

MACHINING OF LABYRINTH RING

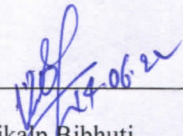
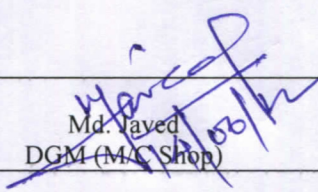
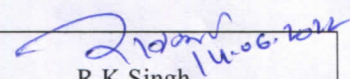
INDENT NO: 20220038

PRE QUALIFICATION REQUIREMENT

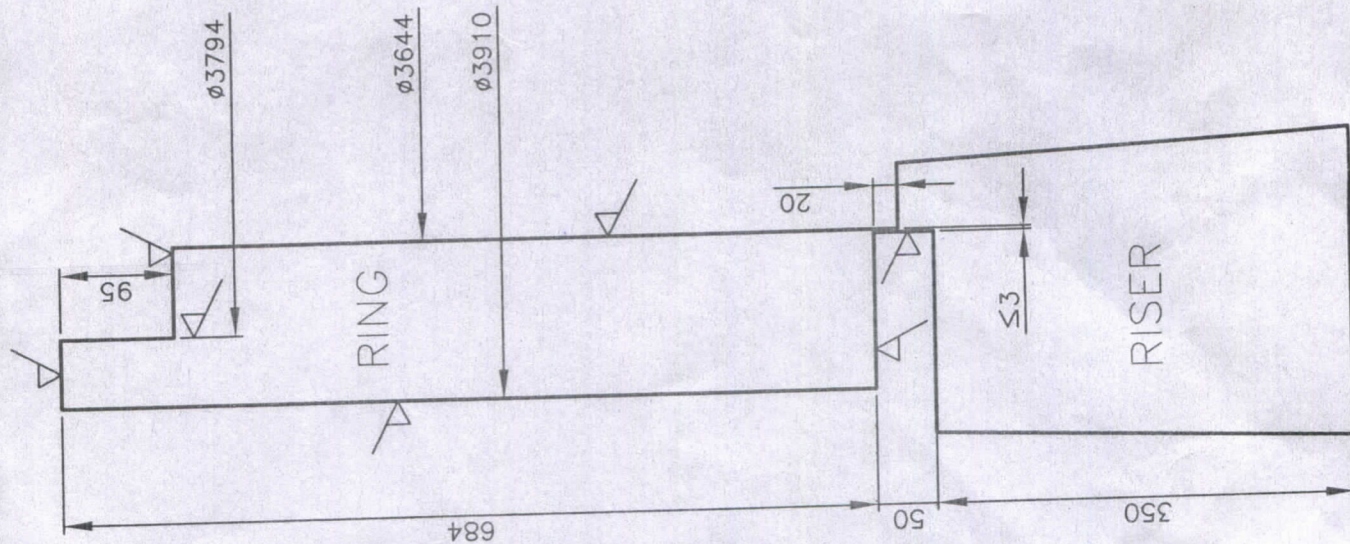
S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 4110 mm, and weight 21MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 21MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-204-07-18401/M1: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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3-204-07-18401/h1



NOTE

- 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. 3-204-07-18401 4N1/M/P AND COMPONENT DRG NO. 3-204-07-18401 REV 01.
3. ESTIMATED WEIGHT OF CASTING BEFORE MACHINING: 20380 KGS. ESTIMATED WEIGHT OF CASTING AFTER MACHINING: 15850 KGS.

CONTROLLED COPY
Foundry Technology
C.No. SF/.....
Date 28 APR 2022

	REV	DATE	ALTERED	CHECKED	DEPTT. FDY.TECH. TITLE ROUGH M/C DRG. FOR (4 IN 1) UPPER ROTATING LABYRINTH	 SCALE N.T.S. WEIGHT IN Kgs	NAME DRN 53/KALESHWARAM-L2P2/2350.3M WKG NKG CHD L AGRAWAL APPD JAN SUGHAKAR	SIGN DATE
	PROJECT AND CUSTOMER NAME KALESHWARAM-L2P2 BHUPAL BHUYER							

220/4

Item Description

Tender Enquiry No	FF/SC/22014/202200381
Item	Upper Rotating Labyrinth (4N1) Nickel= 3.5% - 4.5%
Drg No	3-204-07-18401/M1:Rev-00
Quantity	01 No
Delivery Terms	5 Weeks/Piece
befor Machingh Wt	20380 KG
After Machinigh Wt	15850 KG

Remarks:-

GRADE CONTAINS NICKEL=3.5-4.5%

RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS

MARK & MACHINE AS PER DLY DRG.

IDENTIFICATION NO. TO BE PUNCHED

SEAL TO BE RETAINED