

	Transformer Plant, BHARAT HEAVY ELECTRICAL LIMITED, BHEL, JHANSI.	Machine No	MT-3/2/1525 & MT-1/1/1531		
		Quantity	2 Nos	Due Date :	
		Spec. No.	6022 R-2	Supplier's Ref.:	
				Date :	
Specification cum Compliance Certificate for PORTABLE DRILLING MACHINE					
Note:-					
1. Vendor(OEM) must submit complete information against clause no. 22. The offer meeting this clause would only be processed.					
2. The 'Offered' Column and where applicable, the 'Deviations' & 'Remarks' Column of this format shall be filled in by the Vendor and submitted along with the offer. Inadequate / incomplete, ambiguous or unsustainable information against any of the clauses of the specifications / requirements shall be treated as non-compliance.					
3. The offer and all documents enclosed with offer should be in English language only.					
Name & Address of the supplier:			Name & Address of the Indian Agent:		
Telephone No.			Telephone No.		
Fax No.			Fax No.		
e-mail :			e-mail :		
Scope: Supply, Erection & Commissioning of PORTABLE DRILLING MACHINE complying with specification as below.					
S No.	Description - BHEL's Requirement	Specified	Offered	Deviations	Remarks
1.0	PURPOSE & WORK PIECE MATERIAL				
1.1	Purpose: All Drilling Machine Operations like Drilling, Reaming, Tapping etc. at any angle position.	Vendor to confirm			
1.2	Work Piece Material: Carbon Steel, Alloy Steel, Cast Iron & Stainless Steel. Hardness 20 - 40 HRC	Vendor to confirm			
2.0	SPECIFICATION:				

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2.1	MACHINE CONFIGURATION: The column to be mounted on bed. The column slides on bed and can be traversed by hand wheel & powered motor. It should have provision of locking rigidly in any position on bed. The column should be of robust design so that no tendency of vibration occurs during high speeds and loads. The radial arm should be suitably designed so that it can be traversed across the column by means of a hand wheel & powered motor, elevated by hand wheel & powered motor and moved radically through a complete circle. The angle of drill head swivel from horizontal upwards & downwards should be 90°. Secure locking provision should be provided for all the movements. Drilling head to be adjustable in vertical and horizontal planes to any angle and locked securely in any position. The arm & drill head rotation should be 360 degree. Spindle of the drilling head should be of good wear resistant and case hardened and ground. Power traverse fine, coarse, hand adjustment and reversing motion to be provided to spindle.	Vendor to confirm			
2.1.1	MACHINE FRAME : The machine frame shall be made from high quality grey cast iron. All housing and Radial arm guides shall be hardened and ground.	Vendor to confirm			
2.1.2	HEAD STOCK AND DRIVE: The headstock shall be made from grey cast iron and is equipped with an adjustable quill. The spindle should run in lifetime lubricated precision antifriction bearings. Suitable motorized / hydraulic locking system shall be provided to lock the headstock on the radial arm at desired position. The gear steps, spindle speeds and feeds shall be selected on the control panel by means of the spindle start lever.	Vendor to confirm			
2.1.3	MOVEMENT OF DRILLING HEAD ALONG THE ARM: The movement of drilling head over the arm shall be mechanised. The desired travel direction is selected by means of a direction control lever.	Vendor to confirm and furnish details			
2.2	CAPACITY				
2.2.1	Drilling Capacity in Steel of 60 Kg/mm ² Tensile Strength	50 mm(min)			
2.2.2	Tapping Capacity in Steel of 60 Kg/mm ² Tensile Strength	50 mm(min)			
2.3	SPINDLE				
2.3.1	Spindle feed traverse (Min.)	350 mm			
2.3.2	Spindle Morse Taper	MT5/MT 6			
2.3.3	Main Motor Power (Min.) to be supported by calculation.	vendor to specify			
2.3.4	Braking system to slows down and stops the main spindle.	Vendor to provide			

