

Indent No-20220167

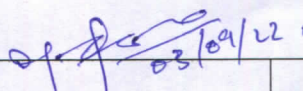
MACHINING OF GUIDE VANE**i) PRE QUALIFICATION REQUIREMENT**

S.No.	BHEL Requirements	Vendor's Confirmation
1	Vendor should have a LATHE machine having "Swing over bed (SOB)" Dia 1100mm or more and that can accommodate a job of length 2.5metres or more.	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Machining as per drawing no. 0-203-01-21203/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: 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 to submit Filled Supplier Registration Form along with Requisite Documents to SDC Cell in MM Deptt. of CFFP, BHEL, Haridwar. If already registered at CFFP or any other unit of BHEL, then Vendor code may be furnished.	Vendor to submit
9	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
10	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

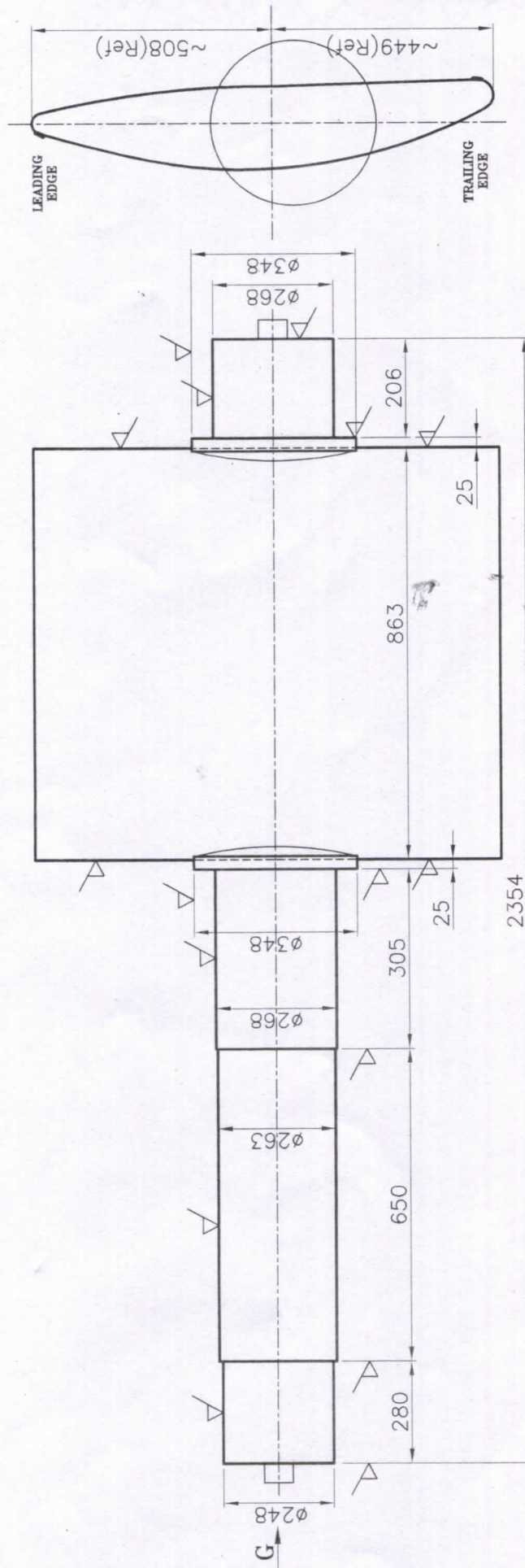

 Vikalp Bihuti
 Dy. Mgr (M/C Shop)


 Md. Asad
 Dy. Mgr (M/C Shop)


 Md. Javed
 DGM (M/C Shop)

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

W/0212-10-502-0
SHEET 1 OF 01



VIEW-G

849(Ref)

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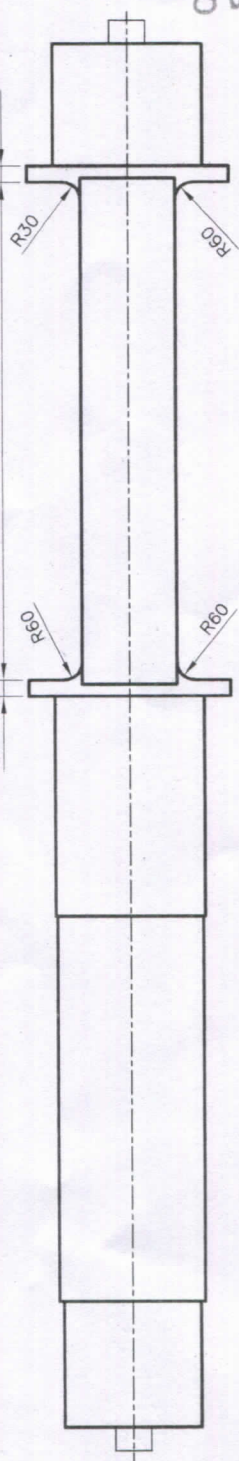
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NOTE:-

1. CASTING TO BE ROUGH MACHINED TO ALL SURFACE MARKED ∇ TO THE DRG. DIMENSIONS OF A SURFACE FINISH OF 12.5 MICRONS, WITHIN A TOLERANCE OF ON +2MM, UNLESS OTHERWISE SPECIFIED.
2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH MACHINING ONLY. FOR ALL OTHER DETAILS PLEASE REFER COMPONENT DRG. NO. 0-203-01-21203 REV 00
3. CASTING IS TO BE MACHINED BASED ON CENTER LINES PROVIDED BY MARKING GROUP AT FOUNDRY USING THE PROFILE TEMPLATE
4. WT OF CASTING BEFORE M/C: 2060 KGS
WT. OF CASTING AFTER M/C: 1750 KGS

CONTROLLED COPY
Foundry Technology
C.No. LF/84
Date: 12 SEP 2021

BHARAT HEAVY ELECTRICALS. LTD. CENTRAL FOUNDRY FORGE PLANT		RANIPUR HARDWAR		NAME		SIGN		DATE	
DEPT. FOUNDRY TECH.		SCALE N.T.S.		WEIGHT IN Kgs		DRN		23/PALAMARU/1/23618M	
TITLE		ROUGH MACHINING DRG FOR GUIDE VANE		WKO		N K GAURAV		Sd 10.5.21	
PROJECT AND CUSTOMER NAME		PALAMARU RANGAREDDY 1		CHD		L AGRAWAL		Sd 10.5.21	
TECHNOLOGY NO		23618		APPD		R LAKRA		Sd 10.5.21	
DRAWING NO.		0-203-01-21203/M		SHEET NO.-		1		NO. OF SHEETS-	
BHHEL BHOPAL									

22054

Item Description

Tender Enquiry No	FF/SC/22054/202201671
Item	Guide Vane (Nickel= 3.5-4.5 %)
Drg No	0-203-01-21203/M: Rev-A
Quantity	120 No
Delivery Terms	2 Weeks/Pc
befor Machingh Wt	2060 KG
After Machinigh Wt	1750 KG

Remarks:

MARK & MACHINE AS PER DLY DRG

IDENTIFICATION NO TO BE PUNCHED

SEAL TO BE RETAINED

GRADE CONTAINS NICKEL:3.5-4.5%(SLAB 5)

RATES TO BE QUOTED ON PER KG CHIP REMOVAL BASIS

ACTUAL WEIGHMENT TO BE DONE FOR BOTH OUTGOING &
INCOMING JOBS

PQR AS PER ANNEXURE :63541/A1