

MACHINING OF LABYRINTH RING

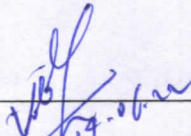
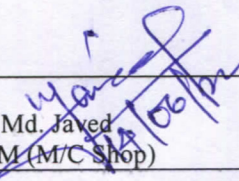
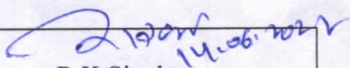
INDENT NO: 20220039

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. 4050 mm, and weight 19MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 19.0MT	Vendor to Confirm and submit detail

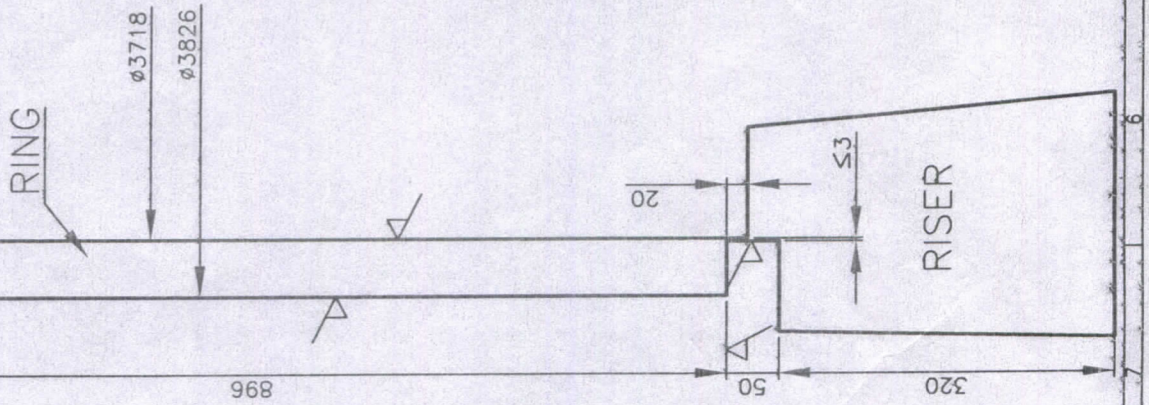
TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18402/M3: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:- 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 Bibhuti Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN M.M.)

DRAWING NUMBER
3-204-07-18402/M3



NOTE

1. CASTING TO BE ROUGH MACHINED ON 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 +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. 3-204-07-18402 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18402 REV 01.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 18874 KGS
ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 10997 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SF/.....4.....
Date..2.8.APR.2022

		BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT	
REV	DATE	ALTERED	CHECKED
ZONE			
DRG. NO.		DATE	
3-204-07-18402/M3		2.8.APR.2022	
PROJECT AND CUSTOMER NAME		DRAWING NO.	
PRANABHATI-71, KALSHESWARAM L2P2		3-204-07-18402 /M3	
BHEL / BHOPAL		SHEET NO. - 1	
235048		NO. OF SHEETS - 1	

Tender Enquiry No	FF/SC/22007/202200202
Item	Lower Rotating Labyrinth (4N1) Nickel= 3.5% - 4.5%

Issue of Material to Sub Store			Return of Material From S/c				Stock Details	
Sn	Sizedrgno	Qty /wt	Iden No	Wono	Size/Drgno	Qty/Wt	Sizedrgno	Wt
1	3-204-07-18402/M3:Rev-00	2 18874.00	S	53818	3-204-07-18402/M3 :Rev-00	2 10997.00		

Remarks:-

MARK & MACHINE AS PER DLY DRG.
IDENTIFICATION NO TO BE PUNCHED
SEAL TO BE RETAINED
GRADE CONTAINS NICKEL=3.5-4.5%
RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS