

MACHINING OF RUNNER SKIRT**iii) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar job having max. dia. greater than 2700 mm and weight more than 13MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. 4600 mm, height 1000 mm and weight 22MT	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 22MT or more	Vendor to Confirm and submit detail

iv) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-204-07-21303/M1/R00	Vendor to confirm
2	Vendor to arrange all tools, templates & instruments required for machining and checking of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 4-6 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit following with the offer:- c) Details of the Organization d) Details of the machine tools and other facilities installed in the company	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bibhuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
--	-----------------------------	-----------------------------

MACHINING OF RUNNER CROWN**i) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar jobs having max. dia. greater than 2700 mm and weight more than 20MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. 4600 mm, height 730 mm and weight 33MT	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 33MT or more	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-204-07-21303/M/R00	Vendor to confirm
2	Vendor to arrange all tools, templates & instruments required for machining and checking of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 5-7 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit following with the offer:- a) Details of the Organization b) Details of the machine tools and other facilities installed in the company	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bishuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
--	-----------------------------	-----------------------------

MACHINING OF RUNNER SKIRT**i) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar job having max. dia. greater than 3000 mm and weight more than 15MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. 5150 mm, height 1100 mm and weight 25MT	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 25MT or more	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-204-07-21503/M1/R00	Vendor to confirm
2	Vendor to arrange all tools, templates & instruments required for machining and checking of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 4-6 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit following with the offer:- a) Details of the Organization b) Details of the machine tools and other facilities installed in the company	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

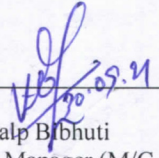
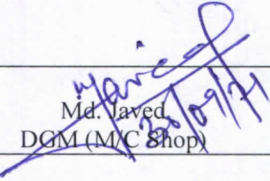
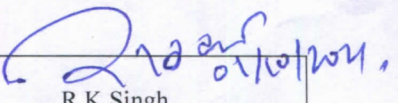
Vikalp Bishuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
--	-----------------------------	-----------------------------

MACHINING OF RUNNER CROWN**i) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar jobs having max. dia. greater than 3000 mm and weight more than 25MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. 5150 mm, height 780 mm and weight 42MT	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 42MT or more	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-204-07-21503/M/R00	Vendor to confirm
2	Vendor to arrange all tools, templates & instruments required for machining and checking of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 5-7 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit following with the offer:- a) Details of the Organization b) Details of the machine tools and other facilities installed in the company	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

 Vikalp B. Bhuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
--	--	---

MACHINING OF RUNNER SKIRT**i) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar job having max. dia. greater than 3000 mm and weight more than 15MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. 5050 mm, height 1100 mm and weight 24MT	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 24MT or more	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-204-07-21203/M1/R00	Vendor to confirm
2	Vendor to arrange all tools, templates & instruments required for machining and checking of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 4-6 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit following with the offer:- a) Details of the Organization b) Details of the machine tools and other facilities installed in the company	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bishnuthi Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
--	-----------------------------	-----------------------------

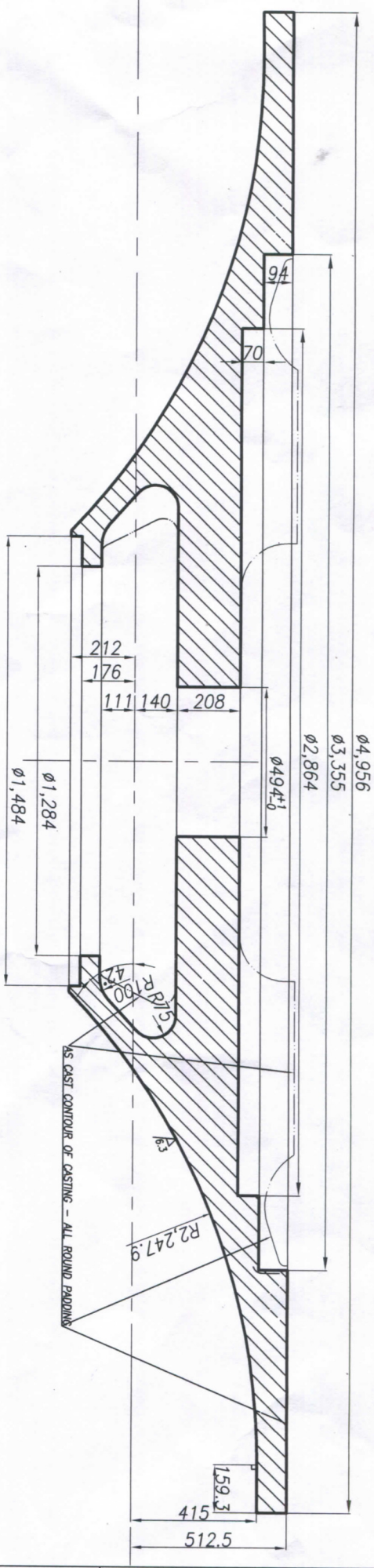
MACHINING OF RUNNER CROWN**iii) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar jobs having max. dia. greater than 3000 mm and weight more than 20MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)
2	Vendor should have a Vertical Boring machine which can machine a job of dia. 5050 mm, height 800 mm and weight 36MT	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 36MT or more	Vendor to Confirm and submit detail

