

MACHINING OF BOTTOM SHAFT

Indent No- 20220085

iii) PRE QUALIFICATION REQUIREMENT

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a LATHE machine having "Swing over bed (SOB)" Dia 2000mm or more and that can accommodate a job of length 4.4metres or more and has loading capacity of 47MT or more	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq 47.0\text{MT}$	Vendor to Confirm and submit detail
3	Vendor should have previous experience of machining of a shaft type of job having maximum Dia $\geq 1200\text{mm}$, Length ≥ 3 metres and weight $\geq 30\text{MT}$.	Vendor to Confirm and submit detail

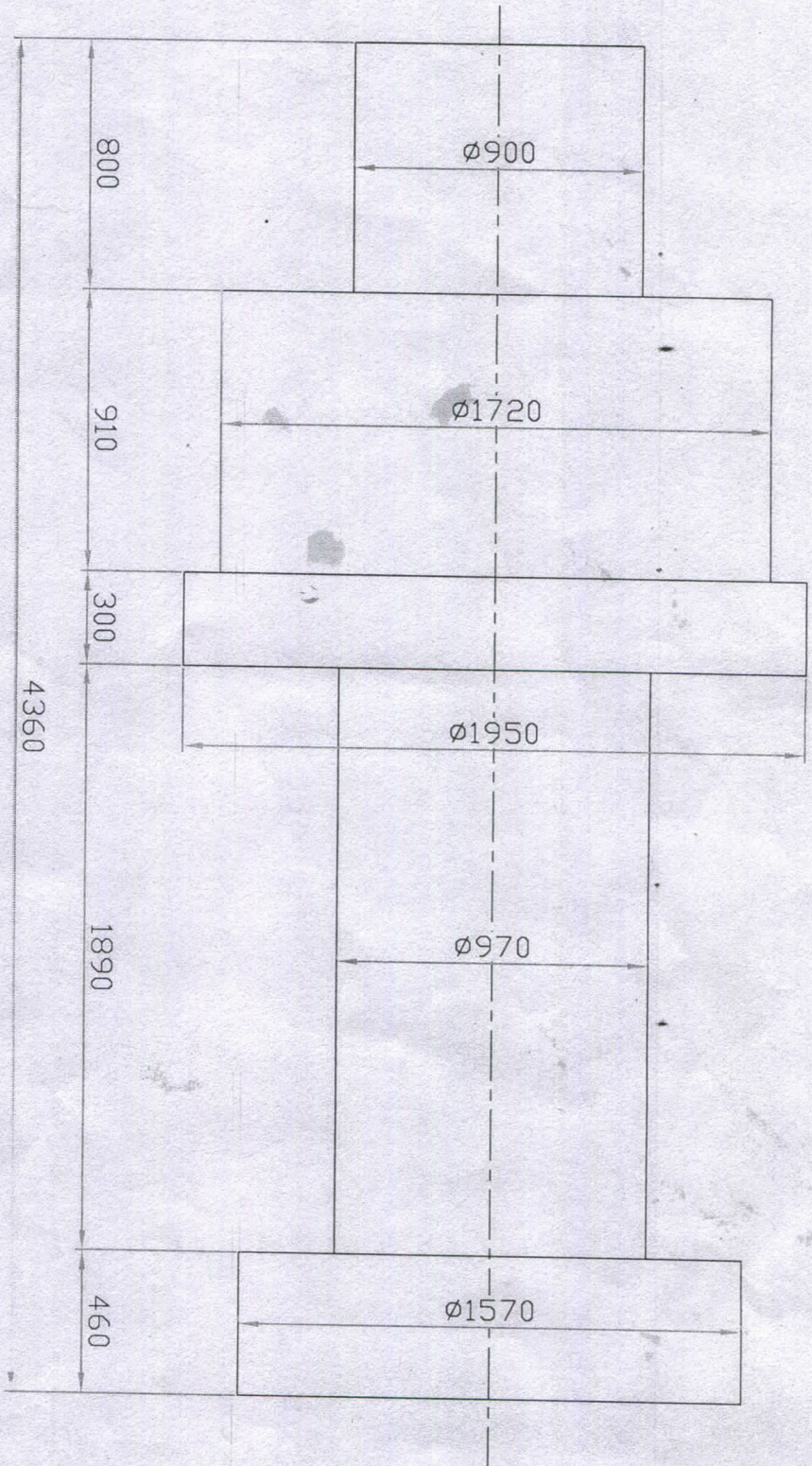
iv) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 04-D-5237: 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: 8 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 to submit Filled Supplier Registration Form along with Requisite Documents to SDC Cell in MM Deptt. of CFFP, BHEL, Haridwar. If already registered at CFFP or any other unit of BHEL, then Vendor code may be furnished.	Vendor to submit
9	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
10	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)

