

Pre-Qualifying Requirement (PQR)
IP-LP Bearing Pedestal (Drg. no. - 01180150000)

20240602

SL. No.	REQUIREMENT	REMARKS
1.	Only those vendors should quote who have following machine, facilities installed & operational at their works for following operations for machining, assembly works of "IP-LP Bearing Pedestal (Drg. no. - 01180150000)". Casting of IP-LP Bearing Pedestal along with cover & inner casing brackets (casting drg. no. 01180150901) shall be supplied to vendor. Refer Scope of work details provided.	Vendor to confirm.
1.A.	Vendor must have suitable toolings / facility such as Marking Table / Machine Bed etc. in good working condition, to facilitate marking / transfer marking of job (as required). Vendor must have suitable facility for lifting / handling the subject job.	Vendor to confirm.
1.B.	Horizontal Boring work :-	
1.B.i.	Vendor must have suitable CNC Horizontal Boring machine with suitable attachments (like Right angle Milling head, Boring & Facing head, Rotary table etc.) for machining of joint plane, holes, pocket, slot, details, bores etc. in Bearing Pedestal and cover, individually & in assembled condition as per drawing, TR & scope of work requirements.	(a) Vendor to confirm. (b) Vendor to provide machine details / specification for referred operation.
1.C.	Drilling work :-	
1.C.i.	Drilling machine suitable for machining of holes, threaded holes etc. as per drawing, TR & scope of work requirements.	(a) Vendor to confirm. (b) Vendor to provide machine details / specification for referred operation.
1.D.	Fitting work :-	
1.D.i.	Vendor must have suitable facility / arrangement for different fitting / assembly works to be done at different stages of IP-LP Bearing Pedestal manufacturing as per drawing, TR & scope of work requirements.	Vendor to confirm.
2	Vendor to confirm that above machines (as per pt. no. 1.A to 1.C) are available at their works & are in good working condition with capability of achieving accuracies, surface finish & tolerances as per drawing requirements. If necessary, Vendor can suggest alternate machines (other than specified in pt. no. 1.A to 1.C) for machining job with accuracies, surface finish & tolerances as per drawing, for review & acceptance by BHEL.	Vendor to confirm & submit details.
3	Front and rear sealing surfaces (bearing seal ring) and bores B & C of both the pedestal and cover to be machined in one operation as per TR no. 2 of drg.	Vendor to note & agree.
4	Leak test (as per TR no. 4 of drg.) and Hydro test (as per TR no. 5 of drg.) will be done at HEEP, BHEL Haridwar.	Vendor to note & agree.
5	Transfer marking of holes from Cover to pedestal casing to be done. Also, item no. 2 of bearing pedestal (cover) to be jointly finished.	Vendor to note & agree.
6	Vendor to confirm that all the dimensions, accuracies & surface finish of the component shall be met as per Technical Requirements & drawing.	Vendor to confirm.
7	Vendor to note that all tools, measuring equipments, technological items etc. required for manufacturing of subject item shall be arranged by vendor, in case of order.	Vendor to confirm.
8	BHEL reserves the right to verify the information provided by vendor. BHEL may also visit vendor works if so desired by BHEL. In case, the information provided by vendor is found to be false/ incorrect, their offer shall be rejected.	Vendor to note & agree.

(I K Ranjan)
Mgr. (TTX)

(Sachin Maggu)
Mgr. (NCT)

Pre-Qualifying Requirement (PQR)
LP-GEN Bearing Pedestal (Drg. no. - 01180350000)