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2.3.5	Spindle Ovality	0.005 max			
2.4	Spindle Speed and Feeds				
2.4.1	Spindle Speeds (Range)(Approx.)	16 - 800 RPM			
2.4.2	Number of Speed steps	15(min)			
2.4.3	Feed range (Approx.)	0.05 - 0.5 mm/rev			
2.4.4	Number of feed steps	6(min)			
2.5	Traverses				
2.5.1	Vertical Travel of Arm (Min)	2400 mm			
2.5.2	Range of Swing of Arm	0 - 360 Deg.			
2.5.2	Traverse of column in bed	1200 mm(min)			
2.6	Distances				
2.6.1	Swing Radius of drilling spindle (max)	2250 mm(min)			
2.6.2	Swing Radius of drilling spindle (min)	1420 mm(Max.)			
2.6.3	Farthest Distance of Spindle end from floor when horizontal drilling	2700mm(min)			
2.6.4	Lowest Distance of Spindle end from floor when horizontal drilling	300 mm (max)			
2.7	BEARINGS				
2.7.1	Make of all bearings shall be SKF/FAG only	Vendor to confirm.			
3.0	OPERATION AND CONTROL SYSTEM:				
3.1	ELECTRICAL EQUIPMENT:				
3.1.1	The clearly laid out operator panel with emergency stop switch and locking device switch shall be mounted on the machine housing.	Vendor to offer			
4.0	HYDRAULIC SYSTEM - Details should be Submitted by the Vendor	Vendor to submit			
5.0	First filling of all required Oils & Grease etc. to be supplied by vendor. Indigenous (Indian) source or Indian equivalent and specifications of oils/ greases are also to be provided by the vendor.	Vendor to confirm			
6.0	LUBRICATION:				
6.1	Lubrication shall be of life time lubricated wherever possible. Other lubrication points shall be of automatic type. Details shall be submitted.	Vendor to confirm			
6.2	Centralized auto lubrication shall be offered with metering cartridges and necessary electrical interlock.	Vendor to confirm			
7.0	ELECTRICAL:				

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7.1	415V + 10% / -10%, 50HZ +/-3 HZ, 3 Phase AC (4 wire system with neutral) Power Supply Voltage will be provided by BHEL at a single point near the machine, as per layout recommended by Vendor. All types of cables, connections, circuit breakers etc. required for connecting BHEL's power supply point to different parts of the machine/control cabinets, shall be the responsibility of vendor. Requirement of grounding/earthing with required material details is to be informed by vendor well in advance so that same could be incorporated during construction of foundation.	Vendor to confirm			
7.2	All electrical & electronic control cabinets & panels should be dust and vermin proof.	Vendor to confirm			
7.3	All electrical components in the cabinets should be mounted on DIN Rail.	Vendor to confirm			
7.4	All electrical and electronic panels including operator's panel should be provided with CFL for sufficient illumination. All adapters/receptacles should have compatibility with Indian equivalents.	Vendor to confirm			
7.5	Motors shall conform to IEC or Indian Standards	Vendor to confirm			
7.6	All cables and cable trays required for the machine should be included in the offer.	Vendor to confirm			
7.7	Vendor should ensure the proper earthing for the machine and its peripherals.	Vendor to confirm			
7.8	The electrical components used shall be from reputed international makes such as Siemens / Telemecanique / Merlin Gerin / GE/ ABB and shall be in accordance with DIN/IEC Standards.	Vendor to confirm			
8.0	SAFETY ARRANGEMENTS:				
	Following safety features in addition to other standard safety features should be provided on the machine:	Vendor to note and reply			
	1. Machine should have adequate and reliable safety interlocks / devices to avoid damage to the machine, work piece and the operator due to the malfunctioning or mistakes.				
	2. A detailed list of safety alarms / indications provided on machine should be submitted by the supplier.				
	3. Emergency Switches at suitable locations as per International Norms should be provided.				
ENVIRONMENTAL PERFORMANCE OF THE MACHINE :					
	The Machine shall conform to following factors related to environment				

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9.0	(a) Maximum noise level shall be 85 dB(A) at normal load condition, 1 meter away from the machine with correction factor for back ground noise, if necessary. This will be measured as per international standards like DIN 45635-16. Supplier to demonstrate compliance to noise level, if so required.	Vendor to confirm			
	(b) If any safety / environmental protection enclosure is required it should be built in the machine by the vendor.				
	(c) Paint of the machine should be oil / coolant resistant and should not peel off and mix up with coolant.	Vendor to confirm			
10.0	LEVELING & ANCHORING SYSTEM				
10.1	Complete anchoring system including anchoring materials, leveling shoes/pads etc should be supplied.	Vendor to confirm			
11.0	TOOLS FOR ERECTION, OPERATION & MAINTENANCE :				
11.1	Special tools and equipment required for erection of the machine shall be brought by the vendor. Necessary tools like Torque Wrench, Spanners, Keys, grease guns etc. for operation and maintenance of the machine should be supplied. List of such tools should be submitted with offer. Test mandrel for checking run-out/taper and alignment should also be supplied.	Vendor to confirm			
12.0	ESSENTIAL ACCESSORIES:				
12.1	Supplier has to provide details of all accessories required and in scope	Vendor to offer with details			
13.0	SPARES:				
13.1	Itemized breakup of mechanical, hydraulic, electrical and electronic spares used on the machine in sufficient quantity as per recommendation of Vendor for 2 years of trouble free operation on three shifts continuous running basis should be offered by vendor. The list to include following, in addition to other recommended spares: (Unit Price of each item of spare should be offered in the price bid)	Vendor to furnish			
13.2	Mechanical & Hydraulic Spares: All types of Pumps, Valves, Pressure Switches, Transducers, Flow Switches, Filters, Seals, O-rings, Hydraulic Hoses etc.	Vendor to furnish			
13.3	Electrical /Electronic : All types of Relays, Contactors, Proximity Switches, Push Buttons, Indicating Lamps, Semiconductor Fuses, Special Fuses, Circuit Breakers, Main Power etc.	Vendor to furnish			

