

MACHINING OF LABYRINTH RING

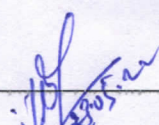
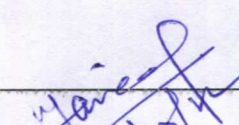
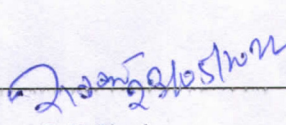
INDENT NO: 20220019

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. 3900 mm, and weight 21MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 21MT	Vendor to Confirm and submit detail

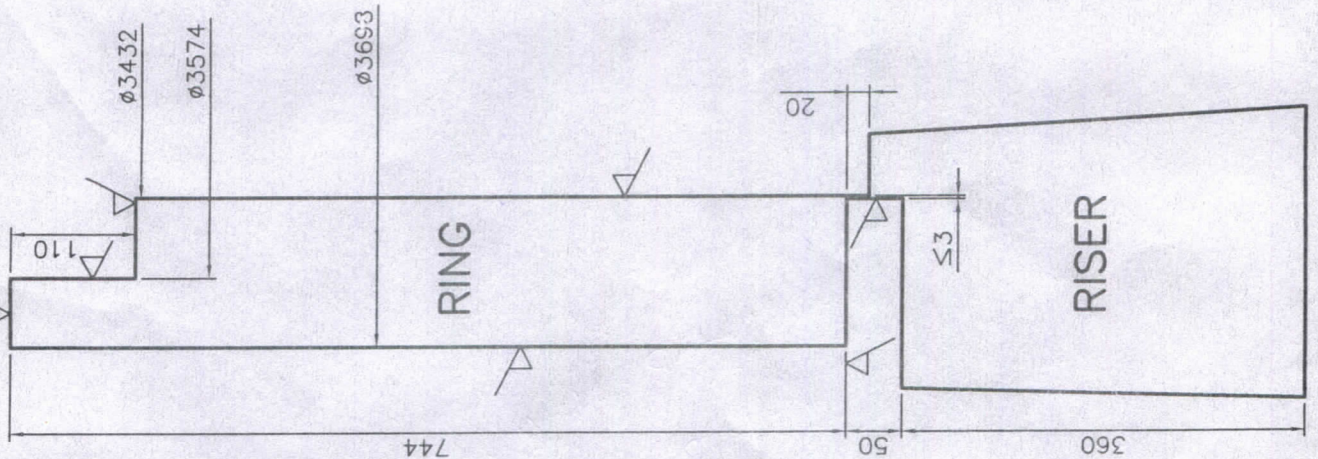
ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18101/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:- 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 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
3-204-07-18101/M1



NOTE

1. CASTING TO BE ROUGH MACHINED ON THE SURFACE ∇ MARKED 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. 3-204-07-18101 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18101 REV 01.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 20682 KGS.
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 15790 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SF/.....&.....
Date 2-8-APR-2022

		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT	
REV	DATE	ALTERED	CHECKED
ZONE			
DEPT. FOUNDRY TECH.		SCALE N.T.S.	MANIPUR HARDWARE
TITLE		ROUGH M/C DRG. FOR UPPER ROTATING LABYRINTH (4IN1)	
PROJECT AND CUSTOMER NAME		PALAMARU RR LIS - I BHEL / BHOPAL	
TECHNOLOGY NO		DRAWING NO	
23621		3-204-07-18101/M1	
SHEET NO - 1		NO. OF SHEETS - 1	

72006