

MACHINING OF LABYRINTH RING

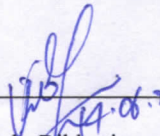
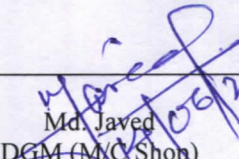
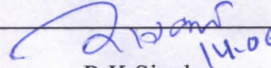
INDENT NO: 20220049

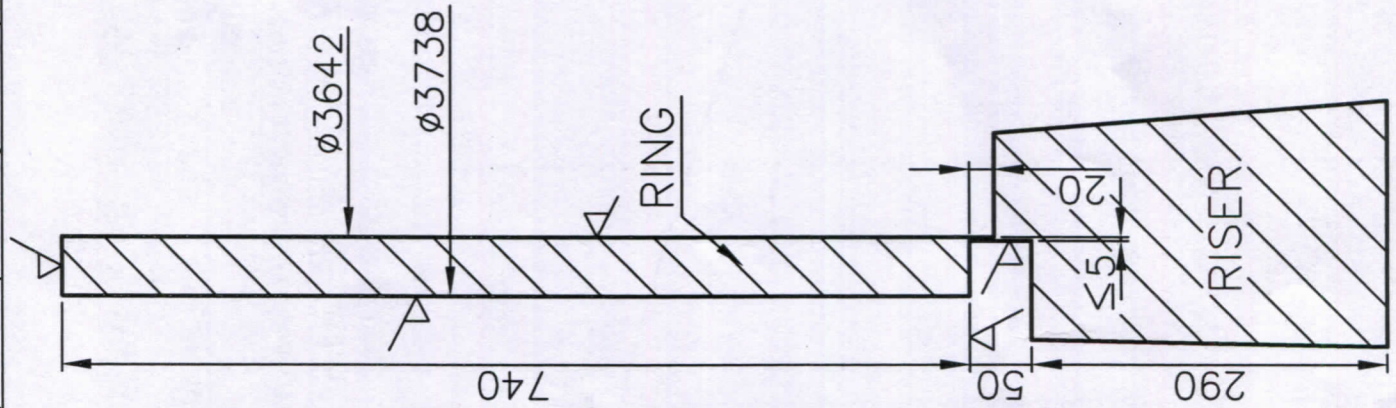
PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 3950 mm, and weight 15MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 15.0MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18102/M4:Rev-00	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:- c) Details of the Organization d) 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 Bibhuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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DRAWING NUMBER
3-204-07-18102/M4

CONTROLLED COPY
Foundry Technology
C.No. SF/ 2-2-
date 28 MAY 2022

NOTE

1. CASTING TO BE ROUGH MACHINED ON THE SURFACES 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. $-0 \quad +0$
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER TO PROPOSED SUPPLY SKETCH DRG. NO. 3-204-07-18102 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18102.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 14190 KGS.
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 8257 KGS.



BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORGE PLANT

REV	DATE	ALTERED	CHECKED	DEPTT.	FDY. TECH.	SCALE	N.T.S.	WEIGHT IN Kgs	NAME	SIGN	DATE
ZONE				TITLE		ROUGH M/C DRG. FOR (4 in 1)		LOWER ROTATING LABYRINTH		DRAWING NO	
				PROJECT AND CUSTOMER NAME		PALAMURU BR. I		TECHNOLOGY NO		3-204-07-18102/M4	
				BHEL / BHOPAL		23502D		SHEET NO. - 1		NO. OFF SHEETS-1	

Item Description

Tender Enquiry No	FF/SC/22019/202200491
Item	Lower Rotating Labyrinth (4N1) Nickel= 3.5% - 4.5%
Drg No	3-204-07-18102/M4: Rev-00
Quantity	01 No
Delivery Terms	5 Weeks/Piece
befor Machingh Wt	14190 KG
After Machinigh Wt	8257 KG