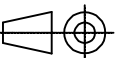


(ALL DIMENSIONS ARE IN mm)

INVENTORY NO.

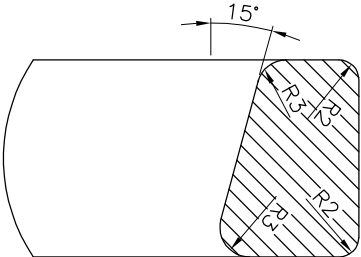
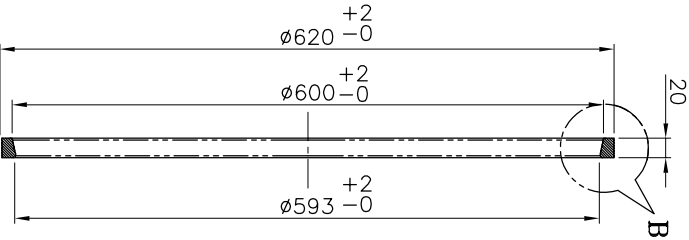
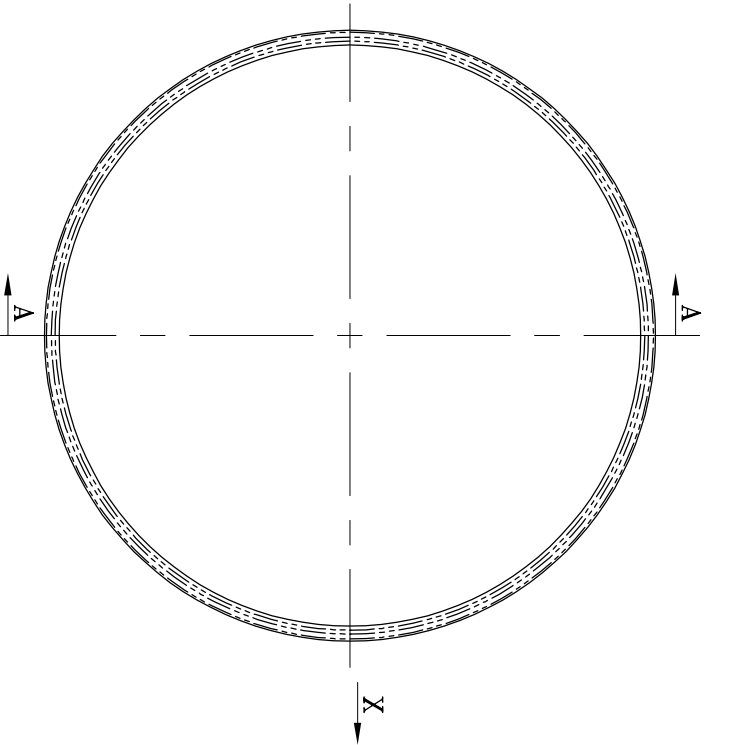
CARD TYPE 3		28		28		CARD TYPE 1		28		CARD TYPE 2	
बी.एच.ई.एल.  BHARAT HEAVY ELECTRICALS LTD. BHOPAL						DRN.	NAME	SIGN	DATE	NO.OF VAR.	
						CKD.	A.JHARIA		03.03.23		
						APPD.	K.D.		03.03.23		
DEPT. TME	UNTOI. DIMS. GR.		SCALE	WEIGHT(KG)	REF.TO ASSY.DRG.		ITEM NO.	NO.OF ITEM			
CODE 405	TM 20079 GR. - M		NTS								
TITLE <u>WINDING SUPPORT RING</u> (IM3004AZ) 1					DRAWING NO.			REV			
					4 445 33 05 053						
					SHT.NO	01	NO.OF.SHT.		01		

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200 49 33 44 3 00

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



NOTES:-

MATERIAL:-

- 1. GLASS FIBER REINFORCEMENT CONTINUOUS CLASS 'E' GLASS FIBER ROVING 30 OR 60 ENDS.
- 2. RESIN EPOXY.

