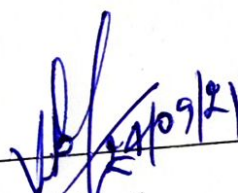
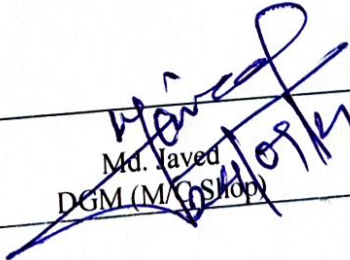
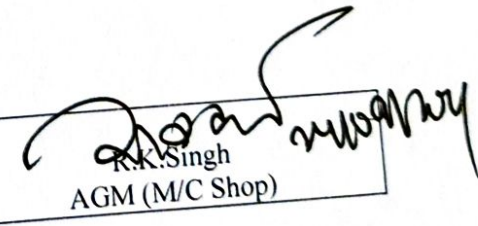


MACHINING OF IMPELLER CONE**v) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 1450 mm, height 925 mm and weight 3.0MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 3.0MT	Vendor to Confirm and submit detail

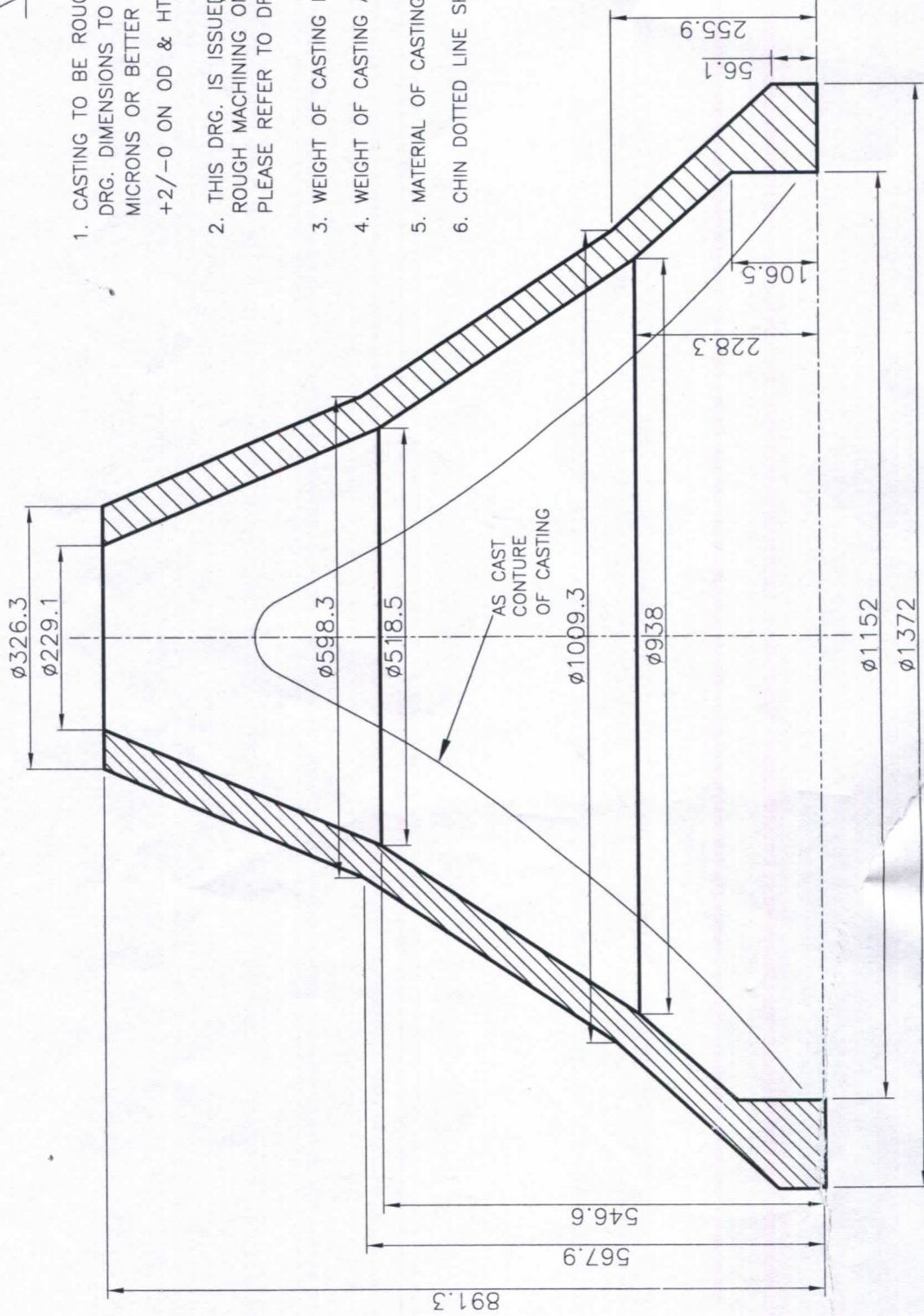
vi) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-204-07-20202/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:- 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 Bihuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
--	---	---

DRAWING NUMBER
W/20202-10-402-2

ALL OVER



1. CASTING TO BE ROUGH MACHINED ALL OVER TO DRG. DIMENSIONS TO THE SURFACE FINISH 12.5 MICRONS OR BETTER AND TO THE TOLERANCE OF +2/-0 ON OD & HT AND -2/+0 ON ID
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO DRG. NO.- 2-204-07-20202 REV-01.
3. WEIGHT OF CASTING BEFORE MACHINING: 2790 KGS
4. WEIGHT OF CASTING AFTER MACHINING: 1037 KGS.
5. MATERIAL OF CASTING: 13Cr4Ni STAINLESS STEEL.
6. CHIN DOTTED LINE SHOWS AS CAST CONTOUR OF CASTING..

CONTROLLED
Foundry Techni...
C.No. LF/.....7/
Date.....30 JUL 2021

BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORGE PLANT

DEPTT.	FDY. TECH.	SCALE	N.T.S.	WEIGHT IN Kgs	NAME	SIGN	DATE
TITLE	ROUGH M/C DRG FOR IMPELLER CONE				SRN	/23/236051.DWG	17.10.20
					WRO	RAMASHISH	-sd- 17.10.20
					CHD	AGRAWAL	-sd- 17.10.20
					APPD	R LAKRA	-sd- 17.10.20
PROJECT AND CUSTOMER NAME	PALAMURU RANGAREDDY BHEL BHOPAL	TECHNOLOGY NO	23605	DRAWING NO	2-204-07-20202/M	SHEET NO.-1	NO. OF SHEETS-1

21046