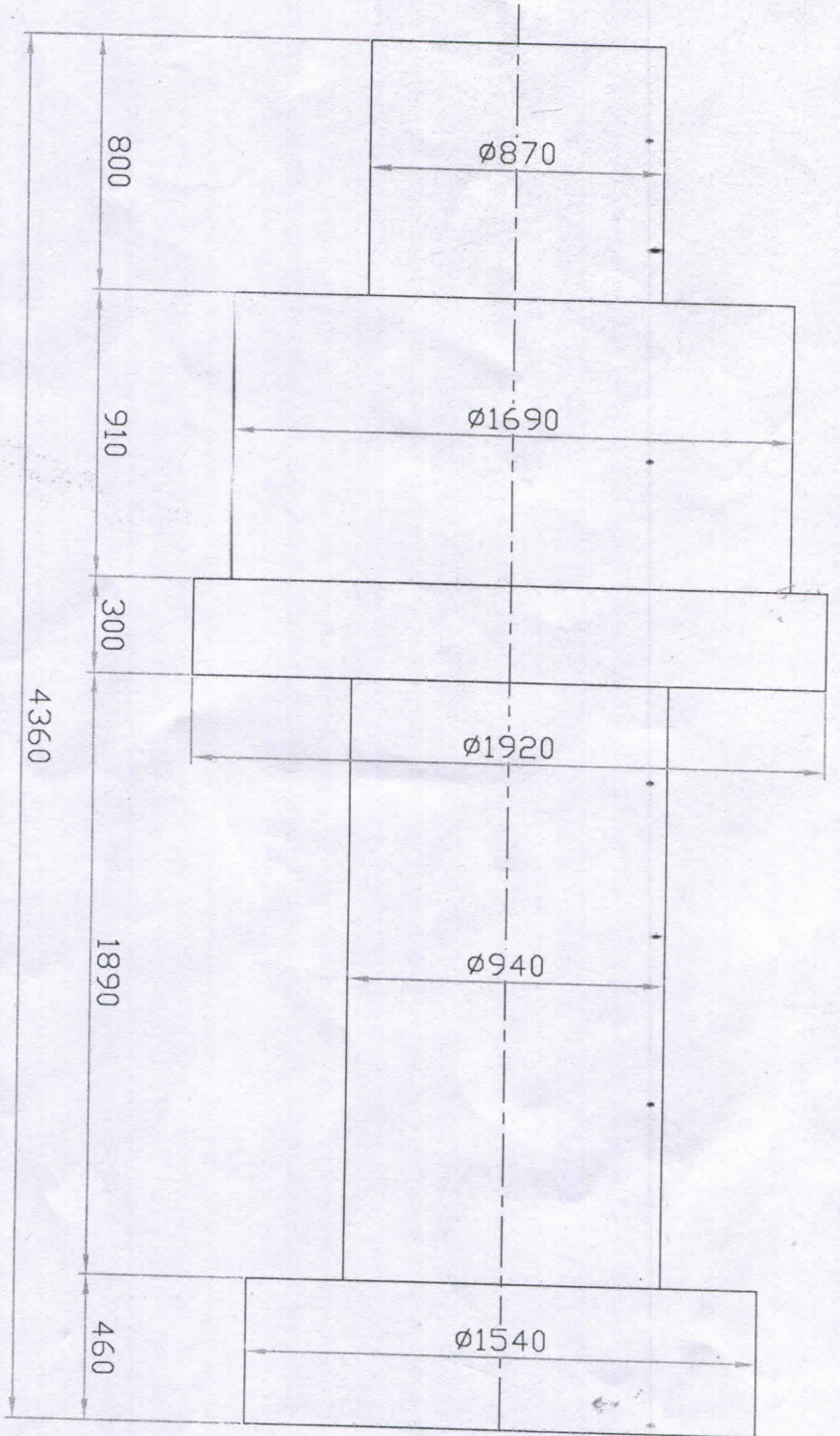
R.K.Singh
AGM (M/C Shop)