TECHNICAL REQUIREMENTS:-

- 3. RINGS TO BE MOULDED IN STEEL MOULDS TO ACHIEVE DIMENSIONAL CONSISTENCY.
- 4. RING TO BE REMOVED FROM MOLD AFTER COLD SET (24 HOURS) AT ROOM TEMP.
- 5. RING AFTER CURING MUST GIVE METALLIC SOUND ALL OVER WHEN TAPPED BY METALLIC ROD.
- 6. DURING ROUTINE TEST, MECHANICAL LOAD OF 80 KG. TO BE APPLIED ON EACH RING.
- 7. THIS DRG. IS SIMILAR TO RDSO DRG. NO. SKEL-4851.

2
5

VIEW-X

SECTION-AA

DETAIL-B

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
---------------	--------------	---------------

REV.	DATE	ALTERED	CHECKED	APPROVED
03	07.09.13			
ZONE NOTE-1 & MATL. SPEC. DELETED. NOTES 5&6 ADDED. UNTOL. DIMS. GR. WAS TM20079 'M'.				

REV.	DATE	ALTERED	CHECKED	APPROVED
04	16.03.14			
ZONE DIMN. 59<3 WAS 59<2. DIMN. 11 DELETED & DIMN. 600<2 ADDED.				

REV.	DATE	ALTERED	CHECKED	APPROVED
02	18.05.12			
MAT. SPEC. IS:10192, GR:EP-3 WAS NOT ON & NOTES MODIFIED & UPDATED.				

REV.	DATE	ALTERED	CHECKED	APPROVED
01	28.06.10			
DISTRIBUTION OF PRINTS TIME-1, TXM-3, TXN-1				

REV.	DATE	ALTERED	CHECKED	APPROVED
01	05/02/10			
NO. OF VAR. 00				

QTY	VAR	NO.	ITEM	NO.	DESCRIPTION	DRAWING NO.	VAR.	MATL. SPON.	QTY.
59	64	65	75	78	79	25	27	29	
BRACING RING									

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS
TIME-1, TXM-3, TXN-1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

6FRA 6068



BHARAT HEAVY ELECTRICALS LTD.
BHOPAL

DEPT. TIME
405

UNTOL. DIMS. GR.
TM20079



SCALE
NTS

WEIGHT (K.G.)

REF. TO ASSY. DRG.

ITEM NO.

NO. OF ITEM

BRACING RING (INNER)
CONNECTION END

DRAWING NO.

3 445 33 64 007

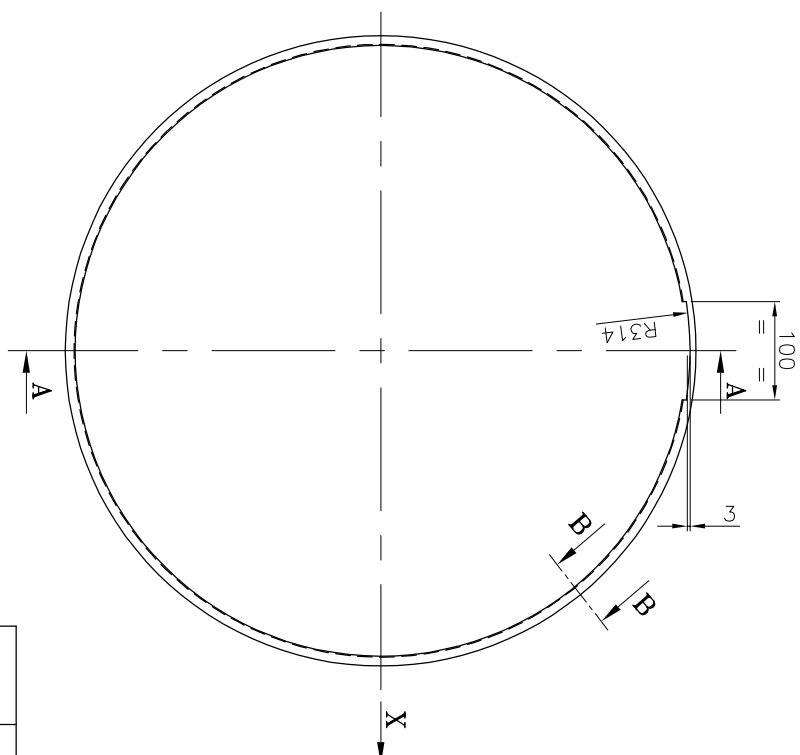
REV. 04

SHT. NO.