iv) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-204-07-21203/M/R00	Vendor to confirm
2	Vendor to arrange all tools, templates & instruments required for machining and checking of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 5-7 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit following with the offer:- c) Details of the Organization d) Details of the machine tools and other facilities installed in the company	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bibhuti Dy. Manager (M/C Shop)	Md. Javed DCM (M/C Shop)	R.K.Singh AGM (M/C Shop)
--	-----------------------------	-----------------------------



- NOTE:-
1. CASTING TO BE ROUGH MACHINED TO THE DRG. DIMENSIONS ON ALL THE SURFACES TO THE FINISH OF 12.5 MICRONS AND TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE SPECIFIED
 2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY, FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-204-07-21203 REV 00
 3. CASTING MACHINED TO THIS DRAWING SHALL BE USED FOR FABRICATION OF IMPELLER AT BHEL BHOPAL,
 4. WT OF CASTING BEFORE MACHINING : 36000 KGS
WT OF CASTING AFTER MACHINING : 24600 KGS

CONTROLLED COPY
Foundry Technology
C.No. SF/...../14
Date.....22 MAY 2021

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
ZONE	CHECKED		ZONE	CHECKED		ZONE	CHECKED		ZONE	CHECKED	

DEPT. FDI/TECH. **SCALE** **N.T.S.** **WEIGHT IN KGS**

PROJECT AND CUSTOMER NAME **TECHNOLOGY NO** **DRAWING NO** **SHEET NO.- 1** **NO. OF SHEETS-1**

BHARAT HEAVY ELECTRICALS. LTD.
CROWN M/C DRG FOR
CROWN OF IMPELLER

23608 **0-204-07-21203/M**

BHEL-BHOPAL

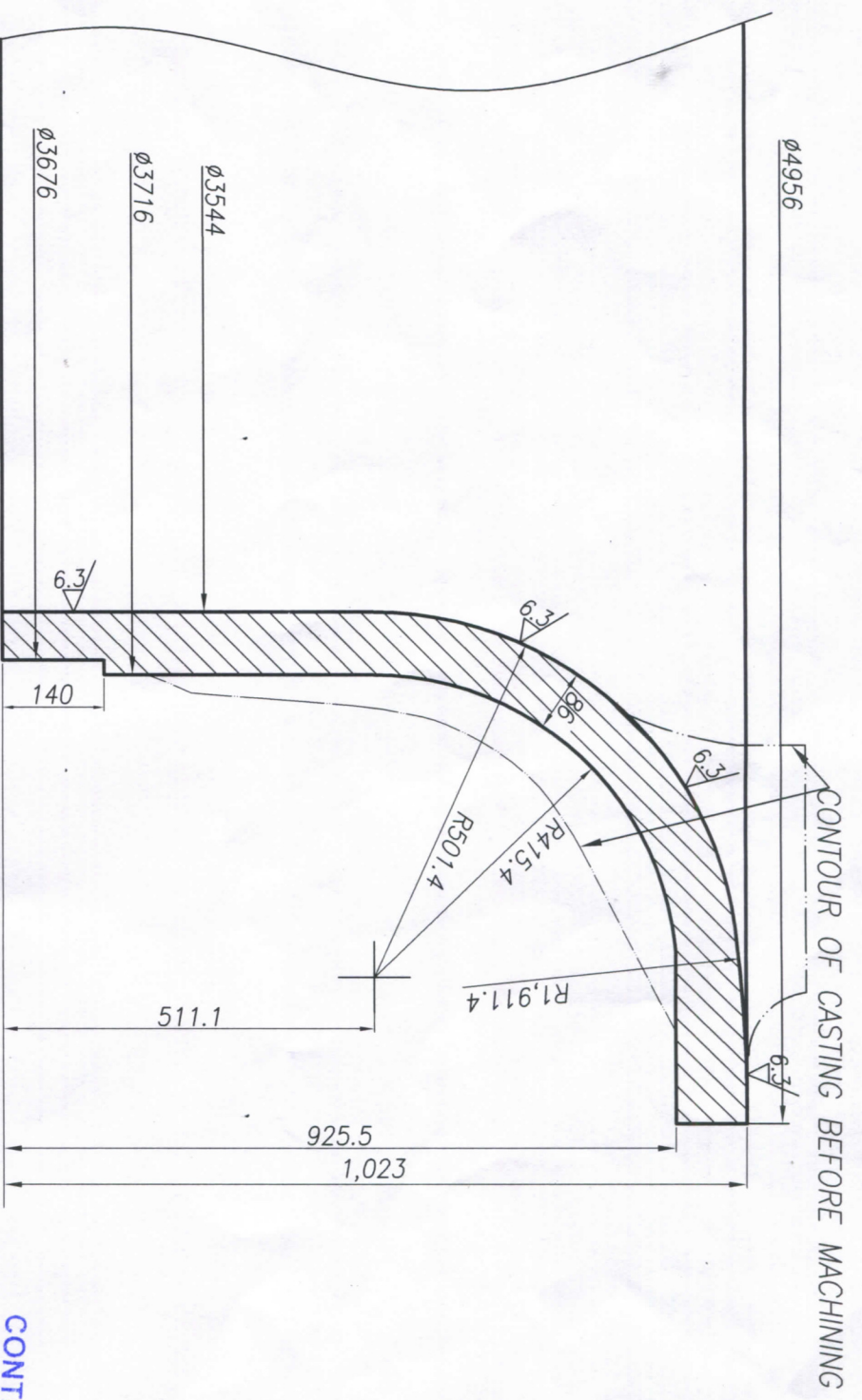
NAME **SIGN** **DATE**

DRN **WRO** **CHD** **APRD**

7/23/P R REDDY/23487/M **50 18 27** **50 18 27** **50 18 27**

NAVEEN **NK GAURAV** **R LAKRA**

21021



NOTE:-
 1. CASTING TO BE ROUGH MACHINED TO THE DRG. DIMENSIONS ON ALL THE SURFACES TO THE FINISH OF 12.5 MICRONS AND TOLERANCE OF +2 ON OD & HT AND -2 ON ID, +0
 2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-204-07-21203 REV00
 3. CASTING MACHINED TO THIS DRAWING SHALL BE USED FOR FABRICATION OF IMPELLER AT BHEL BHOPAL,
 4. WT OF CASTING BEFORE MACHINING : 23300 KGS
 WT OF CASTING AFTER MACHINING : 11980 KGS

REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED	REV	DATE	ALTERED	CHECKED
ZONE				ZONE				ZONE				ZONE			

		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RAIPUR HARDWARE	
DEPT. F.O.Y. TECH.		SCALE N.T.S.	
TITLE ROUGH M/C DRG FOR SKIRT OF IMPELLER		WEIGHT IN Kgs	
PROJECT AND CUSTOMER NAME BHEL BHOPAL		TECHNOLOGIST NO 23609	
DRAWING NO 0-204-07-21203/M1		SHEET NO.-1	
DRN	23/P R REDDY/23609M	NAME	SIGN
WDO	NAVEEN	DATE	
CHD	NK GANJRAV		
APPD	R LAKRA		

