

MACHINING OF LABYRINTH RING

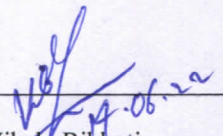
INDENT NO: 20220047

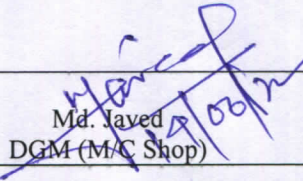
PRE QUALIFICATION REQUIREMENT

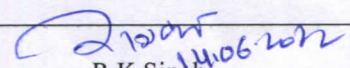
S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a Vertical Boring machine which can machine a job of dia. 4100 mm, and weight 19MT	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity $\geq$ 19.0MT	Vendor to Confirm and submit detail

TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 3-202-05-18101/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

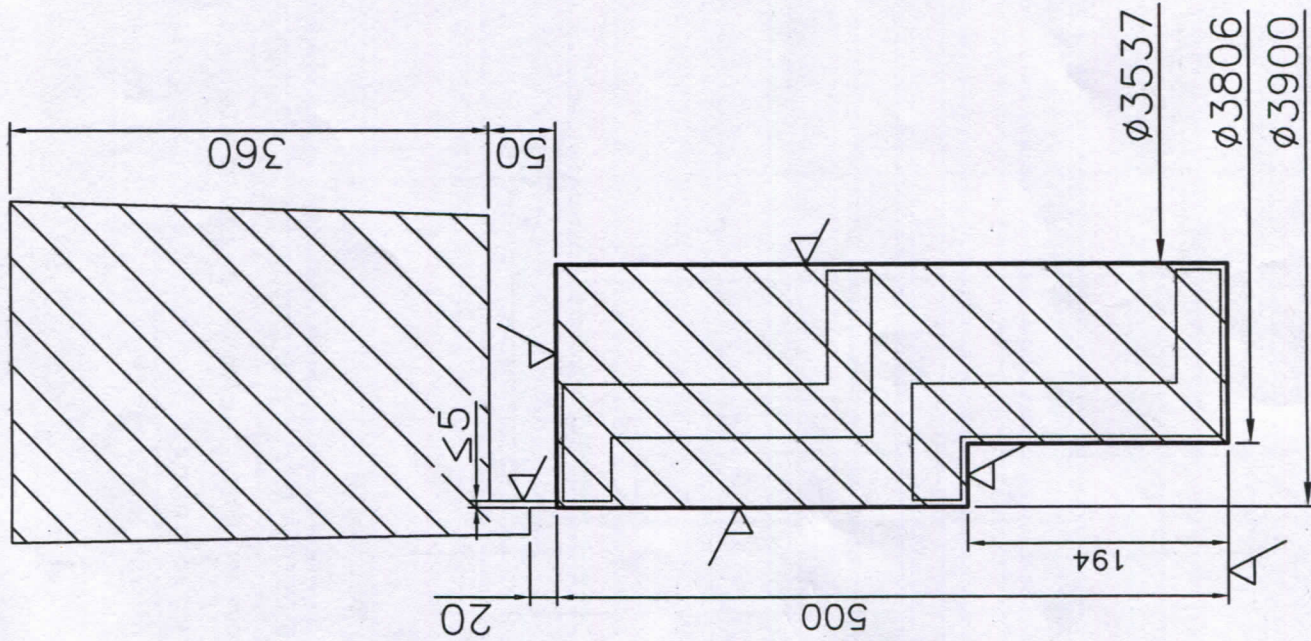

Vikalp Bibhuti
Dy. Manager (M/C Shop)


Md. Javed
DGM (M/C Shop)


R.K. Singh
AGM (M/C Shop)

FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN M.M.)

DRAWING NUMBER
3-202-05-18101/M



CONTROLLED COPY
Foundry Technology
C.No. SF/26
Date 28 MAY 2027

NOTE

1. CASTING TO BE ROUGH MACHINED ON THE 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. 3-202-05-18101 2N1/M/P AND COMPONENT DRG NO. 3-202-05-18101.
3. WEIGHT OF CASTING BEFORE MACHINING:- 18578 KGS
(INCLUDING RISER WEIGHT).
WEIGHT OF CASTING AFTER MACHINING:- 15553 KGS.

		BHARAT HEAVY ELECTRICALS. LTD.	
DEPT. FDY. TECH.		CENTRAL FOUNDRY FORGE PLANT	
REV	DATE	ALTERED	RAMASHISH
Q	28.05.22	CHECKED	LAVIN
ZONE AS PER SHOP FEEDBACK		ROUGH M/C DRAWING	
MODIFIED.		FT/M/2022:-05	
TITLE		ROUGH M/C DRAWING FOR LOWER STATIONARY LABYRINTH (2 IN 1)	
DEPT. FDY. TECH.		SCALE N.T.S.	
NAME		RANIPUR HARDWARE	
DATE		SDN	
DRN		23/PAAMURU RR LIS	
WKO		NKG	
CHD		LAGRAWAL	
APPO		R LAKRA	
DRAWING NO		TECHNOLOGY NO	
PROJECT AND CUSTOMER NAME		PALAMURU RR LIS - I	
BHEL / BHOPAL		23020	
3-202-05-18101/M		SHEET NO.-1	
NO. OFF SHEETS-1			

220/7

Item Description

Tender Enquiry No	FF/SC/22017/202200472
Item	Lower Stationary Labyrinth (2N1) Nickel= 3.5% - 4.5%
Drg No	3-202-05-18101/M: Rev-A
Quantity	03 Nos
Delivery Terms	5 Weeks/Piece
before Machining Wt	18578 KG
After Machining Wt	15553 KG

Remarks:-

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