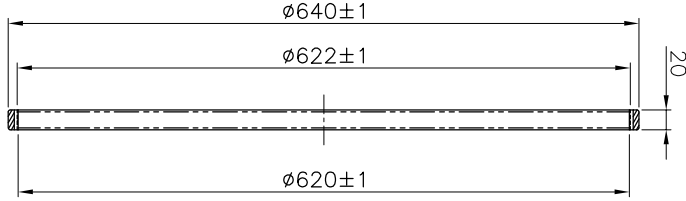
01

NO. OF SHT.

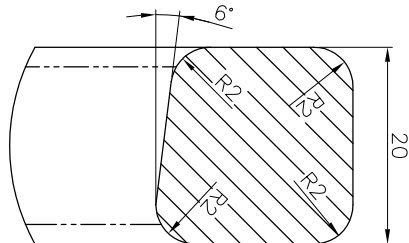
SIZE A3

DRG. NO. 3 445 33 64 008

VIEW-X



SECTION - 'AA'



SECTION - 'BB'

- NOTES:-**
- MATERIAL:-**
1. GLASS FIBER REINFORCEMENT CONTINUOUS CLASS 'E' GLASS FIBER ROVING 30 OR 60 ENDS.
 2. RESIN EPOXY.
- TECHNICAL REQUIREMENTS:-**
3. RINGS TO BE MOULDED IN STEEL, MOULDS TO ACHIEVE DIMENSIONAL CONSISTENCY.
 4. RING TO BE REMOVED FROM MOULD AFTER COLD SET (24 HOURS) AT ROOM TEMP.
 5. RING AFTER CURING MUST GIVE METALLIC SOUND ALL OVER WHEN TAPPED BY METALLIC ROD.
 6. DURING ROUTINE TEST, MECHANICAL LOAD OF 80 KG. TO BE APPLIED ON EACH RING.
 7. THIS DRG. IS SIMILAR TO RDSO DRG. NO. SKEL-4856.

REV.	DATE	ALTERED	REV.	DATE	ALTERED
0.3	18.05.12	CHECKED <i>gk</i>	0.2	24.01.11	CHECKED <i>sd</i>
ZONE	MAT. SPEC. IS:10192, G:EP-3	APPROVED <i>gk</i>	ZONE	SECTION-'AA' MODIFIED,	APPROVED <i>sd</i>
	WAS NOT ON & NOTES			SECTION-'BB' ADDED &	
	MODIFIED & UPDATED.			DRG. UPDATE & DIGITIZED.	

	59	64
	QTY	
	VAR	00

STATUS OF DRAWING			
DISTRIBUTION OF PRINTS			
TME-1, TXM-3, TNX-1			
REV.	DATE	ALTERED	-SD-
01	29.06.10	CHECKED	-SD-
		APPROVED	-SD-
ZONE	IN TITLE BLOCK MODIFIED		
	SECTION AA DIMS. $\phi 62.2$ &		
	$\phi 62.0$ WERE $\phi 61.8$ & $\phi 61.3$		
	IN SECTION-AA DIM. 10		
	WAS 20 ANGLE 6° WAS 7°		

001	BRACING
75	78 79 25 27 29
REMARKS	VAR. ITEM NO. DE
ADDITIONAL INFORMATION	

[illegible]

TYPE OF PRODUCT												
DESCRIPTION	STD	DRAWING NO.	VAR.	SEE NOTES		UNIT	QTY.	ZONE				
				MATL. CODE	MATL. SPGN.							
58	59	60	77	29	31	34	45	55	56	58	65	72
			IT.NO.	32	33	46	54	57	68	71	75	

