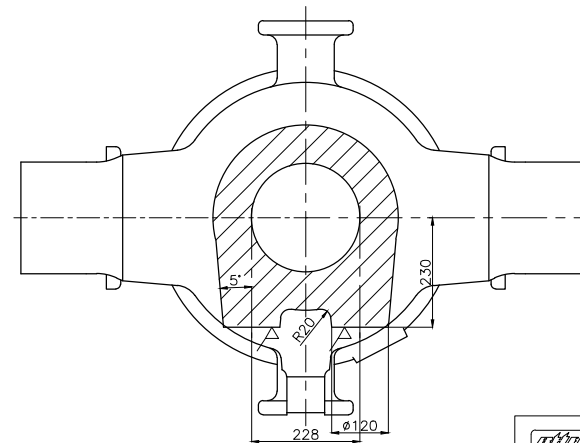
SECTION F-F



DETAIL-Z
(CASTING BEFORE MACHINING)



VIEW-Y



SECTION C-C

NOTE:-

1. CASTING TO BE ROUGH MACHINED TO ALL SURFACE MARKED TO THE DRG. DIMENSIONS OF A SURFACE FINISH OF 12.5 MICRONS AND TOLERANCE OF ON +2 -0 OD & HT AND -2 ON ID, UNLESS OTHERWISE STATED.
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-112-33-56901 REV 00
3. WT. OF CASTING BEFORE M/C: 2200 KGS
WT. OF CASTING AFTER M/C: 1895 KGS
4. MATERIAL:
0-112-41-59901: HW19688 (GX12CrMoVWbN10-1-1)
0-112-33-56901: HW19683 (GX12CrMoVbN9-1)

BHARAT HEAVY ELECTRICALS. LTD.				CENTRAL FOUNDRY FORGE PLANT				RANIPUR HARDWARE			
DEPTT.	FDY.	TECH.	SCALE	N.T.S.	WEIGHT	IN	Kgs	NAME	SIGN	DATE	
REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED
ZONE				ZONE				ZONE			
PROJECT AND CUSTOMER NAME				TECHNOLOGY NO. DRAWING NO.				0-112-33-56901/M			
STEAM TURBINE 600MW				18609				0-112-41-59901/M			
BHEL BHEL HARDWARE				18609A				SHEET NO. -			

ROUGH M/C DRG. FOR

VALVE CASING

FT/M/20-15

APPD. J.K.C.

DRN DWG/16/18609M

WKO L. AGRAWAL

CHD T. DAVE

APPD. J.K.C.