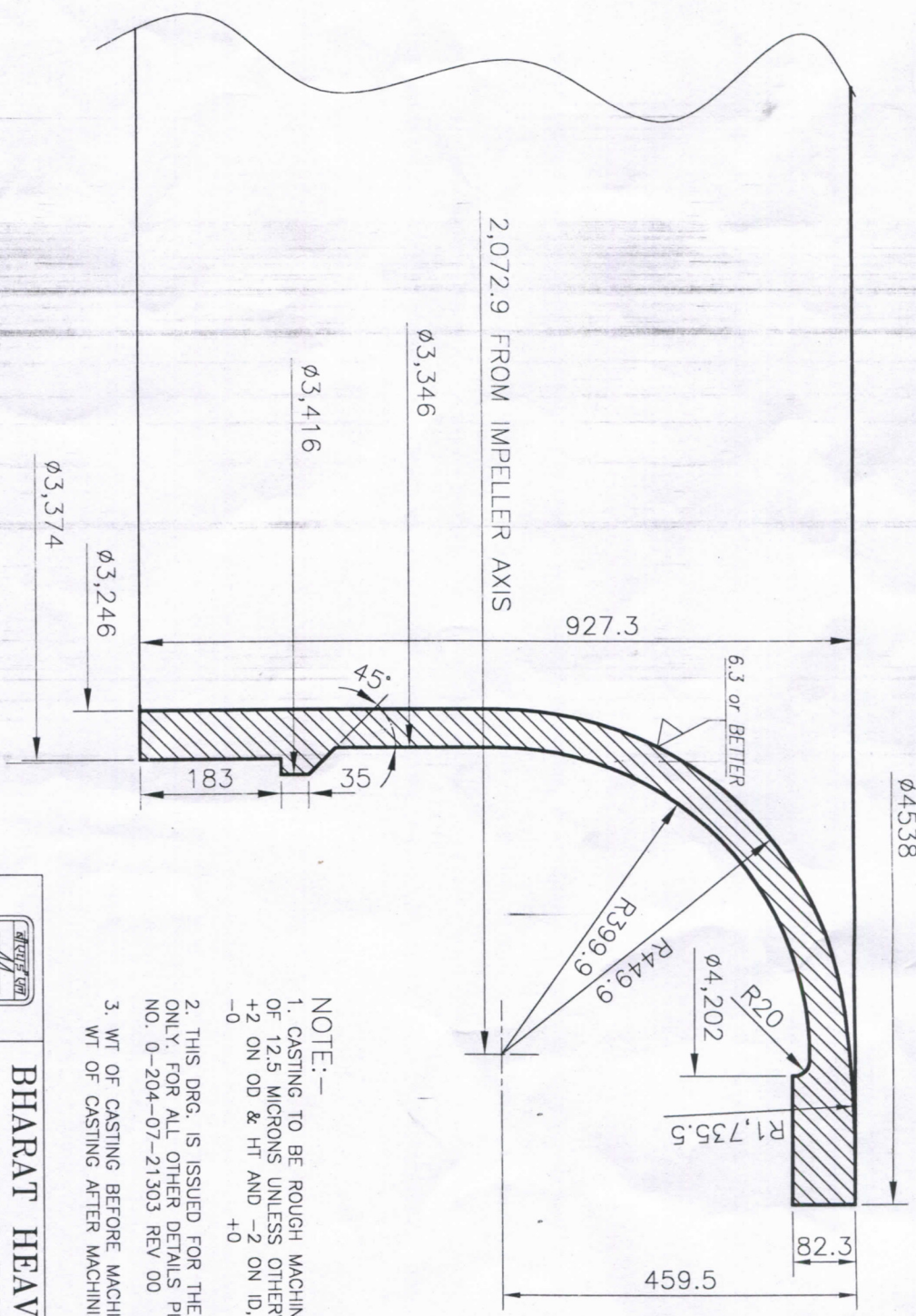
CONTROLLED COPY
 Foundry Technology
 C.No. SF/ 21
 Date 22 MAY 2021

ALL OVER
 12.5 EXCEPT AT SHOWN

21021

Ø4538

ALL OVER
12.5/ EXCEPT AS SHOWN



NOTE:-

1. CASTING TO BE ROUGH MACHINED ALL OVER TO THE FINISH OF 12.5 MICRONS UNLESS OTHERWISE STATED AND TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE SPECIFIED -0
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-204-07-21303 REV 00
3. WT OF CASTING BEFORE MACHINING : 21800 KGS
WT OF CASTING AFTER MACHINING : 6860 KGS