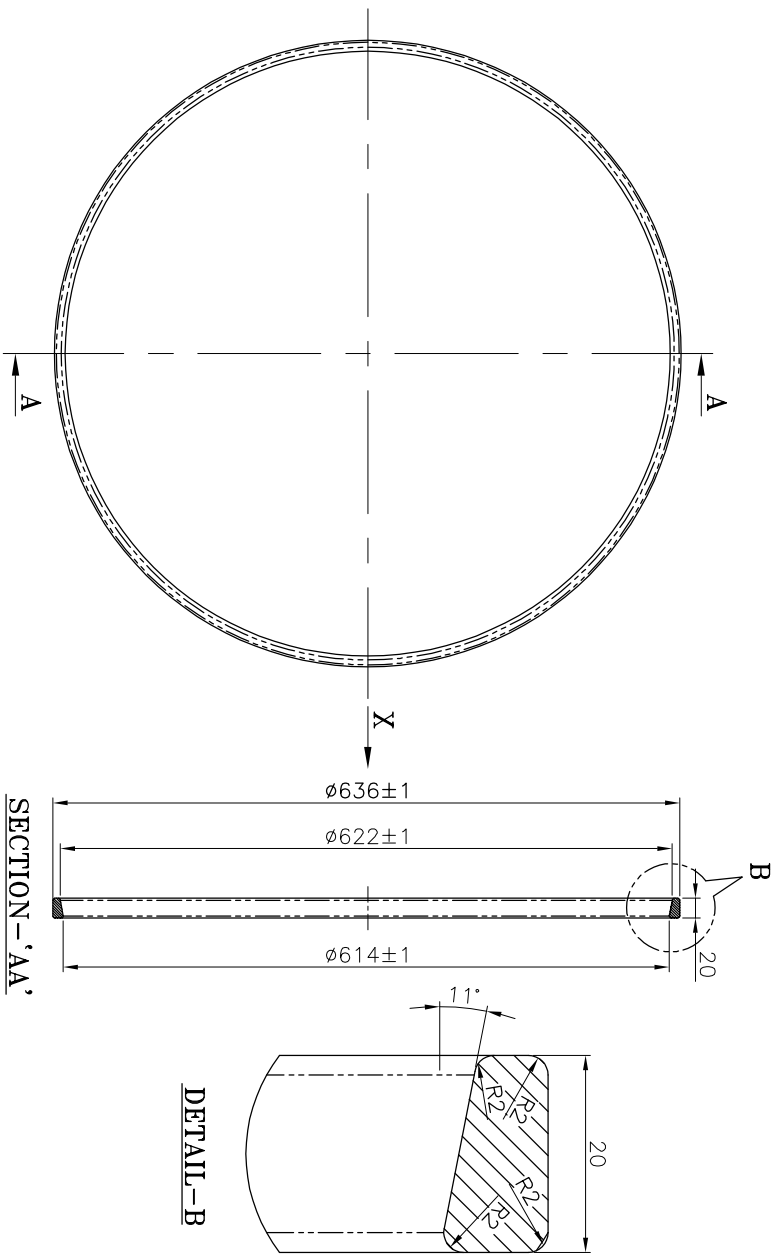
SIZE A3

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110 49 33 445 64 011

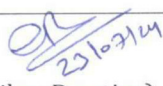
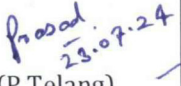
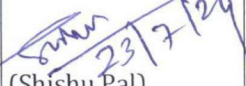
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)



- NOTES:-**
- MATERIAL:-**
1. GLASS FIBER REINFORCEMENT CONTINUOUS
 2. CLASS 'E' GLASS FIBER ROVING 30 OR 60 ENDS.
 3. RESIN EPOXY.
- TECHNICAL REQUIREMENTS:-**
1. RINGS TO BE MOULDED IN STEEL, MOULDS TO ACHIEVE DIMENSIONAL CONSISTENCY.
 2. RING TO BE REMOVED FROM MOULD AFTER COLD SET (24 HOURS) AT ROOM TEMP.
 3. RING AFTER CURING MUST GIVE METALLIC SOUND ALL OVER WHEN TAPPED BY METALLIC ROD.
 4. DURING ROUTINE TEST, MECHANICAL LOAD OF 80 KG. TO BE APPLIED ON EACH RING.
 5. THIS DRG. IS SIMILAR TO RDSO DRG. NO. SKEL-4852.

INVENTORY NO.	SIGN. & DATE	REF. DRG. NO.
VIEW-X		
SECTION-AA		
DETAIL-B		
NOTES:-		
MATERIAL:-		
TECHNICAL REQUIREMENTS:-		
ADDITIONAL INFORMATION		
STATUS OF DRAWING		
DISTRIBUTION OF PRINTS		
TIME-1, TXM-3, TNX-1		
REV. DATE ALTERED CHECKED APPROVED		
ZONE NOTE-1 & MATL. SPEC. DELETED. DIMS. GR. WAS TM20079 'M'.		
REV. DATE ALTERED CHECKED APPROVED		
ZONE MAT. SPEC. IS:10192, GR:EP-3 WAS NOT ON, & NOTES MODIFIED & UPDATED.		
DEPT. TIME UNTOL. DIMS. GR. NTS SCALE WEIGHT (K.G.) REF. TO ASSY. DRG. ITEM NO. NO. OF		
405 TM20079 GR:R' NTS NTS (K.G.) REF. TO ASSY. DRG. ITEM NO. NO. OF		
BRACING RING (NON-CONNECTION END)		
DRAWING NO. 3 445 33 64 011		
SHT. NO. 01 NO. OF SHT. 01		

