

MACHINING OF RUNNER BLADE

Indent No: 20220152

i) PRE QUALIFICATION

S.No.	BHEL Requirement	Vendor's Confirmation
1	Vendor should have a Horizontal boring machine of Spindle Dia 125mm or more	Vendor to Confirm and submit detail
2	Vendor should have material handling capacity of 3.5MT or more	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 0-204-07-19303/M/R00	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: 2 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 Bishnoi Dy. Manager (M/C Shop)	Ma. Jayesh DGM (M/C Shop)	R.K.Singh AGM (M/C Shop)
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1. Casting to be rough machined on all surfaces thus marked ∇ to the drg. dimensions and surface finish of 6.3 microns and to the tolerance of $+2/-0$ on OD and ht, $-2/+0$ on ID unless otherwise stated.

2. This Drg. is issued for the purpose of rough machining only. for all other details please refer component Drg.

no.0-204-07-19303 Rev.- 01

3. Estimated weight of casting before machining: 3100 Kgs

4 Estimated weight of casting after machining: 2850 kgs.

5. Vertical and horizontal centrelines of the casting as marked by the foundry is to be taken as reference for setting of the blade for machining.

6. The material grade of casting is ASTM A743 CA6NM (13%Cr-4%Ni stainless steel)

 BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT RANIPUR HARDWAR															
DEPTT.				SCALE		WEIGHT IN Kgs		NAME		SIGN		DATE			
FDY.TECH.				N.T.S.											
TITLE										DRN		23/SHPK/23591M.DWG			
ROUGH M/C DRG FOR RUNNER BLADE										WKD		L AGRAMWL		Sd 15.6.20	
										CHD		R LAKRA		Sd 15.6.22	
										APPD		R LAKRA		Sd 15.6.20	
PROJECT AND CUSTOMER NAME										TECHNOLOGY NO		DRAWING NO.-		NO. OF SHEETS-1	
SHAHPURKANDI 33MW										23591		0-204-07-19303/M			
BHEL BHOPAL												SHEET NO.- 1			
REV		DATE		ALTERED											
				CHECKED											
ZONE															
4															

Item Description

Tender Enquiry No	FF/SC/22052/202201521
Item	SS RUNNER BLADE CASTING (Nickel=4%)
Drg No	0-204-07-19303/M: Rev-00
Quantity	40 No
GRADE CONTAINS NICKEL	4%
Delivery Terms	2 Weeks/Piece
befor Machingh Wt	3100 KG
After Machinigh Wt	2850 KG

Remarks:

- 1 MARK & MACHINE AS PER DLY DRG.
- 2 IDENTIFICATION NO. TO BE PUNCHED
- 3 SEAL TO BE RETAINED
- 4 GRADE CONTAINS NICKEL=4%
- 5 RATE TO BE QUOTED ON PER KG CHIP REMOVAL BASIS
- 6 ACTUAL WEIGHMENT TO BE DONE FOR BOTH OUTGOING & INCOMING JOBS