

MACHINING OF HP OUTER CASING**i) PRE QUALIFICATION**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Vendor should have a Horizontal boring machine of Spindle Dia 125 mm or more	Vendor to Confirm and submit detail
2	Vendor should have a Vertical Boring Machine that can accommodate a job of Dia 3550mm or more and Height 3800mm or more	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 60MT or more	Vendor to Confirm and submit detail
4	Only those vendors should quote who have past experience of machining of similar jobs having height greater than 2500mm and weight more than 40MT. (Both criteria may be fulfilled through one or more jobs)	Vendor to Confirm and submit detail (including copy of P.O. & Inspection/Acceptance report along with the offer)

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
1	Marking and Machining as per drawing no.: 0-105-01-19901/M1:REV-00.	Vendor to confirm
2	Vendor to arrange tools, instruments, template, jig, fixture, gauge etc. required for machining of the job	Vendor to confirm
3	Inspection of the machined job may be carried out by BHEL at vendor's works before despatch	Vendor to confirm
4	Delivery requirement: 7 weeks/pc from the date of lifting	Vendor to confirm
5	Identification details on the casting to be maintained	Vendor to confirm
6	Vendor to submit Details of the Organization, Contact details, Facilities and Similar works carried out along with the offer.	Vendor to submit
7	Vendor may plan a visit to CFFP for technical discussion.	Vendor to Note
8	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Vikalp Bibhuti
Dy. Manager (M/C Shop)

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

Md. Javed
DGM (M/C Shop)



PRODUCT NAME	1ST STAGE ROUGH M/C DRG. FOR HP OUTER CASING
PROJECT AND CUSTOMER NAME	
DATE	15094
BY	
CHECKED	
APPROVED	
REVISIONS	
NO. OF SHEETS	1

1. CASTING TO BE ROUGH MACHINED ON ALL SURFACES MARKED ∇ TO THE DRAWING DIMENSIONS TO THE SURFACE FINISH OF 6.3 MICRONS AND TO THE TOLERANCE OF $+2$ ON OD AND HT, -2 ON ID, UNLESS OTHERWISE STATED -0^{+0}

2. THIS DRG. IS ISSUED FOR THE PURPOSE OF ROUGH

REFER COMPONENT DRG. NO. 1-105-01-19901, REV.- 03

WT OF CASTING AFTER MACHINING:50000 KG
4 THIS DRAWING IS FOR 1ST STAGE ROUGH MACHINING

TO BE SENT TO STEEL FOUNDRY FOR UPGRADE/ION WORK AFTER
1ST STAGE MACHINING.

CENTRAL FOUNDRY FORGE PLANT
DARTMOUTH HARDWARE

DEPT.,			SCALE	WEIGHT IN LBS	NAME	SIGN	DATE
FDY. TECH.			N.T.S.				
TITLE					DRN	/15/15094M	

HP OUTER CASING	CHD AKC	sd	sd
	APPD AKC	sd	sd

600 MW SI	15094	0-105-01-1880/M
BHEL HEER HARDWAR	SHEET NO.- 1	NO. OF SHEETS- 1

Item Description

Tender Enquiry No	FF/SC/22063/202201631
Item	HP Outer Casing
Drg No	0-105-01-19901/M1: Rev-00
Quantity	01 No
Delivery Terms	7 Weeks/Pc
befor Machingh Wt	60000 KG
After Machinigh Wt	50000 KG

Remarks:

MARK & MACHINE AS PER DLY DRG
IDENTIFICATION NO TO BE PUNCHED
SEAL TO BE RETAINED