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13.4	All types of spares for total machine and accessories should be available for at least ten years after supply of the machine. If machine or control is likely to become obsolete in this period, the vendor should inform BHEL sufficiently in advance and provide drawings of parts / details of spares & suppliers to enable BHEL to procure these in advance, if required	Vendor to furnish			
13.5	Vendor to confirm that complete list of spares for machine and accessories, along with specification / type / model, and name & address of the spare supplier shall be furnished along with documentation to be supplied with the machine	Vendor to confirm			
13.6	Vendor to supply 2 Sets of Electronic cards or PCBs, Modules of PLCs, Display Boards if any used in the machine as essential spares.	Vendor to offer			
14.0	DOCUMENTATION : Five sets of following documents (Hard copies) in English language should be supplied along with the machine	Vendor to confirm			
14.1	Operating manuals of Machine				
14.2	Detailed Maintenance manual of machine with all drawings of machine assemblies/sub-assemblies/parts including Electrical / Pneumatic/ Coolant / Hydraulic circuit diagrams. All Assembly/ Sub Assembly Drawings shall be supplied with the part list also.				
14.3	Catalogues, O&M Manuals of all bought out items including drawings, wherever applicable.				
14.4	Detailed specification of all rubber items and hydraulic/lube fittings				
14.5	Complete Master List of parts used in the machine shall be submitted by the vendor.				
14.6	One additional set of all the above documentation on CD ROM, wherever possible.				
15.0 TRAINING					
15.1	BHEL Persons should be trained at supplier's Works for mutually agreed period in the area of (a) Electrical and Electronic maintenance for machine & other supplied equipments wherever applicable. (b) Mechanical & Hydraulic maintenance of the machine & other supplied equipments (c) Operation of the machine & other supplied equipments.	Vendor to agree			
15.2	Air-fare, boarding & lodging for the trainees shall be borne by BHEL.	Vendor to note			

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15.3	Competent, English speaking experts shall be arranged by the vendor during training for satisfactory & effective training of BHEL personnel.	Vendor to note and accept			
15.4	Vendor to quote for training on man / day basis	Vendor to note			
16.0 ERECTION & COMMISSIONING					
16.1	Supplier to take full responsibility for carrying out the erection, start up, testing of machine, it's control & all types of other supplied equipment, machining of test pieces etc. Service requirement like power, air & water shall be provided by BHEL. Other requirements like crane and helping personnel shall also be provided by BHEL subject to availability. Details of these requirements should be informed by vendor in advance.	Vendor to note			
16.2	Successful proving of BHEL components by the supplier shall be considered as part of commissioning. All tests, as mentioned at clause 18 (Machine Acceptance) shall form part of the commissioning activity.	Vendor to note			
16.3	Tools, Tackles, instruments and other necessary equipment required to carry out all above activities should be brought by the supplier.	Vendor to note			
16.4	Commissioning spares, required for commissioning of the machine within stipulated time, shall be brought by the supplier on returnable basis.	Vendor to note			
16.5	All Cover Plates required for the machine and its peripherals including pits, if any, shall be supplied and installed by the vendor..	Vendor to note			
16.6	Portion, if any, of the machine, accessories and other supplied items where paint has rubbed off or peeled during transit or erection should be repainted and merged with the original surrounding paint by the vendor. For this purpose, the vendor should supply sufficient quantity of touch-up paint of various colors of paint used.	Vendor to note			
16.7	Schedule of Erection and Commissioning shall be submitted with the offer.	Vendor to submit			
16.8	Charges, duration, terms & conditions for E&C should be furnished in detail separately by vendor along with offer.	Vendor to submit			
17.0 GEOMETRICAL ACCURACIES :					
17.1	The machine shall be tested for Geometrical Accuracy as per IS 2199 /ISO 2423 latest revision.Supplier shall submit test chart for BHEL approval.	Vendor to confirm and submit			