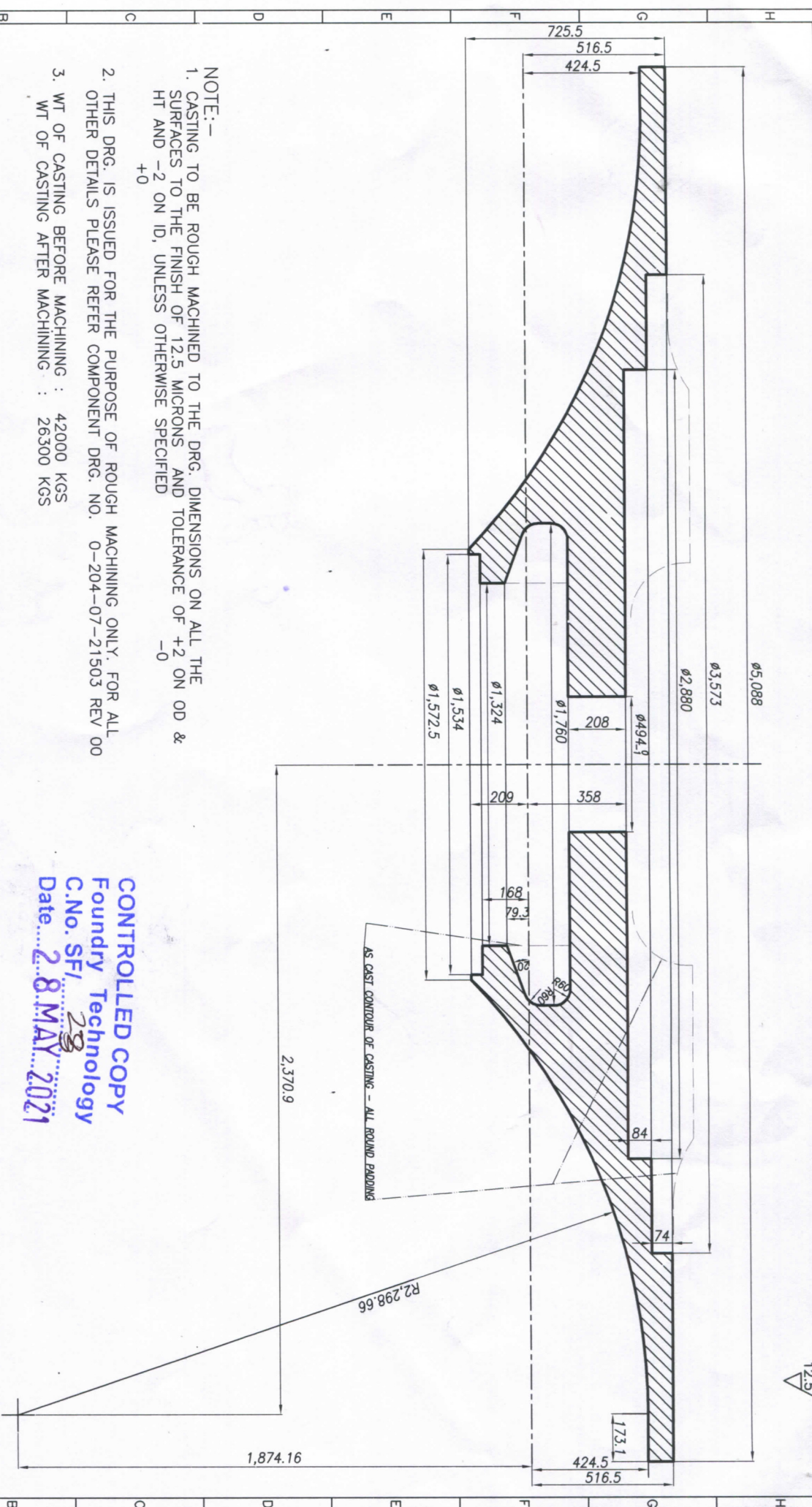
CONTROLLED COPY
Foundry Technology
C.No. SF/...../7
Date...22 MAY 2021



BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORCE PLANT
RANIPUR HARDWAR

REV	DATE	ALTERED	CHECKED

DEPT. - FDR. TECH	SCALE	WEIGHT IN KG.	NAME	SIGN	DATE
TITLE	ROUGH M/C DRG FOR	IMPELLER SKIRT	DRN	/23/23616M/DWG	
PROJECT AND CUSTOMER NAME	PALAMURU RANGAREDDY & KALESHWARAN L2P1	TECHNOLOGY NO.	WKD	NK GAURAV	Sd 10.5.21
BHEL BHOPAL	23616	DRAWING NO.	CHD	L AGRAWAL	Sd 10.5.21
			APPD	R LAKRA	Sd 10.5.21



NOTE:-
1. CASTING TO BE ROUGH MACHINED TO THE DRG. DIMENSIONS ON ALL THE SURFACES TO THE FINISH OF 12.5 MICRONS AND TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE SPECIFIED
+0
-0

2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-204-07-21503 REV 00
3. WT OF CASTING BEFORE MACHINING : 42000 KGS
WT OF CASTING AFTER MACHINING : 26300 KGS

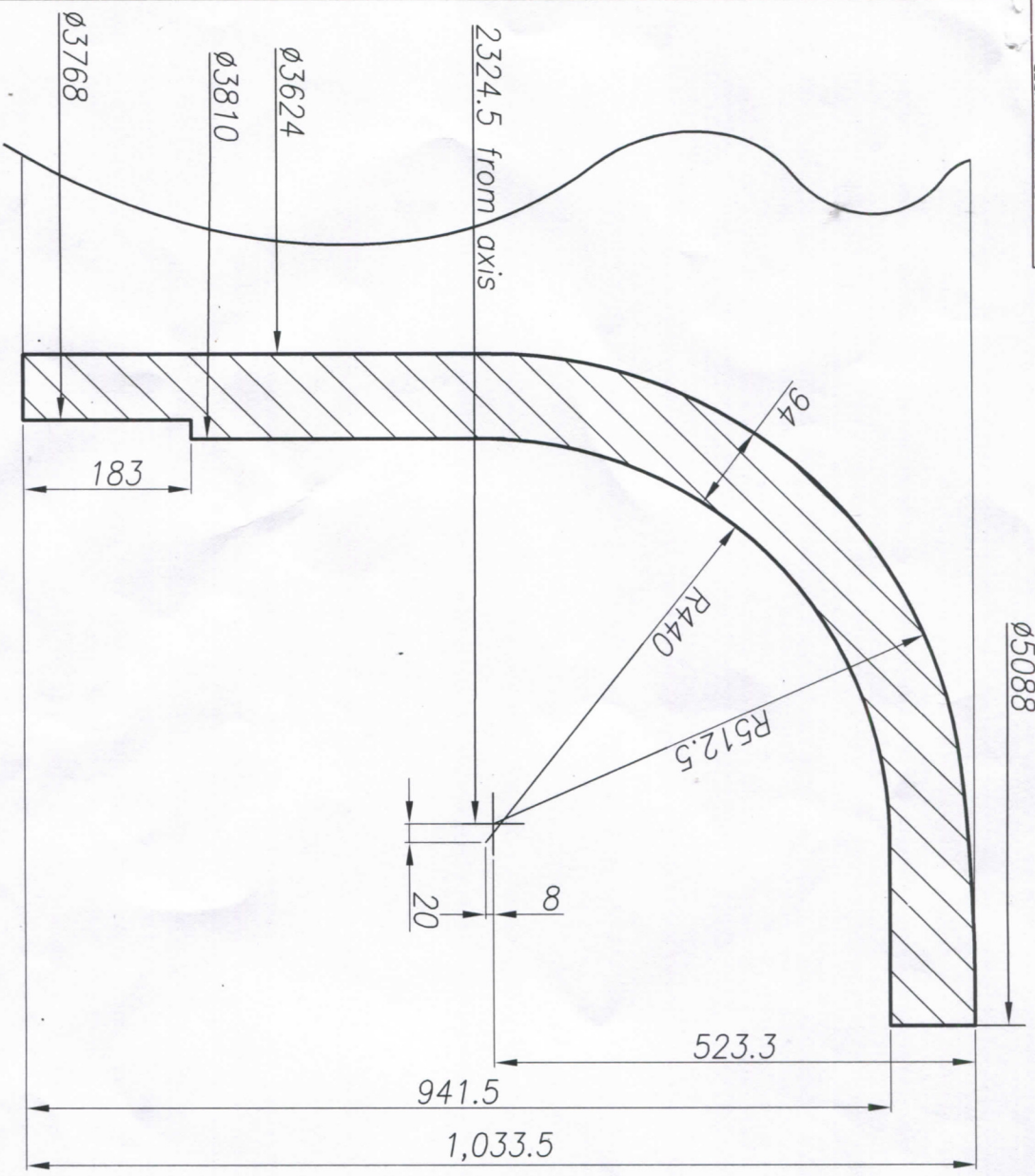
CONTROLLED COPY
Foundry Technology
C.No. SFI/28
Date 28 MAY 2021

REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED
ZONE	CHECKED		ZONE	CHECKED		ZONE	CHECKED		ZONE	CHECKED	

BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWAR		DEPT. FDY. TECH.		SCALE N.T.S.		WEIGHT IN KGS		NAME		SIGN		DATE	
PROJECT AND CUSTOMER NAME KALESHWARAN L2P2 BHEL-BHOPAL		TITLE ROUGH M/C DRG FOR IMPELLER CROWN		TECHNOLOGY NO 23611		DRAWING NO 0-204-07-21503/M		DRN I/23/KALESHWARAN L2P2		CHK INR. GAURAV SD 27/5/21		APPD R. LAKRA SD 27/5/21	
SHEET NO.- 1		NO. OFF SHEETS-1											

21021

12.5
ALL OVER



NOTE:-
1. CASTING TO BE ROUGH MACHINED TO THE DRG. DIMENSIONS ON ALL THE SURFACES TO THE FINISH OF 12.5 MICRONS AND TOLERANCE OF +2 ON OD & HT AND -2 ON ID.
+0
-0
UNLESS OTHERWISE SPECIFIED
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-204-07-21503 REV00
3. WT OF CASTING BEFORE MACHINING : 24500 KGS
WT OF CASTING AFTER MACHINING : 12980 KGS

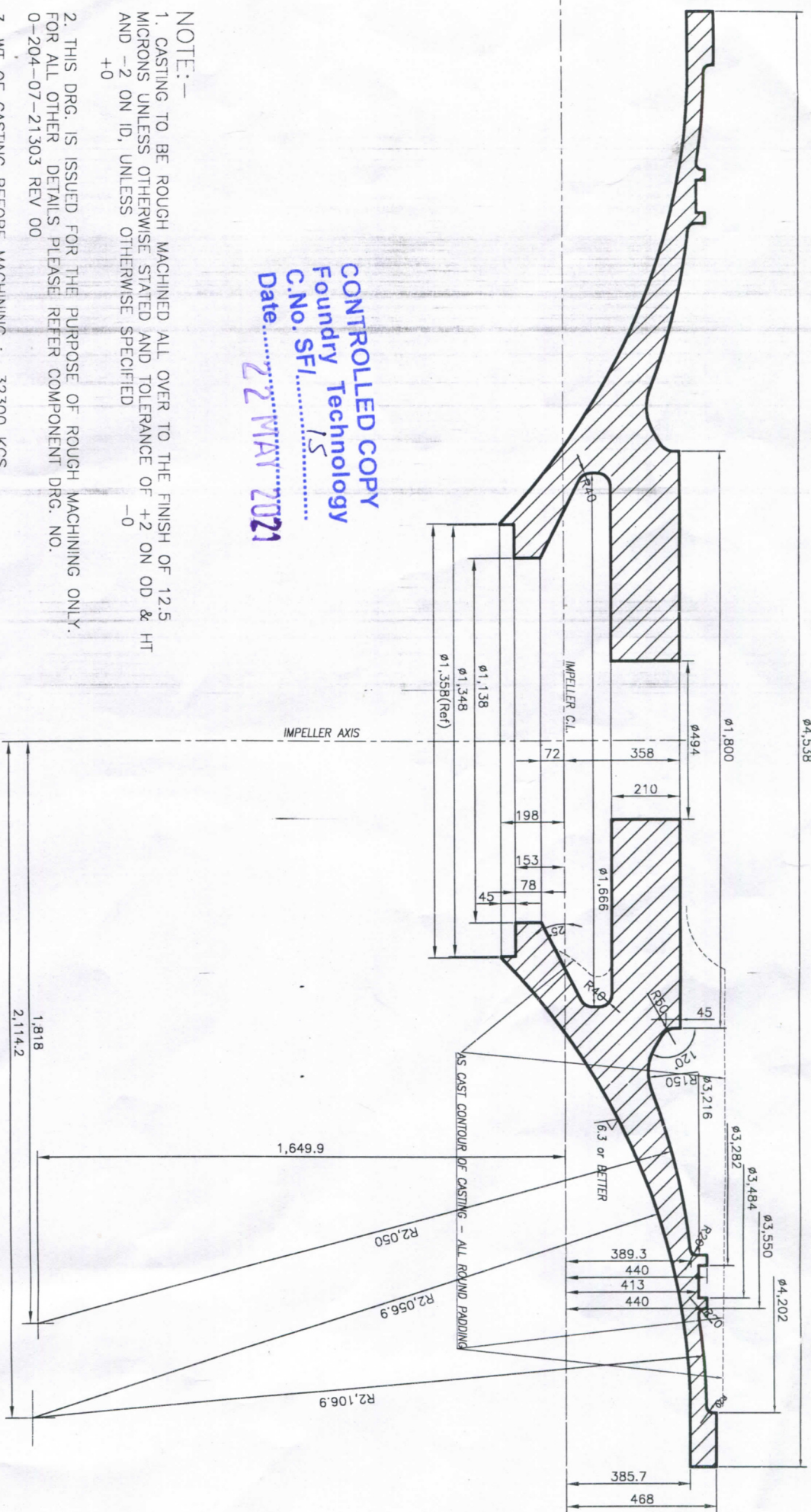
CONTROLLED COPY
Foundry Technology
C.No. SF/ 24
Date: 28 MAY 2021