	PRODUCT STANDARD TME DIVISION, BHOPAL		TM24637	
			REV 00	
			PAGE: 01 OF 01	
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED It must not be used directly or indirectly in any way detrimental to the interest of the company	<u>SPECIFICATION FOR EPOXY BRACING RING OF TRACTION MACHINES</u>			
	1.0 General This specification governs technical requirements of bracing ring of traction machines. Support rings will be wound on suitable former to give the section and dimension as specified in the relevant drawings. 1.1 Material • Glass Roving: - Continuous glass roving to BP 25693 or equivalent shall be used. • Epoxy Resin System: - Suitable epoxy resin of Class 155 or above along with suitable hardener to be used. • Release Agent: - A suitable release agent like silicone release compound, petroleum jelly or wax etc. can be used. 2.0 Ring Manufacturing Manufacturing/ Winding Mount the former on a winding machine. Apply a thin and uniform coat of release agent to the winding surfaces of the former, Wind continuous filament roving as per BP25693 impregnated with the epoxy resin system, under proper tension to produce a component, which after curing has a glass content of minimum 50% by weight. Allow the ring to cure at room temperature in the former for 12 hours minimum. Remove the ring from the former and post cure in an oven at suitable temperature. Clean the high spot and loose glass fibres on the rings by sand paper. Apply a finishing coat of Epoxy resin on the ring and allow to dry. 3.0 Inspection • Ring after curing should produce a metallic sound. • Mechanical load test done should be done as per load mentioned in corresponding drawing. • Unless or otherwise specified in drawing, max permissible tolerance on nominal internal diameter and variation in flatness on the rings when laid on a smooth surface shall be as follows: • ≤ 1000 mm ring: ± 1.0 mm. • 1000 mm up to 1500 mm ring: ± 2.0 mm. Note: All corners of the support ring must have radii as specifies in the drawing. ***			
Revision: 00 Dt: 23/07/24	Distribution TME TXM QTM MNX	Qty 1 2 1 1	Approved:  (Vikas Rawtiya) Prepared:  (P Telang) Checked:  (Shishu Pal) Date: 23/07/24	



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL **TRACTION MACHINES ENGINEERING DIVISION**



Technical Pre-Qualification Requirement

Ref No. TME/PQR/ Bracing Ring

Dated: 09/08/2024

Technical Pre-Qualification requirement of material as per spec TM24637 is as under:

Sl No.	Description	Vendor to comment	
		Complied / Not complied	Supporting relevant document to be submitted
1.	Bracing ring shall be as per BHEL specification & size shall be as per tender enquiry.	Yes/No	-
2.	Supply experience in preceding 5 years (from tender opening date) of same/similar * item.(Development/trial order shall not be considered)	Yes/No	Un-price PO copies & corresponding proof of supply (delivery challan / invoice etc.)
3.	Vendor should be a manufacturer & not a trader	Yes/No	-
4.	Manufacturing facility assessment may be carried out by BHEL at supplier's works. Vendor to confirm same.	Yes/No	-

Note:

- (*) Ring made from Epoxy resin and glass shall be considered as a similar item.
- Compliance of all the points of T-PQR are mandatory. In absence of compliance of above, vendor's offer is liable to be rejected.
- Declaration by vendor regarding information / compliance submitted by vendor shall be correct in all respect. In case any deviation / false-information is revealed later on, BHEL is free to initiate appropriate punitive proceeding as per prevalent processes and guidelines of the company.
- BHEL has right to verify information/confirmation furnished, by asking additional documents proofs etc.

(S. S. Patel) Manager/TME	(V Rawtiya) SDGM/TME
--------------------------------------	---------------------------------

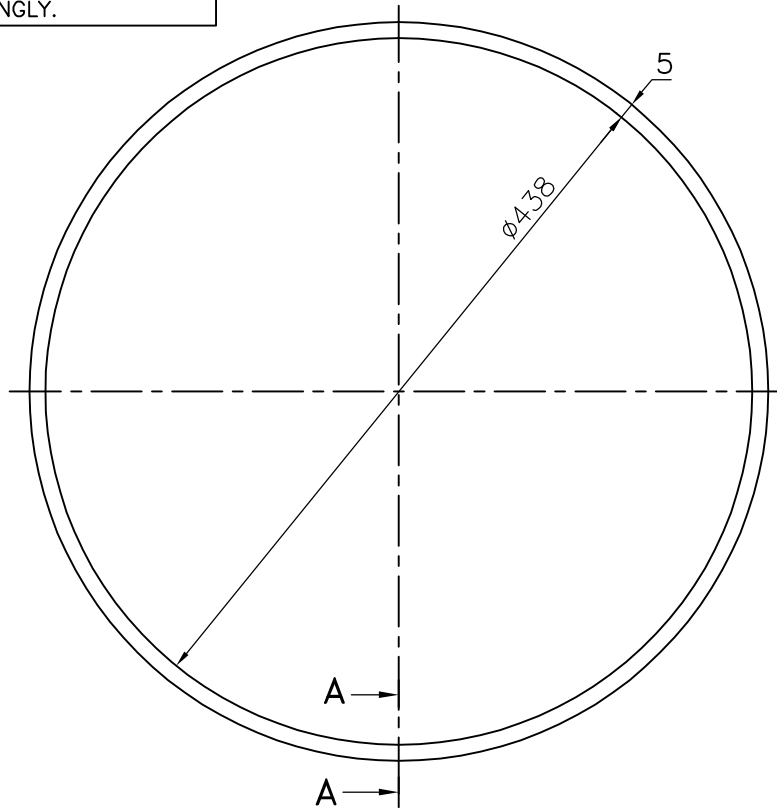
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

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REV.	DATE	ALTERED	AJ	REV.	DATE	ALTERED	AJ	ADDITIONAL INFORMATION
02	21.03.23	CHECKED	KD	01	14.03.23	CHECKED	KD	
		APPROVED	KD			APPROVED	KD	
MATERIAL WAS POLYESTER, NOTES UPDATED ACCORDINGLY.				ITEM WIDTH 10MM WAS NOT ON.				STATUS OF DRAWING
								DISTRIBUTION TME- 1, TXM-3 OF PRINTS TNX-1

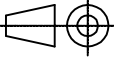
REV.	DATE	ALTERED	AJ
03	02.05.25	CHECKED	AT
MATERIAL TM24637 ADDED & NOTES UPDATED ACCORDINGLY.			



SECTION-AA

NOTES:-

1. DURING ROUTINE TEST, MECHANICAL LOAD OF 20 KG. TO BE APPLIED ON EACH RING.
2. ALL CORNERS TO BE ROUNDED / SMOOTH.

001	SEE NOTES	001	SUPPORT RING (Epoxy)			KG	0.132		
					TM24637				
VAROO QTY.	REMARKS	ITEM NO.	DESCRIPTION	STD	MATL. CODE	A C	UNIT WT.		
					MATL. SPECN.		QTY.		
CARD TYPE 3		28		28	CARD TYPE 1	28	CARD TYPE 2		
बी. सच. ई. सल.  BHARAT HEAVY ELECTRICALS LTD. BHOPAL					DRN.	NAME	SIGN	DATE	NO.OF VAR.
					CKD.	A.JHARIA		03.03.23	
					APPD.	K.D.		03.03.23	
					DEPT. TME	UNTOL. DIMS. GR.		SCALE	WEIGHT(KG)
CODE 405	TM 20079 GR. – M		NTS	0.132	2 445 33 05 052	009	001		
TITLE <u>WINDING SUPPORT RING</u> (IM3004AZ)					DRAWING NO.			REV	
					4 445 33 05 053			03	
					SHT.NO	01	NO.OF.SHT.	01	



नमोनेन्द्र
 वि. एम. एन. ट्रा. सिंग
 उप प्रधान, वि. एम. एन. ट्रा. सिंग
 टी. एक्स. एम. आर. वि. एम. एन. ट्रा. सिंग
 बी. एच. ई. एल., भोपाल

