Scope of work For Machining of Exhaust Hood

Dt: 15.05.2023

Project:

Tata Jamshedpur (WO No. 1019714000)

PR No. 1400229280 & 1400229281

Volumetric Dimensions:

Volumetric dimns LxBxH UP+LP : 2685 x 7884 x 5827mm

Volumetric dimns LxBxH UP : 2375 x 7250 x 2827mm

Volumetric dimns LxBxH LP : 2685 x 7884 x 3000mm

Drawings to be referred:

Exh. Hood Assembly drg : 03012500082- 00 Rev.01

Exh. Hood Upper part drg : 03012500083-00 Rev.05

Exh.Hood Lower part drg : 03012500084-00 Rev.12

Facilities required for machining of Exh. Hood :

1. Horizontal Boring machine of Spindle dia 200.
2. Vertical Lathe of Turning dia 10m for combined boring.
3. Radial Drilling VR10 drilling capacity dia 100mm.
4. Portable/Universal drilling machine with capacity dia 50mm.
5. Suitable clamping supports i.e. Angle Blocks & Height Blocks.
6. Measuring instruments and cutting tools.

SCOPE OF WORK FOR MACHINING OF EXHAUST HOOD UPPER & LOWER PARTS:

Note:-Refer the technological process from opn 0010 to 0330.

1. Machining should be done strictly according to machining drawings and scope of work .

2. Dimensional tolerances, geometrical accuracies like perpendicularity, parallality, concentricity and cylindricity are to be maintained as mentioned in the machining drawings and scope of work.

3. Initial marking for suitability for total m/cing.

4. Parting Plane rough machining of upper and lower parts.

5. Parting Plane holes drilling, back counter boring and enlarging of Upper and lower Parts.

6. PP grinding in UP and LP to achieve the good surface finish if required.

7. Blue matching of parting planes of upper and lower parts.

8. Parting plane PP holes mismatch checking, PP gap checking & assembly of both the parts for taper pin holes drilling & reaming.

9. Combined boring for all dias and faces.

10. Dismantle both the parts.

11. Peripheral m/cing in both the halves

12. Peripheral drilling & tapping of UP and LP parts.

13. Clean and Deburr both parts.

14. Final Inspection for both the parts.

Note:-

1) All the axial dimensions in specified tolerances are to be maintained from reference plane.

2) Inspection of the job at supplier's works shall be carried out by BHEL / agency authorized by BHEL for which adequate prior notice shall be given by the sub-contractor.

4) After inspection protect the machined surfaces with rust washable preventive paint.

5) Final inspection by BHEL-QC/Its authorized inspection agency.

6) Dispatch with proper supports and protections during transportation.

7) Clamping fasteners required for combined machining will be supplied by BHEL.

M. Gayatri

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