

MACHINING OF LABYRINTH RING

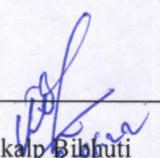
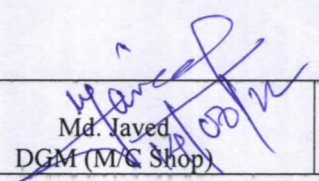
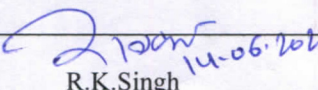
INDENT NO: 20220036

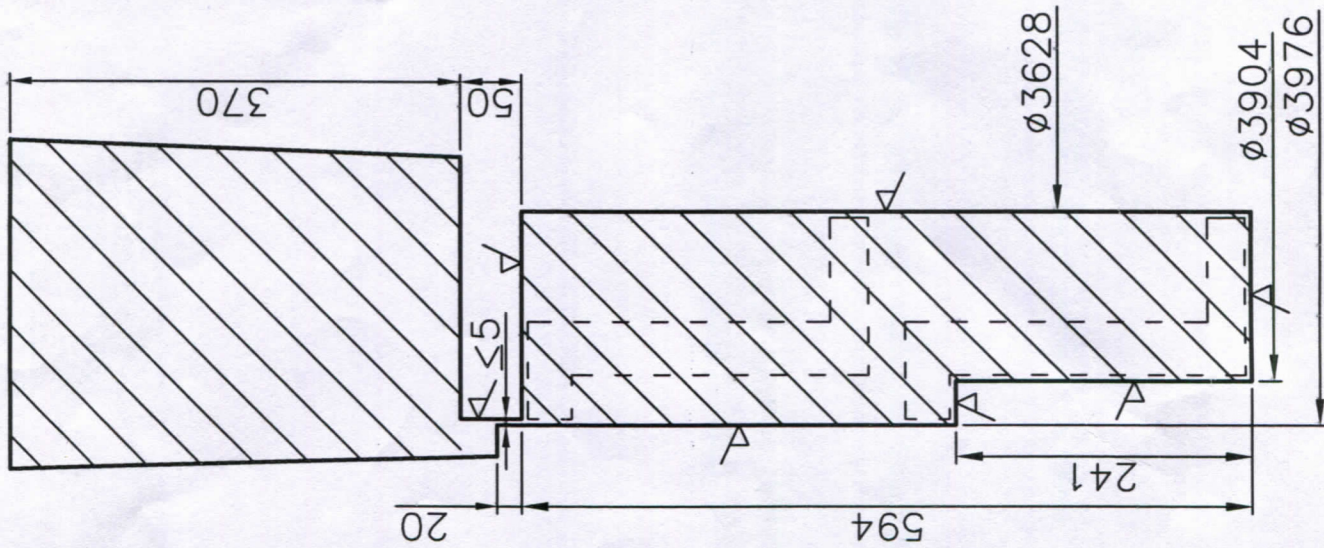
PRE QUALIFICATION REQUIREMENT

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 22MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 22MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-202-05-18402/M: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 Bishnuthi Dy. Manager (M/C Shop)	 Md. Javed DGM (M/C Shop)	 R.K. Singh AGM (M/C Shop)
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DRAWING NUMBER
2-202-05-18402 /M

CONTROLLED COPY
Foundry Technology
C.No. SF/.....12.....
Date.....25 MAY 2022

NOTE

1. CASTING TO BE ROUGH MACHINED ON 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. 2-202-05-18402 2N1/M/P AND COMPONENT DRG NO. 2-202-05-18402 REV 01.
3. WEIGHT OF CASTING BEFORE MACHINING: 21825 KGS
(INCLUDING RISER WEIGHT).
WEIGHT OF CASTING AFTER MACHINING: 18675 KGS.



BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORGE PLANT

REV	DATE	ALTERED	RAMAKISH	DEPT.	FDY. TECH.	SCALE	N.T.S.	WEIGHT IN kg	NAME	SIGN	DATE
0	25.05.22	CHECKED	LAVIN						DRN	23/04/ESHWARAM-12P2	23/05/2022
ZONE AS PER SHOP FEEDBACK											
ROUGH M/C DRAWING											
MODIFIED.											
FT/M/2022-02											
PROJECT AND CUSTOMER NAME											
KALSHESWARAM-12P2											
BHEL / BHOPAL											
DRAWING NO											
2-202-05-18402 /M											
SHEET NO.- 1											
NO. OF SHEETS-1											

Tender Enquiry No	FF/SC/22012/202200362
Item	Lower Stationary Labyrinth (2N1) 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	2-202-05-18402/M:Rev-A	2	S	53815	2-202-05-18402/M	2		
		21825.00			:Rev-A	18675.00		

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