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY CONTROL, TRANSPORTATION
QUALITY ASSURANCE PLAN(QAP)

QA PLAN NO. : QTM/TXM/VENDOR/QAP/2016-17/6FRA6068/BRACING RING (INNER) DT. 12.08.2016 REV 00
REFERENCE- DRG NO. 34453364007

SL. NO.	CHARACTERISTIC	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOCUMENT	FORMAT OF RECORD	REMARKS
				TP	TP/A			
1.0	Raw Material Test Certificate	A	VR	100%	100%	Drq. no. 34453364007 (Latest revision)	TR	TEST LAB NABL / EQUIVALENT ACCREDITED/ SOURCE MILL. (Supplier to get the raw material correlated with TC, purchase document from TP/A/QC), TC to be Submitted
2.0	Dimension	A	I	100%	5%	Drq. no. 34453364007 (Latest revision),	SR	Report to be submitted
3.0	Routine test	A	I	100%	5%	Note 6 of Drq. no. 34453364007 (Latest revision),	SR	Report to be submitted
4.0	Identification Vendor Name, PO No. & item serial no.	A	VR	100%	5%	PO/Drawing	SR	---
5.0	Packaging suitability for transit & storage	B	VR	100%	5%	---	SR	Packaging shall be such that during transit components should not damage.
PREPARED BY		APPROVED BY						
Shalendra Kumar Ram Yadav Manager, QAP		Jalendra Kumar Ram Yadav 12/8/16						

Notes: 1) All TR, SR checked by BH/TP/A/QC (duly signed & sealed) as per above QAP requirement shall be submitted along with consignment.

Abbreviation: A - Critical, B - Major, VR - Verification, I - Instrument/ Gauges,

T R - Test Record, S R - Shop Record.

AGENCIES:

TP/A - BHEL appointed third Party Inspecting Agency

TP - Task Performer

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY CONTROL TRANSPORTATION
QUALITY ASSURANCE PLAN(QAP)

QA PLAN NO. : QTM/TXM/VENDOR/QAP/2016-17/6/FRA6068/BRACING RING (OUTER) DT. 12.08.2016 REV 00
 REFERENCE - DRG NO. 34453364008

SL. NO.	CHARACTERISTIC	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOCUMENT	FORMAT OF RECORD	REMARKS
				TP	TP/A			
1.0	Raw Material Test Certificate	A	VR	100%	100%	Drg. no. 34453364008 (Latest revision)	TR	TEST LAB NABL / EQUIVALENT ACCREDITED/ SOURCE MILL. (Supplier to get the raw material correlated with TC, purchase document from TP/A/QC), TC to be Submitted
2.0	Dimension	A	I	100%	5%	Drg. no. 34453364008 (Latest revision),	SR	Report to be submitted
3.0	Routine test	A	I	100%	5%	Note 6 of Drg. no. 34453364008 (Latest revision),	SR	Report to be submitted
4.0	Identification Vendor Name, PO No. & item serial no.	A	VR	100%	5%	PO/Drawing	SR	---
5.0	Packaging suitability for transit & storage	B	VR	100%	5%	---	SR	Packaging shall be such that during transit components should not damage.
PREPARED BY				APPROVED BY				

Notes:

1) All TR, SR checked by TP, TP/A/QC (duly signed & sealed) as per above QAP requirement shall be submitted along with consignment.

Abbreviation: A - Critical, B- Major, VR - Verification, I-Instrument/ Gauges,

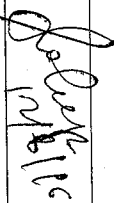
TR - Test Record, SR- Shop Record.

AGENCIES:

TP/A -BHEL appointed third Party Inspecting Agency

TP - Task Performer

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL
QUALITY CONTROL TRANSPORTATION
QUALITY ASSURANCE PLAN(QAP)
QA PLAN NO. : QTM/TXM/VENDOR/QAP/2016-17/6FRA6068/BRACING RING (NCE) DT. 12.08.2016 REV 00
REFERENCE - DRG NO. 34453364011

