

MACHINING OF LABYRINTH RING

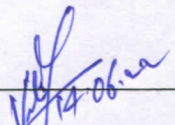
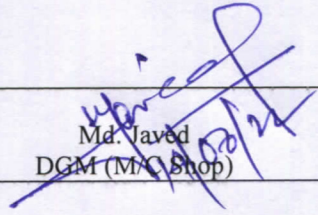
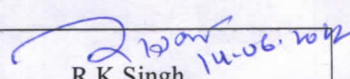
INDENT NO: 20220037

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 26MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 26MT	Vendor to Confirm and submit detail

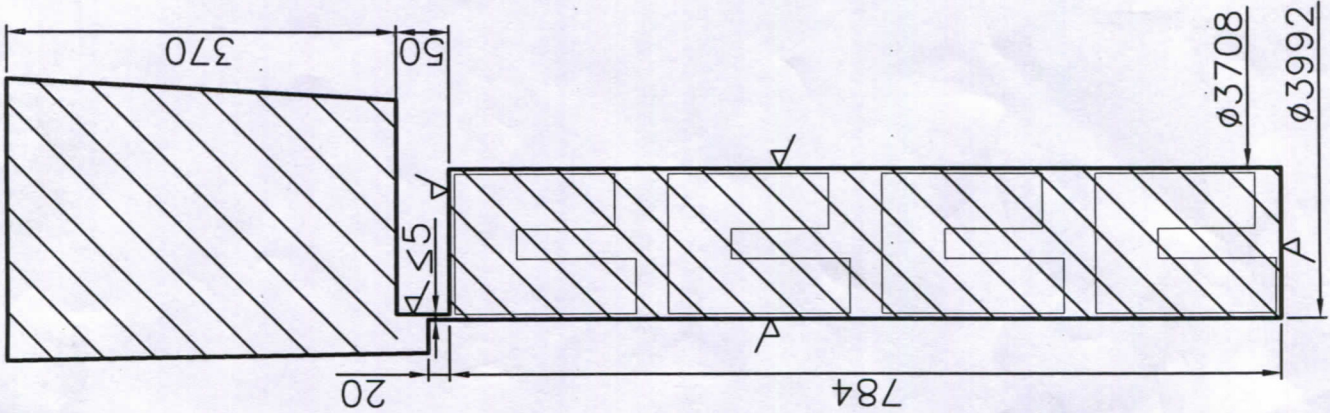
TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 2-203-01-18410/M1: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 Bihuti 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
2-203-01-18410/M1



CONTROLLED COPY
Foundry Technology
C.No. SF/13
Date.....26 MAY 2022

NOTE

1. CASTING TO BE ROUGH MACHINED ON SURFACE 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. 2-203-01-18410 4N1/M/P AND COMPONENT DRG NO. 2-203-01-18410 REV 01.
3. WEIGHT OF CASTING BEFORE MACHINING: 25382 KGS (INCLUDING RISER WEIGHT).
WEIGHT OF CASTING AFTER MACHINING: 19360 KGS.



BHARAT HEAVY ELECTRICALS. LTD.
CENTRAL FOUNDRY FORCE PLANT

REV	DATE	ALTERED	RAMAKISH
0	23.05.22	CHECKED	LAVIN
ZONE AS PER SHOP FEEDBACK ROUGH M/C DRAWING MODIFIED.			
FT/M/2022:-03			

DEPT.	FDY. TECH.	SCALE	N.T.S.	WEIGHT IN Kgs	NAME	SKN	DATE
ROUGH M/C DRG. OF (4 IN1) UPPER STATIONARY LABYRINTH							
PROJECT AND CUSTOMER NAME				TECHNOLOGY NO	DRAWING NO	SHEET NO. - 1	
PRANABHATI-71/KALASERWARAM-12P2 BHEL / BHOPAL				23505A	2-203-01-18410/M1	NO. OFF SHEETS-1	

22013

Tender Enquiry No	FF/SC/22013/202200372
Item	Upper Stationary 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	2-203-01-18410/M1:Rev-A	1	S	53816	2-203-01-18410/M1	1		
		25382.00			:Rev-A	19360.00		

REMARKS:-

MARK & MACHINE AS PER DLY DRG.

IDENTIFICATION O. TO BE PUNCHED

SEAL TO BE RETAINED

GRADE CONTAINS NICKEL:3.5-4.5%

RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS