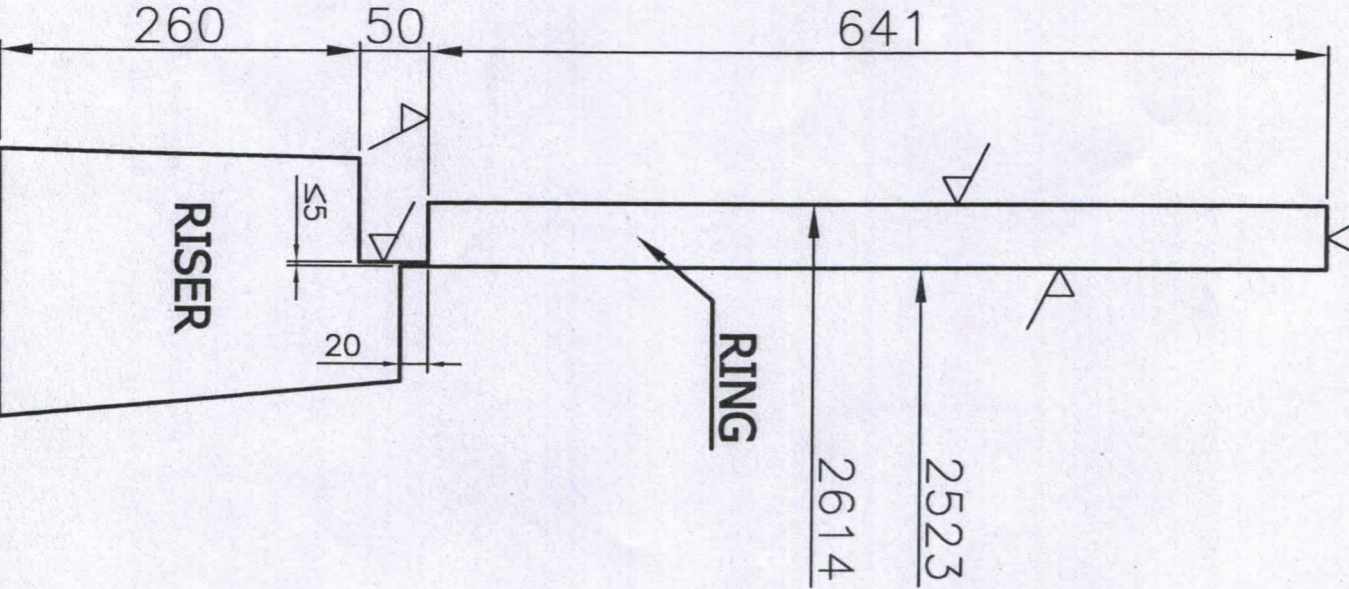




NOTE

1. CASTING TO BE ROUGH MACHINED ALL OVER TO THE DRAWING DIMENSIONS AND SURFACE FINISH 12.5 MICRONS AND TO THE TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE STATED.
-0 +0
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO PROPOSED SUPPLY SKETCH DRG. NO. 3-204-07-21602 3N1/M/P AND COMPONENT DRG NO. 3-204-07-21602 REV 00.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 8151 KGS.
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 4827 KGS.

CONTROLLED COPY
Foundry Technology
C.No. LFI/25
Date: 12 FEB 2022

REV	DATE	ALTERED	CHECKED
1			
2			
3			
4			
5			
6			
7			
8			

		BHARAT HEAVY ELECTRICALS, LTD. CENTRAL FOUNDRY FORCE PLANT RANIPUR BARDWAR	
REV DATE ALTERED CHECKED	ZONE	DEPT. FDY/TECH.	SCALE N.T.S.
TITLE ROUGH M/C DRG. FOR LOWER ROTATING LABYRINTH (3 IN 1)		PROJECT AND CUSTOMER NAME BHEL / BHOPAL	TECHNICAL NO 3-204-07-21602/M1
DRN 23/04/2021	CHKD 18/11/2021	APPD 18/11/2021	NO. OF SHEETS-1

MACHINING OF LABYRINTH RING

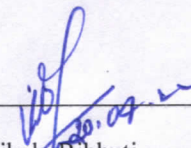
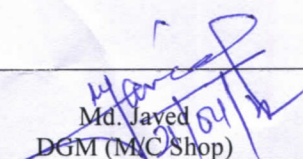
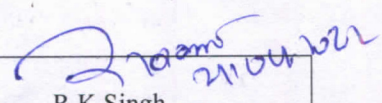
INDENT NO: 20210587

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. 2800 mm, and weight 9.0MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 9.0MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-21602/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: 5 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:- e) Details of the Organization f) 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 Bibhuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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Sh. A.K. Singh, J.
for M.A. P.I.
Date 23/04/22

Sh. Tahir
23/04/22