REV.	DATE	ALTERED BY	CHECKED BY	REV.	DATE	ALTERED BY	CHECKED BY	REV.	DATE	ALTERED BY	CHECKED BY

		ITEM BOTTOM SHAFT	
DRN.	APPR.	COND.	AS FORGED
Pyramod 21/05/12	Pc		
31/05/12			
W. O. C.F.P. : MF2-5237-U2		MATERIAL : HG-10035	
SCALE : N.T.S		Wt. : 43040 KG.	
CUSTOMER BHEL, HYDERABAD		C.F.P. DRG. NO. F - 5237	
REV. NO. 00		REV. NO. 00	

P 222018

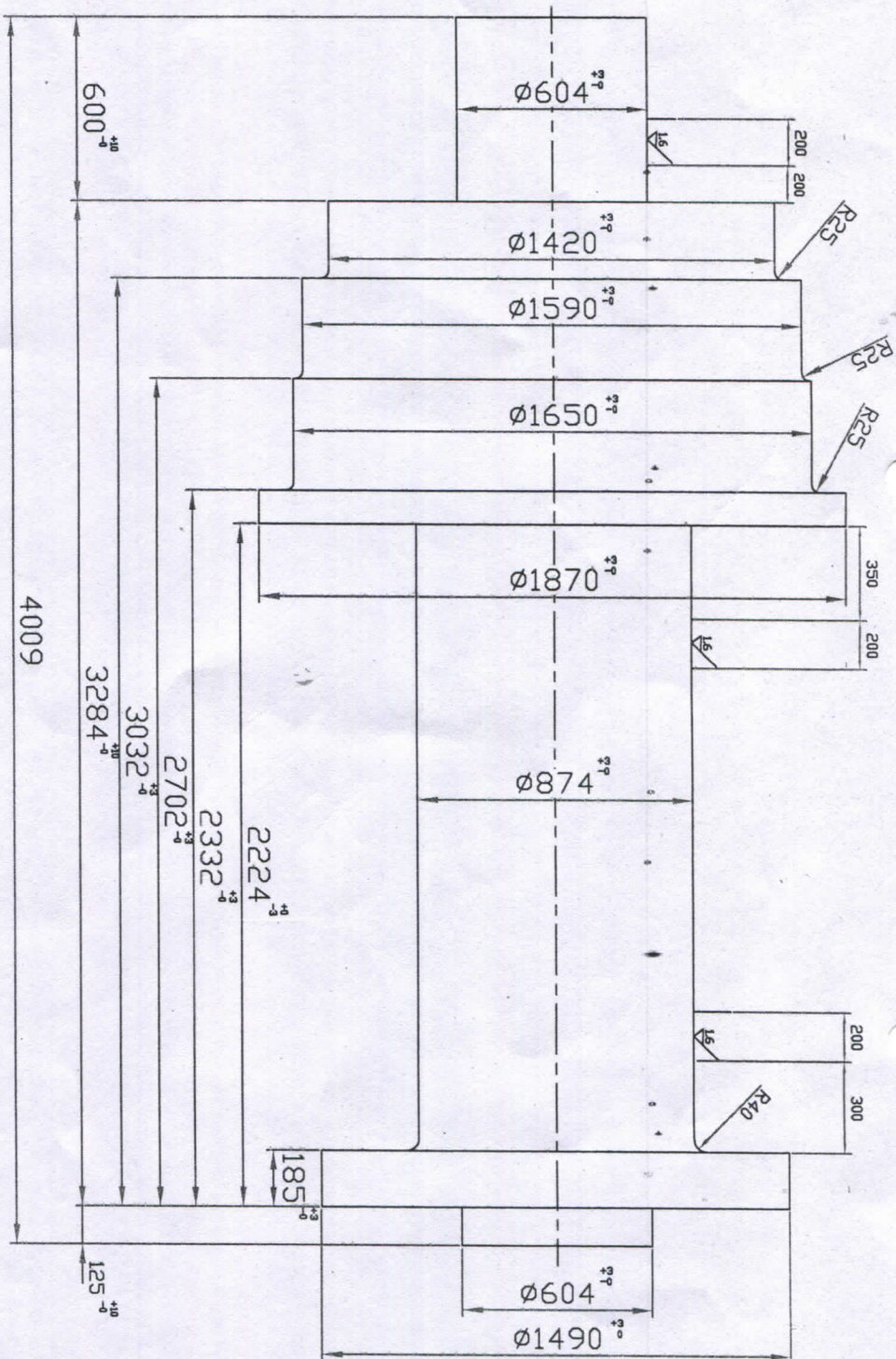


NOTE:
TOLERANCE ON DIA +3, -0
ON TOTAL LENGTH +10, -0

REV.	DATE	ALTERED BY	CHECKED BY	REV.	DATE	ALTERED BY	CHECKED BY

		ITEM
BOTTOM SHAFT		COND.
DRN.	APPD.	PRE U.T
P. 2024/04/31/05/212 9K 5164/31/05/212		
W. O. GTFP : MF2-5237-U2 MATERIAL : HG-10035 SCALE : N.T.S WT. : 43385 KG CUSTOMER : BHEL, HYDERABAD DRG. NO. : 2-254-01-19702 R00 GTFP DRG. NO. : U - 5237 REV. NO. : 00		

6.3
ALL OVER
EXCEPT STATED



NOTE:

1. TOLERANCE

OUTSIDE DIMENSION: $+3/-0$, ON INSIDE GAP: $-3/+0$,

TOTAL LENGTH: $+10/-0$

ON OUTSIDE GAP: $+3/-0$

2. UNSPECIFIED RADIUS SHALL BE TAKEN AS R10.

3. BAND RUNOUT SHALL BE WITHIN 0.2 MM