REV		DATE	ALTERED	ZONE	
			CHECKED		
		4			

		BHARAT HEAVY ELECTRICALS. LTD.			
		CENTRAL FOUNDRY FORCE PLANT			
		RANPUR HARDWAR			
DEPT. F.D.Y. TECH.			SCALE	N.T.S.	WEIGHT IN Kgs
TITLE		ROUGH M/C DRG FOR IMPELLER SKIRT			
PROJECT AND CUSTOMER NAME KALESHWARAN L2P2 BHEL BHOPAL		TECHNOLOGY NO 23612		DRAWING NO 0-204-07-21503/M1	
SHEET NO.- 1		NO. OF SHEETS- 1			

DRN	23/KALESHWARAN L2P2	NAME	SGRN	DATE
WKO	N. K. GADURAI			27.5.21
CHD	L. KISHANRAI			27.5.21
APRD	R. LAKRA			27.5.21

21021



CONTROLLED COPY
Foundry Technology
C.No. SFL...../5
Date.....22 MAY 2021

NOTE:-

1. CASTING TO BE ROUGH MACHINED ALL OVER TO THE FINISH OF 12.5 MICRONS UNLESS OTHERWISE STATED AND TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE SPECIFIED -0 +0
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-204-07-21303 REV 00
3. WT OF CASTING BEFORE MACHINING : 32300 KGS
WT OF CASTING AFTER MACHINING : 15460 KGS

REV	DATE	ALTERED	ZONE	REV	DATE	ALTERED	ZONE	REV	DATE	ALTERED	ZONE	REV	DATE	ALTERED	ZONE
		CHECKED				CHECKED				CHECKED				CHECKED	

		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWAR	
DEPT.	FDY/TECH.	SCALE	N.T.S.
PROJECT AND CUSTOMER NAME	PALAMURU RANGAREDDY-4		
TITLE	ROUGH M/C DRG FOR CROWN OF IMPELLER		
DRN	1/23/PALAMURU-4/23615M	NAME	SD 215.27
CHKD	INK. GAURAV SD 215.27	NAME	SD 215.27
APRD	R. LAKSHI SD 215.27	NAME	SD 215.27
TECHNOLOGY NO	0-204-07-21303/M	SHEET NO.	1
NO. OF SHEETS	1		

21021