I-20240603

SL. No.	REQUIREMENT	REMARKS
1	Only those vendors should quote who have following machine, facilities installed & operational at their works for following operations for machining, assembly works of "LP-GEN Bearing Pedestal (Drg. no. - 01180350000)". Casting of LP-GEN Bearing Pedestal along with cover & inner casing brackets (casting drg. no. 01180350901) shall be supplied to vendor. Refer Scope of work details provided.	Vendor to confirm.
1.A.	Vendor must have suitable toolings / facility such as Marking Table / Machine Bed etc. in good working condition, to facilitate marking / transfer marking of job (as required). Vendor must have suitable facility for lifting / handling the subject job.	Vendor to confirm.
1.B.	<u>Horizontal Boring work :-</u>	(a) Vendor to confirm.
1.B.i.	Vendor must have suitable CNC Horizontal Boring machine with suitable attachments (like Right angle Milling head, Boring & Facing head, Rotary table etc.) for machining of joint plane, holes, pocket, slot, details, bores etc. in Bearing Pedestal and cover, individually & in assembled condition as per drawing, TR & scope of work requirements.	(b) Vendor to provide machine details / specification for referred operation.
1.C.	<u>Drilling work :-</u>	(a) Vendor to confirm.
1.C.i.	Drilling machine suitable for machining of holes, threaded holes etc. as per drawing, TR & scope of work requirements..	(b) Vendor to provide machine details / specification for referred operation.
1.D.	<u>Fitting work :-</u>	
1.D.1.	Vendor must have suitable facility / arrangement for different fitting / assembly works to be done at different stages of LP-GEN Bearing Pedestal manufacturing as per drawing, TR & scope of work requirements.	Vendor to confirm.
2	Vendor to confirm that above machines (as per pt. no. 1.A to 1.C) are available at their works & are in good working condition with capability of achieving accuracies, surface finish & tolerances as per drawing requirements. If necessary, Vendor can suggest alternate machines (other than specified in pt. no. 1.A to 1.C) for machining job with accuracies, surface finish & tolerances as per drawing, for review & acceptance by BHEL.	Vendor to confirm & submit details.
3	Front and rear sealing surfaces (bearing seal ring) and bores B & C of both the pedestal and cover to be machined in one operation as per TR no. 1 of drg.	Vendor to note & agree.
4	Gravity test for leaks (as per TR no. 5 of drg.) and Hydro test (as per TR no. 7 of drg.) will be done at HEEP, BHEL Haridwar.	Vendor to note & agree.
5	Transfer marking of holes from Cover to pedestal casing to be done. Also, item no. 2 of bearing pedestal (cover) to be jointly finished.	Vendor to note & agree.
6	Vendor to confirm that all the dimensions, accuracies & surface finish of the component shall be met as per Technical Requirements & drawing.	Vendor to confirm.
7	Vendor to note that all tools, measuring equipments, technological items etc. required for manufacturing of subject item shall be arranged by vendor, in case of order.	Vendor to confirm.
8	BHEL reserves the right to verify the information provided by vendor. BHEL may also visit vendor works if so desired by BHEL. In case, the information provided by vendor is found to be false/ incorrect, their offer shall be rejected.	Vendor to note & agree.

(I K Ranjan)
Mgr. (TTX)

(Sachin Maggu)
Mgr. (NCT)

Pre-Qualifying Requirement (PQR)
LP-LP Bearing Pedestal (Drg. no. - 01182450000)

I - 20240604

SL. No.	REQUIREMENT	REMARKS
1	Only those vendors should quote who have following machine, facilities installed & operational at their works for following operations for machining, assembly works of "LP-LP Bearing Pedestal (Drg. no. - 01182450000)". Casting of LP-LP Bearing Pedestal along with cover & inner casing brackets (casting drg. no. 01182450901) shall be supplied to vendor.	Vendor to confirm.
1.A.	Vendor must have suitable toolings / facility such as Marking Table / Machine Bed etc. in good working condition, to facilitate marking / transfer marking of job (as required). Vendor must have suitable facility for lifting / handling the subject job.	Vendor to confirm.
1.B.	Horizontal Boring work :-	(a) Vendor to confirm.
1.B.i.	Vendor must have suitable CNC Horizontal Boring machine with suitable attachments (like Right angle Milling head, Boring & Facing head, Rotary table etc.) for machining of joint plane, holes, pocket, slot, details, bores etc. in Bearing Pedestal and cover, individually & in assembled condition as per drawing, TR & scope of work requirements.	(b) Vendor to provide machine details / specification for referred operation.
1.C.	Drilling work :-	(a) Vendor to confirm.
1.C.i.	Drilling machine suitable for machining of holes, threaded holes etc. as per drawing, TR & scope of work requirements.	(b) Vendor to provide machine details / specification for referred operation.
1.D.	Fitting work :-	
1.D.1.	Vendor must have suitable facility / arrangement for different fitting / assembly works to be done at different stages of LP-LP Bearing Pedestal manufacturing as per drawing, TR & scope of work requirements.	Vendor to confirm.
2	Vendor to confirm that above machines (as per pt. no. 1.A to 1.C) are available at their works & are in good working condition with capability of achieving accuracies, surface finish & tolerances as per drawing requirements. If necessary, Vendor can suggest alternate machines (other than specified in pt. no. 1.A to 1.C) for machining job with accuracies, surface finish & tolerances as per drawing, for review & acceptance by BHEL.	Vendor to confirm & submit details.
3	Front and rear sealing surfaces (bearing seal ring) and bores B & C of both the pedestal and cover to be machined in one operation as per TR no. 1 of drg.	Vendor to note & agree.
4	Gravity test for leaks (as per TR no. 5 of drg.) and Hydro test (as per TR no. 7 of drg.) will be done at HEEP, BHEL Haridwar.	Vendor to note & agree.
5	Transfer marking of holes from Cover to pedestal casing to be done. Also, item no. 2 of bearing pedestal (cover) to be jointly finished.	Vendor to note & agree.
6	Vendor to confirm that all the dimensions, accuracies & surface finish of the component shall be met as per Technical Requirements & drawing.	Vendor to confirm.
7	Vendor to note that all tools, measuring equipments, technological items etc. required for manufacturing of subject item shall be arranged by vendor, in case of order.	Vendor to confirm.
8	BHEL reserves the right to verify the information provided by vendor. BHEL may also visit vendor works if so desired by BHEL. In case, the information provided by vendor is found to be false/ incorrect, their offer shall be rejected.	Vendor to note & agree.

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