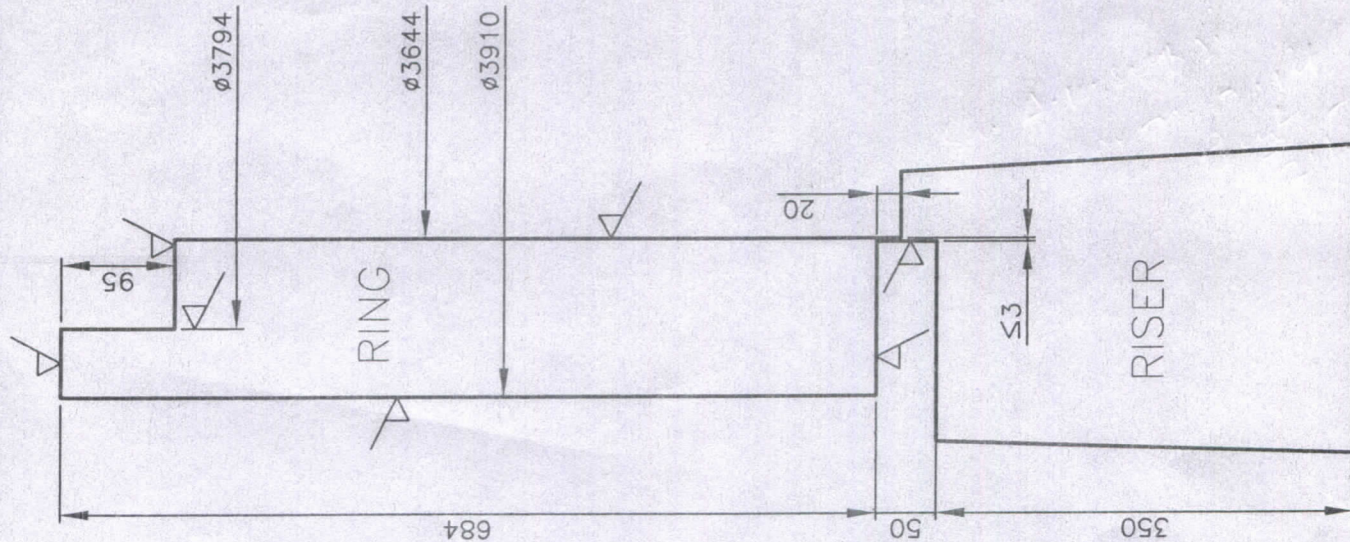


FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN M.M.)

DRAWING NUMBER
3-204-07-18401/M1



NOTE

1. CASTING TO BE ROUGH MACHINED ON SURFACES 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. $-0 \quad +0$
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO PROPOSED SUPPLY SKETCH DRG. NO. 3-204-07-18401 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18401 REV 01.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 20380 KGS.
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 15850 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SFI/1
Date 28 APR 2022



BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORGE PLANT
RANIPUR HARDWAR

REV	DATE	ALTERED	CHECKED	DEPTT.	FDY. TECH.	SCALE	N.T.S.	WEIGHT IN Kgs	NAME	DATE
ZONE										
TITLE										
ROUGH M/C DRG. FOR (4 IN 1)										
UPPER ROTATING LABYRINTH										
PROJECT AND CUSTOMER NAME										
KAJESHWARAM-12P2										
BHEL / BHOPAL										
TECHNOLOGY NO										
23623										
DRAWING NO										
3-204-07-18401/M1										
SHEET NO.-1										
NO. OFF SHEETS-1										

22008

MACHINING OF LABYRINTH RING

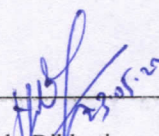
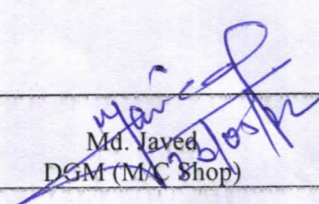
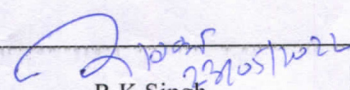
INDENT NO: 20220021

v) 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. 4110 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

vi) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18401/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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