

MACHINING OF LABYRINTH RING

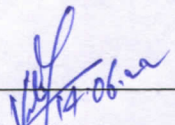
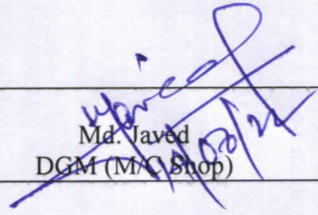
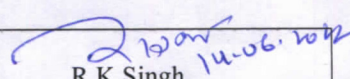
INDENT NO: 20220037

PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 4200 mm, and weight 26MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 26MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-203-01-18410/M1:Rev-A	Vendor to confirm
2	Vendor to arrange all tools & instruments required for machining of the job	Vendor to confirm
3	BHEL reserves the right to visit vendor for stage inspection during job machining to assess the progress and technical aspects and further processing shall be done accordingly.	Vendor to confirm
4	Final Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
5	Delivery requirement: 5 weeks/pc from the date of lifting	Vendor to confirm
6	Identification details on the casting to be maintained	Vendor to confirm
7	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
8	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
9	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

 Vikalp Bihuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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DRAWING NUMBER
2-203-01-18410/M1

CONTROLLED COPY
Foundry Technology
C.No. SF/13
Date.....

Date.....26 MAY 2022

NOTE

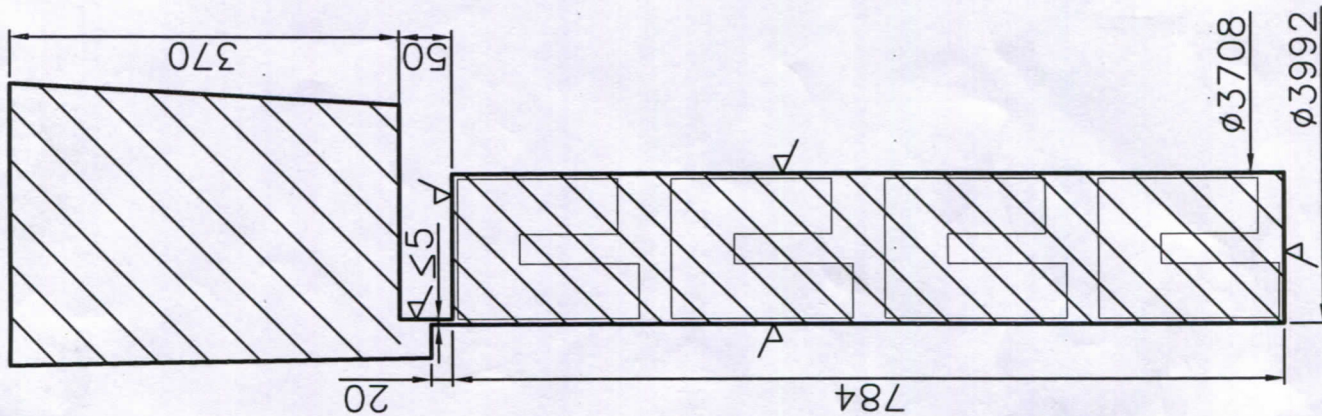
1. CASTING TO BE ROUGH MACHINED ON SURFACE MARKED ✓ TO THE DRAWING DIMENSIONS AND SURFACE FINISH 12.5 MICRONS AND TO THE TOLERANCE OF +2 ON OD & HT AND -2 ON ID, UNLESS OTHERWISE STATED.

-0	+0
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2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO PROPOSED SUPPLY SKETCH DRG. NO. 2-203-01-18410 4N1/M/P AND COMPONENT DRG NO. 2-203-01-18410 REV 01.

3. WEIGHT OF CASTING BEFORE MACHINING: 25382 KGS
(INCLUDING RISER WEIGHT).

WEIGHT OF CASTING AFTER MACHINING: 19360 KGS.



REV	DATE	ALTERED	RAMAKSHISH
Q	25.03.22	CHECKED	LAVIN
ZONE		AS PER SHOP FEEDBACK ROUGH M/C DRAWING MODIFIED.	
		FT/M/2022:-03	
			
BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWARE			
DEPT.	FDY. TECH.		SCALE
		N.T.S.	WEIGHT IN Kgs
TITLE		ROUGH M/C DRG. OF (4 IN1) UPPER STATIONARY LABYRINTH	
PROJECT AND CUSTOMER NAME	TECHNOLOGY NO		
PRANABITA-T/KALSHESWARAM-12P2	2-203-01-18410/M1		
BHDEL/BHOPAL	23505A		
	SHEET NO - 1	NO. OFF SHEETS-1	

22613

Item Description

Tender Enquiry No	FF/SC/22013/202200371
Item	Upper Stationary Labyrinth (4N1) Nickel= 3.5% - 4.5%
Drg No	2-203-01-18410/M1: Rev-A
Quantity	01 No
Delivery Terms	5 Weeks/Piece
befor Machingh Wt	25382 KG
After Machinigh Wt	19360 KG