

Δ ALLOVER

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.

2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 2-204-07-18102
REV 00

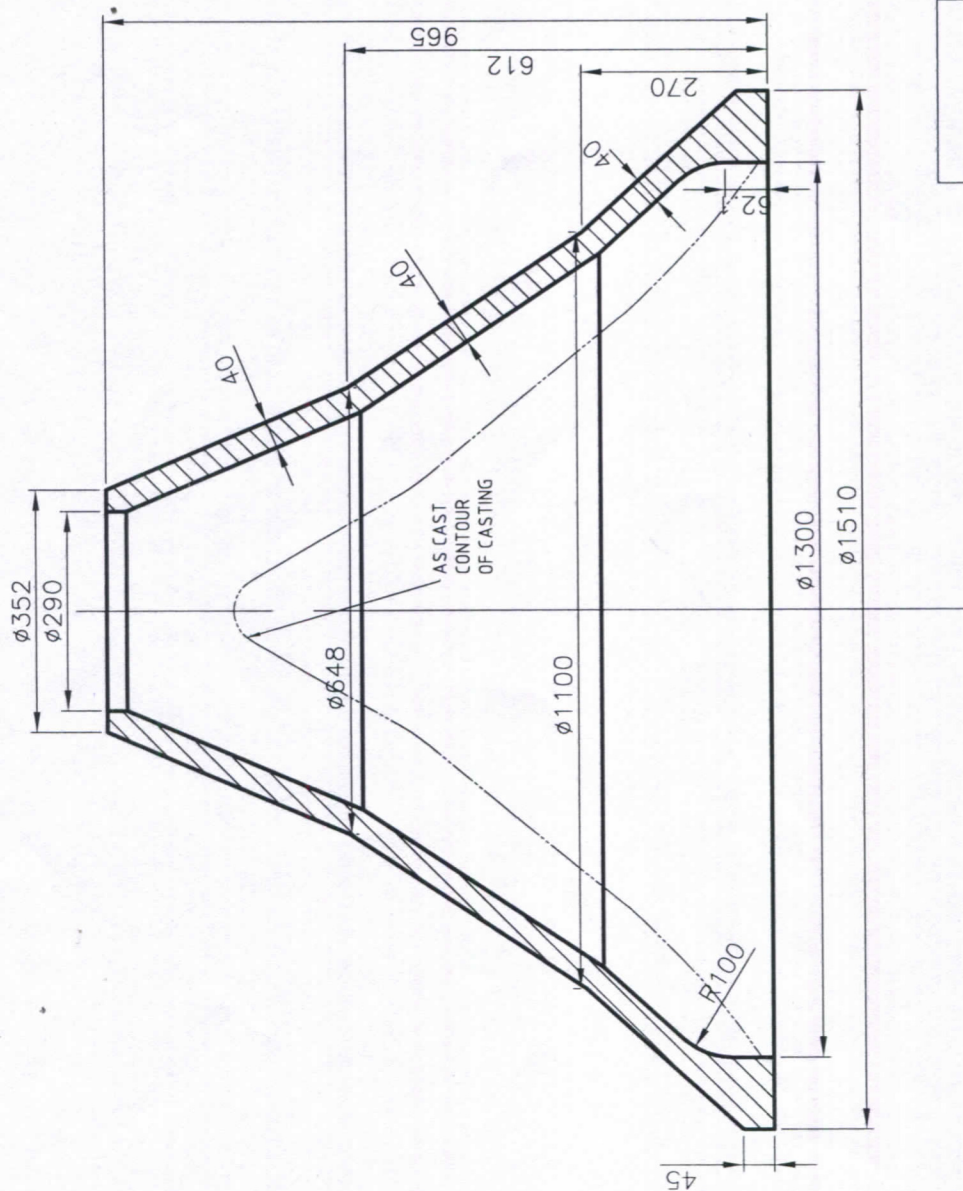
3. WT OF CASTING BEFORE M/C: 3810 KGS

WT. OF CASTING AFTER M/C: 1090 KGS

4 MATERIAL OF CASTING: 13Cr 4Ni STAINLESS STEEL

5. CHAIN DOTTED LINE SHOWS AS CAST CONTOUR OF CASTING.

CONTROLLED COPY
Foundry Technology
C.No. LF/.....72.....
Date.....30 JUN.....



	BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWAR									
	DEPTT. - FDY. TECHY			SCALE	WEIGHT IN KG.		NAME		SIGN	DATE
	TITLE									
	ROUGH M/C DRG FOR IMPELLER CONE									
	PROJECT AND CUSTOMER NAME PRANAHAITA VIII BHEI. RHOPIAL.									
	DRAWING NO. 2-204-07-18102/M									
REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE
		CHECKED			CHECKED			CHECKED		
			G	11.1.17						
As cast contour modified. Weight of casting before machining modified. TT/T/2016-23										
TECHNOLOGY NO. 23510										
SHEET NO. NO. OF SHEETS										

21045

MACHINING OF IMPELLER CONE**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. 1600 mm, height 1020 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

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-204-07-18102/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:- 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)

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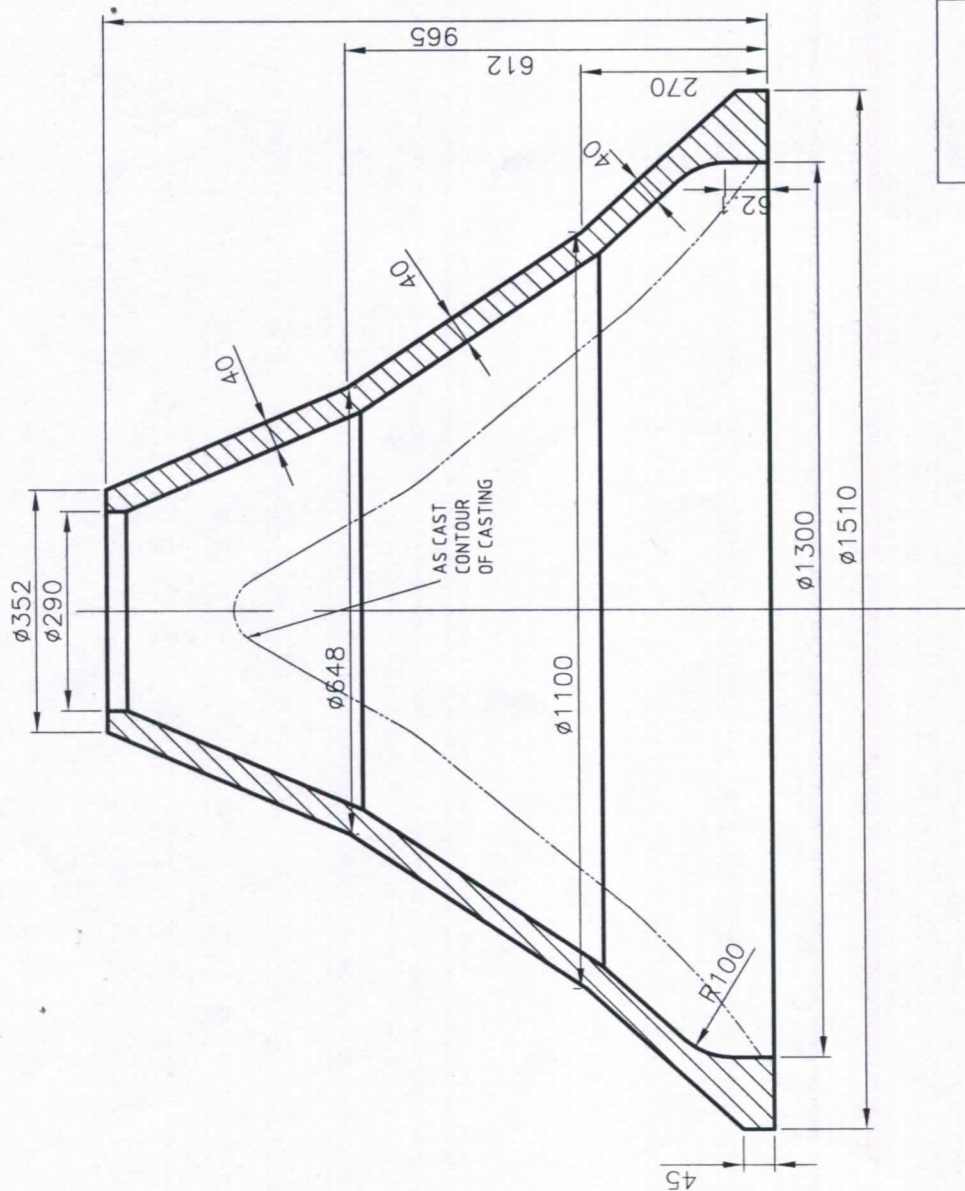
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