

MACHINING OF IMPELLER CONE**iii) 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. 1640 mm, height 1050 mm and weight 4.0MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 4.0MT	Vendor to Confirm and submit detail

iv) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-204-07-18402/M: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 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:- c) Details of the Organization d) 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 Bishuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K. Singh AGM (M/C Shop)
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FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

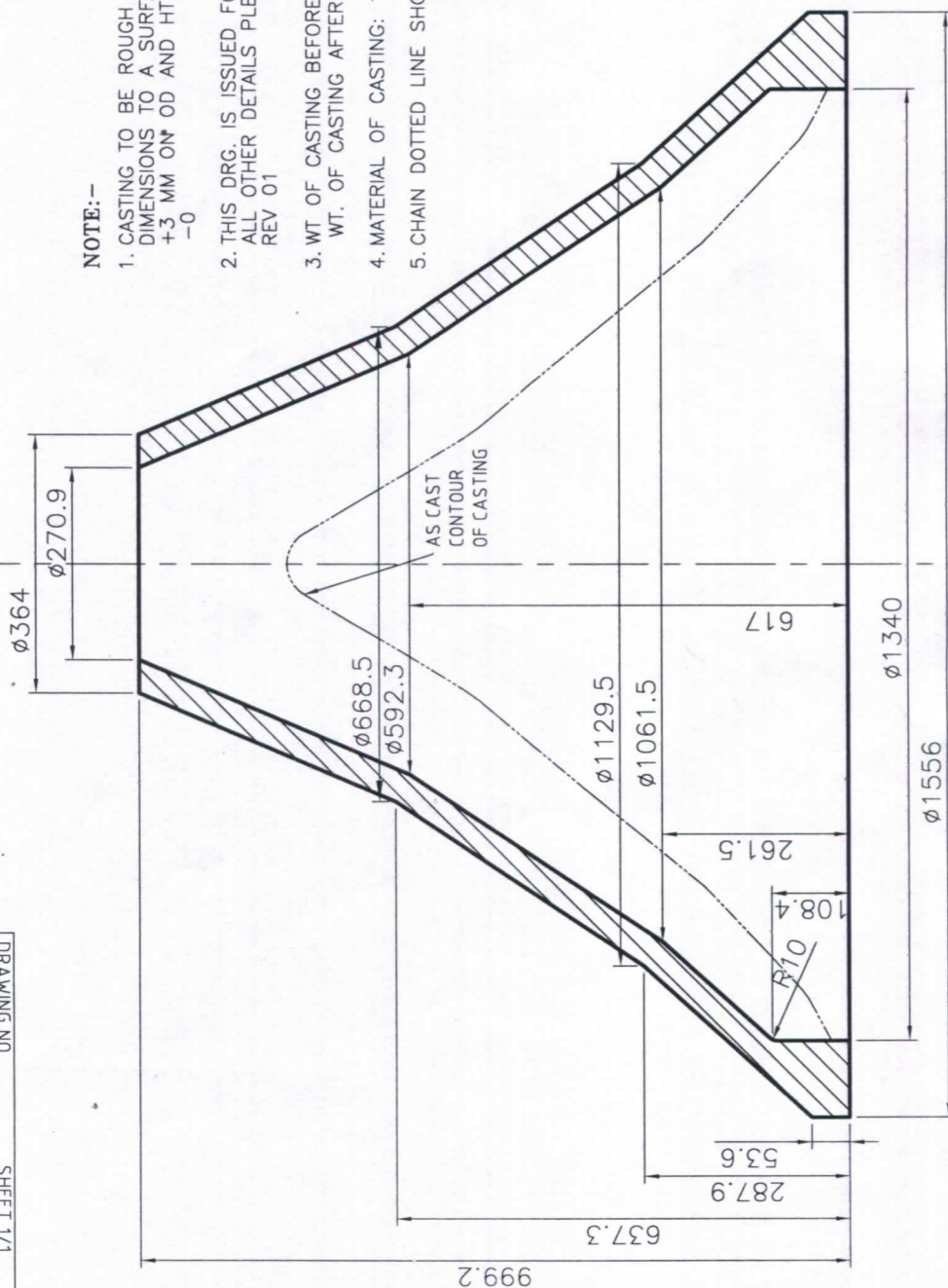
W/20781-L0-702-2
DRAWING NO.
SHEET 1/1

✓ ALLOVER

NOTE:-

1. CASTING TO BE ROUGH MACHINED ON ALL SURFACE TO THE DRAWING DIMENSIONS TO A SURFACE FINISH OF 12.5 MICRONS, WITH TOLERANCE OF +3 MM ON OD AND HT, -3 MM ON ID, UNLESS OTHERWISE SPECIFIED.
-0
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 2-204-07-18402 REV 01
3. WT. OF CASTING BEFORE M/C: 4000 KGS
WT. OF CASTING AFTER M/C: 1260 KGS
4. MATERIAL OF CASTING: 13Cr 4Ni STAINLESS STEEL
5. CHAIN DOTTED LINE SHOWS AS CAST CONTOUR OF CASTING.

CONTROLLED COPY
Foundry Technote
C.No. LF/73.....
Date.....3-0 JUL 2021



	DEPTT. - FDY. TECHY	SCALE	WEIGHT IN KG.	NAME	SIGN	DATE
	TITLE			DRN	PRANAHITA VI/23509M.DWG	
	ROUGH M/C DRG FOR			WKO	T DAVE	Sd 18.5.16
	IMPELLER CONE			CHD	R LAKRA	Sd 18.5.16
PROJECT AND CUSTOMER NAME			TECHNOLOGY NO.	DRAWING NO.		
PRANAHITA VI			23509	2-204-07-18402/M		
BHEL BHOPAL				SHEET NO.	NO. OF SHEETS	

As cast contour modified. Weight of casting before machining modified.
FT/M/2016-24

REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED

21043