4. ALL FACES SHALL BE PARALLEL AND SQUARE TO THE AXIS

 FORCE SHOP		ITEM	
DRG.	CHKD.	BOTTOM SHAFT	
APPRD.	APPRD.		
COND.		AS DELIVERED	
W. O. CFP : MF2-3654-U2		CUSTOMER	
MATERIAL : HG-10035		NAME	
SCALE : N.T.S		DRG. NO.	
WT : 30582 KG.		2-254-01-19702 R00	
CFPP DRG. NO.		REV. NO.	
04-D-5237		00	

P222018

Item Description

Tender Enquiry No	FF/SC/P22018/202200851
Item	Bottom Shaft Forging
Drg No	F-5237:Rev-00,04-D-5237:Rev-00
Quantity	2 No
Delivery Terms	8 Weeks / Pc
Before M/c weight	43040 KG
After M/c weight	30582 KG

Remarks:

MARK AS PER DLY DRG: 04-D-5237R00

MACHINE TO DRG U-5237R00 AND OFFER FOR U.T,IF O.K IN UT
THEN M/C TO DELY DRG: 04-D-5237R00

FORGE NO TO BE PUNCHED

SIZES & WTS ARE TECHNOLOGICAL AND INDICATIVE ONLY AND
ACTUAL MAY VARY.

ACTUAL CHIPS GENERATION =WT AT LIFTING -WT OF FORGING
RECV AFTER M/C.

RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS

SINGLE RATE TO BE QUOTED FOR THESE JOBS.

PQR & TR AS PER ANNEXURE: 25237/A1

ACTUAL WEIGHMENT TO BE DONE FOR BOTH OUTGOING &
INCOMING JOB.