SL. NO.	CHARACTERISTIC	CLASSIFICATION	TYPE OF CHECK	QUANTUM OF CHECK		REF. DOCUMENT	FORMAT OF RECORD	REMARKS
				TP	TP/A			
1.0	Raw Material Test Certificate	A	VR	100%	100%	Drg. no. 34453364011 (Latest revision)	TR	TEST LAB NABL / EQUIVALENT ACCREDITED/ SOURCE MILL. (Supplier to get the raw material correlated with TC, purchase document from TP/A/QC), TC to be Submitted
2.0	Dimension	A	I	100%	5%	Drg. no. 34453364011 (Latest revision),	SR	Report to be submitted
3.0	Routine test	A	I	100%	5%	Note 6 of Drg. no. 34453364011 (Latest revision),	SR	Report to be submitted
4.0	Identification Vendor Name, PO No. & item serial no.	A	VR	100%	5%	PO/Drawing	SR	---
5.0	Packaging suitability for transit & storage	B	VR	100%	5%	--	SR	Packaging shall be such that during transit components should not damage.
PREPARED BY		APPROVED BY						
 Shalendra Kumar Yadav Engineer		 J. K. Singh BHEL Division						

Notes:
 1) All TR, SR checked by TP/A/QC (duly signed & sealed) as per above QAP requirement shall be submitted along with consignment.

Abbreviation: A - Critical, B - Major, VR - Verification, I - Instrument/ Gauges,
 T R - Test Record, S R - Shop Record.

AGENCIES:

TP/A -BHEL, appointed third Party Inspecting Agency
 T P - Task Performer



BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

QUALITY ASSURANCE PLAN FOR WINDING SUPPORT RING TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. -QAP/QTm/VENDOR QAP/2023-24/ IM3004/ WINDING SUPPORT RING REV 00 DTD. 15.12.2023

Reference Document- PO DRAWING/SPECIFICATION

Page : 1 of 2

SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TPIA					
1)	Raw material	All test	TC verification	100%	100%	As per detail mentioned in drawing	As per detail mentioned in drawing	MTC	BHEL/TPIA	1. TC from NABL Lab/MILL TC to be submitted along with supply. 2. Supplier to get the raw material TC correlated with material TC.
2)	Dimension	Dimension	TC verified & Measurement	100%	10%	As per drawing	As per drawing	Supplier record	BHEL/TPIA	Dimension to be Witnessed
SL. NO	COMPONENT	CHARACTERISTICS	TYPE OF CHECK	QUANTAM OF CHECK		REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	INSPECTION AGENCY	REMARKS
				TP	TPIA					

Prepared By

अमित सेन / AMIT SEN
अभियंता / Engineer
स्क्यू टी.एम. विभाग / Q.T.M. Division
बी.एच.ई.एल. भोपाल / BHEL, BHOPAL

Approved By

गजेन्द्र सिंह राठौर / G.S. RATHORE
उप प्रबंधक / Dy. Manager
स्क्यू टी.एम. विभाग / QTM Division
बी.एच.ई.एल. भोपाल / BHEL, BHOPAL

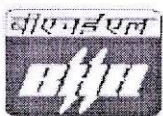
आशीष मिश्रा / ASHISH MISHRA
प्रबंधक (आंकड़ा) / Manager (Design)
टी.एम.ई. विभाग / T.M.E. Division
बी.एच.ई.एल. भोपाल / BHEL, BHOPAL

मनेन्द्र सिंह / MANENDRA SINGH
उप प्रबंधक / Dy. Manager
टी.एम.ई. विभाग / T.M.E. Division
बी.एच.ई.एल. भोपाल / BHEL, BHOPAL

Issued By

अमित सेन / AMIT SEN
अभियंता / Engineer
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BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

QUALITY ASSURANCE PLAN FOR WINDING SUPPORT RING TO BHEL ORDERING SPECIFICATION/DRAWING AS PER PO

QUALITY PLAN NO. –QAP/QTm/VENDOR QAP/2023-24/ IM3004/ WINDING SUPPORT RING REV 00 DTD. 15.12.2023
Reference Document- PO DRAWING/SPECIFICATION

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3)	Visual	Burr, Sharp edges, surface finish	visual	100%	10%	As per drawing & specification	As per drawing & Specification	Supplier record	BHEL/TPIA	Witness
4)	Identification vendor name, PO & job serial no.	Visual	Visual	100%	10%	As per drawing	As per drawing	Supplier record	BHEL/TPIA	Witness

Prepared By

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