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17.2	All the above accuracies should be demonstrated to BHEL engineers during pre-acceptance at Suppliers works and during Erection & Commissioning at BHEL Works.	Vendor to accept			
18.0	MACHINE ACCEPTANCE: (Tests/Activities to be Performed by Vendor)	To be accepted & confirmed by Vendor			
18.1	Quality assurance plan to be submitted for BHEL approval within 4 weeks time after LOI/PO.				
18.2	Tests/Activities to be carried out at supplier's works on the machine before dispatch :				
18.2.1	Motors data sheet	Vendor to submit			
18.2.2	Internal routine test report	Vendor to submit			
18.2.3	The machine should be tested for its full capacity at supplier works . Vendor shall arrange test pieces at their end.	Vendor to accept			
18.2.4	Demonstration of all features of the machine, control system & accessories	Vendor to demonstrate			
18.3	Tests/Activities to be carried out at BHEL works while commissioning the machine :				
18.3.1	The machine should be tested for its full capacity at BHEL works . BHEL will provide test pieces for prove out.	Vendor to accept			
18.3.2	Demonstration of all features of the machine, control system & accessories to the satisfaction of BHEL for efficient and effective use of the machine.	Vendor to accept			
18.3.3	Training of BHEL machine operators for four working days in operation of complete machine & accessories etc by the supplier's experts / engineers during their stay at BHEL works.	Vendor to accept			
19.0	PACKING:				
19.1	Sea worthy & rigid packing for all items of complete machine, CNC System, all Accessories and other supplied items to avoid any damage/loss in transit. When machine is despatched in containers, all small loose items shall be suitably packed in boxes.	Vendor to note and accept			
20.0	GUARANTEE :				
20.1	24 months from the date of acceptance of the machine at BHEL works..	Vendor to accept			
21.0	GENERAL :				
21.1	Machine Model .	Vendor to furnish			
21.2	Total connected load (KVA):	Vendor to furnish			
21.3	Floor area required (Length, Width, Height) for complete machine & accessories	Vendor to furnish			
21.4	Painting of Machine / Electrical Panels : RAL 6011 Apple Green (Polyurethane Paint)	Vendor to note			

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21.5	Total weight of the machine	Vendor to furnish			
21.6	Weight of heaviest part of machine	Vendor to furnish			
21.7	Weight of the heaviest assembly / sub-assembly of the Machine	Vendor to furnish			
21.8	Dimensions of largest part/ sub-assembly/ assembly of the machine	Vendor to furnish			
21.9	Vendor to submit, along with offer, reference list of customers where similar machines have been supplied mentioning broad specifications of the supplied machine i.e. Model, Capacity etc.	Vendor to furnish			
21.10	Detailed catalogues, sketch/ photographs of the m/c and accessories/ attachments should be submitted with the offer.	Vendor to submit			
21.11	Hydraulic, Pneumatic & oil pipings should be preferably metallic except places where flexible pipings are essential. All the pipes required for the same shall be included in the standard scope of the machine.	Vendor to note			
22.0	COMPANY PROFILE/QUALIFYING CONDITIONS :				
22.1	COMPANY PROFILE				
	The BIDDER has to provide the details pertaining to each clause in the	Vendor to submit			
	Number of years of experience of the BIDDER/ VENDOR in the field	Vendor to submit			
	Details on the Codes/Standards adopted for the machine design and	Vendor to submit			
	Details on Manufacturing facilities available with the VENDER for:	Vendor to submit			
	(a) Sourcing/Building large machine casting or fabricated components	Vendor to submit			
	(b) Heat treatment facilities	Vendor to submit			
	(c) Machine assembly & testing Rigs	Vendor to submit			
	vendor to supply machine within 6 months after LOI	Vendor to confirm			
	Capacity of vendor .	Vendor to submit			
22.2	QUALIFYING CONDITIONS :				
	Only those vendors(OEM), who have supplied and commissioned at least two similar machines in the past 10 years (on the date of opening	Vendor to submit details			
	The following information should be submitted by the vendor about the companies where similar machines have been supplied. This is required from all the vendors for qualification of their offer.	Vendor to submit details			
	1. Name of the customer / company where similar machine is installed.	Vendor to submit			
	2. Complete postal address of the customer.	Vendor to submit			
	3. Month & Year of commissioning.	Vendor to submit			
	4.Parameters of machine(s) supplied & application for which the machine is supplied.	Vendor to submit			
	5. Name and designation of the contact person of the customer.	Vendor to submit			

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	6. Phone, FAX no. and email address of the contact person of the customer.	Vendor to submit			
	7. Performance certificate from the customers regarding satisfactory performance of machine supplied to them (original certificate or through E-mail directly from the customer).The original may be returned after verification by BHEL,If required.	Vendor to submit			
	8.BHEL reserves the right to verify the information provided by vendor.In case the information provided by vendor is found to be false/incorrect, the offer shall be rejected.	Vendor to confirm			

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