

**SCOPE OF WORK: RS01**

- 1 Collection of raw materials from BHEL Stores at Trichy. **Raw Material will be issued as block (with minimum 10 mm tolerance on each side) cut out from pipes.**
- 2 Machining of UT Ref Block/Calibration Blocks as per BHEL drawings. **ID/OD machining need not be done.**
- 3 Completed blocks are to be calibrated at NABL approved metrology lab as per BHEL drawings
- 4 After calibration, all machined surfaces are to be coated with suitable rust preventive as per BHEL drawing.
- 5 Offering the finished items for inspection by BHEL or BHEL authorised inspection agency
- 6 Stencilling / Hard punching of the following shall be done:
DU details, material grade, supplier code, pipe ID/OD & Thickness, Block type (Axial/Circumferential).
- 7 Handing over of finished goods to BHEL, Trichy/Logistics for RS01 with relevant IR & DC documents.
- 8.1 NOTE 1: AS – ALLOY STEEL REFERRED IS P11,P12 & P22 / F11,F12 & F22 / GR11,GR12 & GR-22, GR-91/92
- 8.2 NOTE 2: All suitable tools, gauges required for components machining & inspection shall be arranged by Vendor and measuring instruments to be used shall be calibrated from NABL accredited lab.
- 8.3 NOTE 3: Comprehensive measurement of all dimensions for each block shall be provided by the vendor from a NABL (or equivalent) certified laboratory.
- 8.4 NOTE 4: Methods such as replica, CMM measurements or suitable methods with code backup for UT calibration block measurements shall be used.

SCOPE OF WORK: RS02

- 1 Collection of raw materials from BHEL-NDTL Stores at Trichy. **Raw Material will be issued as pipes in ID / OD machined condition.**
For Drg: NDT: FB-UT-01-REV-00, 2 nos. pipes will be issued. For the remaining drawings, one pipe will be issued.
- 2 Cutting of the block to the required size from the pipe raw material issued.
- 3 Machining of UT Ref Block/Calibration Blocks as per BHEL drawings. ID/OD machining need not be done.
- 4 Completed blocks are to be calibrated at NABL approved metrology lab as per BHEL drawings. Tolerances, surface finish requirement, perpendicularity and parallelism have to be maintained as per the drawings.
- 5 Application of rust preventive oil (meeting IS 1154 or equivalent standard) immediately after completion of machining and ensure the same during delivery.
- 6 Offering the finished items for inspection by BHEL or BHEL authorised inspection agency
- 7 Stencilling / Hard punching of the following shall be done:
DU details, material grade, supplier code, pipe ID/OD & Thickness, Block type (Axial/Circumferential).
- 8 Handing over of **finished blocks and the balance raw material** to NDT Lab-Ward-16 for RS02 with relevant IR, DC and RSV documents.
- 9.1 NOTE 1: AS – ALLOY STEEL REFERRED IS P11,P12 & P22 / F11,F12 & F22 / GR11,GR12 & GR-22, GR-91/92
- 9.2 NOTE 2: All suitable tools, gauges required for components machining & inspection shall be arranged by Vendor and measuring instruments to be used shall be calibrated from NABL accredited lab.
- 9.3 NOTE 3: Comprehensive measurement of all dimensions for each block shall be provided by the vendor from a NABL (or equivalent) certified laboratory.
- 9.4 NOTE 4: Methods such as replica, CMM measurements or suitable methods with code backup for UT calibration block measurements shall be used.



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Note 1: Finished blocks shall be engraved with following details: Vendor code, PO No, DU No, Material specification (Size, Thickness and Grade), Block Type (Axial or Circumferential).

Note 2: Vendors/Suppliers raise and obtain approvals for Loading Advice Slip for material collection, Cutting Plan, Inspection Calls (Stage Call and Final call), Inspection reports, Delivery Challans and Invoices in BHEL, Trichy's B2B portal only. Suppliers are advised to get acquainted with the B2B portal & working in the portal immediately on release of POs to avoid confusions/hold up at later stage.



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