

MACHINING OF RUNNER CROWN**Indent No-20220081****i) PRE QUALIFICATION REQUIREMENT**

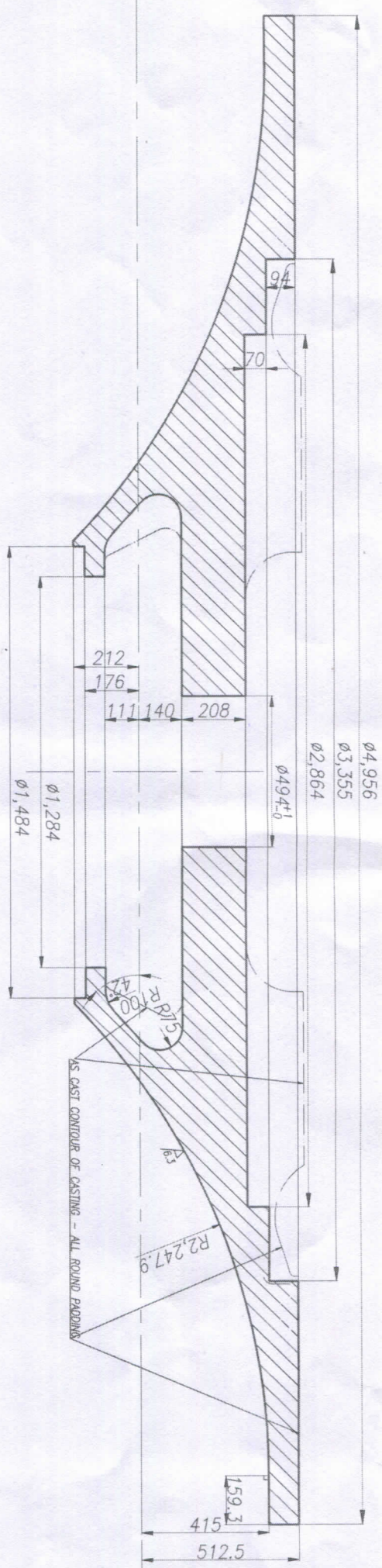
S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar jobs having max. dia. greater than 3000 mm and weight more than 20MT to the full satisfaction of the customer (Both criteria may be fulfilled through one or more jobs)	Vendor 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

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no. 0-204-07-21203/M:Rev-00	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: 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 Bibhuti Dy. Manager (M/C Shop)	Md. Javed DGM (M/C Shop)	R.K. Singh AGM (M/C Shop)
--	-----------------------------	------------------------------

ALL OVER
12.5/
EXCEPT AS SHOWN



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

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 FORCE PLANT RANIPUR HARDWAR	
DEPT.	F.D.Y. TECH.	SCALE	N.T.S.
ROUGH M/C DRG FOR CROWN OF IMPELLER		WEIGHT IN Kgs	
PROJECT AND CUSTOMER NAME PAJAMARD RANGAREDDY I BHEL-BHOPAL		TECHNOLOGY NO	0-204-07-21203/M
DRAWING NO 23608		SHEET NO.- 1 NO. OF SHEETS-1	
DRN	23/P R REDDY/23497M	NAME	SIGN
WHD	NAVEEN	DATE	18/12/21
CHD	NK GAURAV	DATE	18/12/21
APPD	R LAKRA	DATE	18/12/21

22031

Item Description

Tender Enquiry No	FF/SC/22031/202200811
Item	Impeller Crown (PRR1) Nickel= 3.5% - 4.5%
Drg No	0-204-07-21203/M: Rev-00
Quantity	04 No
Delivery Terms	6 Weeks/Piece
befor Machingh Wt	36000 KG
After Machinigh Wt	24600 KG

Remarks:-

GRADE CONTAINS NICKEL= 3.5-4.5%

RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS

PQR & TR AS PER ANNEXURE-53825/A1

ACTUAL WEIGHMENT TO BE DONE FOR BOTH OUTGOING &
INCOMING JOB