

TTX/PQR/2025/154.

PQR for Indent no:

SL.No	REQUIREMENT	REMARKS
1.	Only those vendors should quote who have following machine installed & operational at their works for following operations of ESVCV Casing drawing no 01122230035/00 and 01122230035/01: -	Vendor to Note
A.	Milling Operation: -	
i.	Horizontal Boring machine with rotary table and suitable to accommodate the job. Machine should be capable to carry out all milling operation as per drawing and Technical requirement. <ul style="list-style-type: none"> Rotary table: 3 m X 3 m Table Loading Capacity: 25 T or more 	Vendor to confirm & submit machine details. Vendor should also submit positional accuracy and runout of the machine.
B.	Turning Operation: -	
	CNC Horizontal Boring machine with rotary table and CNC controlled Boring Head: <ul style="list-style-type: none"> Rotary table: 3 m X 3 m Table Loading Capacity: 25 T or more CNC Boring Head working Length with Tool : 2000 mm or more and suitable to work through bore diameter 420 mm. 	Vendor to confirm & submit positional accuracy of the machine and CNC Head along with basic machine details (X,Y,Z traverse, table size, spindle diameter & runout).
	-OR-	
i.	CNC Vertical Boring Machine with following specifications: <ul style="list-style-type: none"> Table Size: 4.5 m or more Table Swing: 5 m or more Table Loading Capacity: 35 T or more Machine RPM : 80 or more Height: 5 m or more The vertical boring machine should be suitable to accommodate the job and capable of machining a bore to a depth of 2300 mm using the RAM and a boring bar.	Vendor to confirm & submit machine details.
2.	Vendor to confirm that above machines (A & B) installed at their works are in good working condition with capability of achieving all the dimensions, surface finish, accuracies & tolerances as per drawing.	Vendor to confirm.
3.	Vendor to confirm that all the dimensions & surface finish of the component shall be met as per drawing. Vendor to provide detail of complete manufacturing process including the detail of machining of Bore hole diameter 280 (Zone G-15 of the drawing) Buttress Thread and steam tight surface.	Vendor to confirm.
4.	Vendor to note that all tools, measuring equipment's, technological items, CNC Programs etc. required for manufacturing of subjected item shall be arrange by the vendor, in case of order.	Vendor to confirm.
5.	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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