



Pre-Qualifying Requirement (PQR)		
HP OUTER CASING- INLET END (Drg. no. - 01052630000) (Complete Finish Machining)		Indent No..... 2024 0676
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, fitting works of "HP Outer Casing- Inlet End" as per Drg. No. 01052630000 . Raw material casting (Drg. No. 01052630901) shall be supplied to vendor after control marking for complete finish machining as per drawing.	Vendor to confirm.
2	Vendor must have suitable tooling / facility such as Marking Table / Machine Bed etc. in good working condition, to facilitate marking. Vendor must have suitable facility for lifting / handling the subject job.	Vendor to confirm.
3	Turning / Vertical Boring Operation :-	
3.1	CNC Vertical Boring Machine, suitable for Vertical Boring of HP Outer Casing- Inlet End as per drawing & T.R.'s requirement. Machine Requirement : (a) Table diameter of machine = 4000 mm or more. (b) Maximum Turning Height of job = 2800 mm or more. (c) Ram Stroke = 2600 mm or more (d) Weight capacity of machine = 45 Tons or more.	(a) Vendor to confirm. (b) Vendor to provide machine details / specification for referred operation.
4	Horizontal Boring work :-	
4.1	Vendor must have suitable CNC Horizontal Boring machine with suitable attachments (i.e. UT-800 or UT-1000 or equivalent) for machining of different details, holes, Threaded holes, Slots as per Drg. and TR requirement. Required Machine details as below : (i) SPINDLE + RAM (Movement) : 2000 mm (ii) X-AXIS : 4000 or more, Y-AXIS : 3500 mm or more, (iii) TABLE SIZE : 3000 x 3000 mm or more (iv) WEIGHT CAPACITY – 45 Ton or more.	(a) Vendor to confirm. (b) Vendor to provide machine accuracies & Geometrical details / specification for referred operation.
5	Vendor need to submit manufacturing process, tooling used for machining Butress threads.	Vendor to submit details
6	Fitting work :-	
6.1	Vendor must have suitable facility / arrangement for different fitting / assembly works to be done as per drawing & TR.	Vendor to confirm.
7	Vendor to confirm that above machines (as per pt. no. 3 & 4) 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. 3 & 4) for machining job with accuracies, surface finish & tolerances as per drawing, for review & acceptance by BHEL.	Vendor to confirm & submit the machine accuracies & Geometry details along with specification.
8	Vendor to confirm that all the dimensions, accuracies & surface finish of the component shall be met as per Technical Requirements & drawing.	Vendor to confirm.
9	Vendor to note that all tools, measuring equipment, technological items etc. required for manufacturing of subject item shall be arranged by vendor, in case of order.	Vendor to confirm.
10	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 & Confirm.


 (I K Ranjan)
 Mgr. (TTX)


 (R P Singh)
 Sr. Mgr. (NCT)