

**TELANGANA STATE POWER GENERATION CORPORATION LIMITED
(TSGENCO)**

**1x800 MW KOTHAGUDEM THERMAL POWER STATION STAGE-VII,
UNIT#12
FLUE GAS DESULPHURISATION (FGD) SYSTEM PACKAGE**


**TECHNICAL SPECIFICATION
FOR
MISCELLANEOUS PUMPS (HORIZONTAL & VERTICAL)**

Specification No. : PE-TS-439-100-N001 (REV. 00)



**BHARAT HEAVY ELECTRICALS LIMITED
POWER SECTOR
PROJECT ENGINEERING MANAGEMENT
PPEI BUILDING, SECTOR 16 A
NOIDA - 201301**

735230/2022/PS-PEM-MSE

	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001	
		SECTION:	
		SUB-SECTION:	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1	OF 1

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Notes:

1) For detailed list of documents to be submitted by bidder in their technical offer, please refer cl. no. 15.00.00 of Section-IIA.

2) For detailed list of documents to be submitted by vendor after award of contract, please refer Datasheet-C of Section-IIA.

3) In case there is conflict in different clauses of specification, most stringent clause (as decided by BHEL / end customer) shall be followed, if no specific deviation is taken by bidder and accepted by BHEL during tender stage in that regard.

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SPECIFIC TECHNICAL REQUIREMENTS

SECTION - I

SPECIFIC TECHNICAL REQUIREMENTS

- SUB-SECTION IA** - Specific Technical Requirements (Mech.)
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TITLE:


TECHNICAL SPECIFICATION
MISCELLANEOUS PUMPS

SPECIFIC TECHNICAL REQUIREMENTS

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SUB-SECTION – IA

SPECIFIC TECHNICAL REQUIREMENTS (MECHANICAL)

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1.0 SCOPE

1.1 This enquiry covers the design, manufacture, assembly, inspection and testing at manufacturer's and/or his sub-contractors works, painting, proper packing to avoid damage of items during transportation & storage at site of Miscellaneous Pumps (along with Motors & mandatory spares as applicable), transportation to site, complete with all other accessories as per the requirements specified in this specification, site services including installation checks of pump motor set & supervision of replacement of gland packing with Mechanical Seal arrangement (if applicable) at site for Miscellaneous Pumps, PG Test at site and any other services, etc. if called for in the succeeding sections of the specification for the following projects:

(1) 1X800 MW TSGENCO KOTHAGUDAM TPS STAGE –VII, PALONCHA (FGD Pkg.)

1.2 The miscellaneous pumps covered under this specification shall be grouped (Type) as under:

- i. Horizontal Pumps (Group-I)
- ii. Vertical Pumps (Group-II)

NOTE:-

1. The bidder shall include complete supplies for Pump Type as above in his scope. Part supplies offered for the Pump Type shall disqualify the bidder's offer for that Pump Type.

2. Pump details shall be as per Data Sheet-A at Section-ID.

3. If stated specifically in NIT, bidder shall include complete supplies for Project(s)/Group(s) in his scope. Part supplies offered for the Project(s)/Group(s) shall disqualify the bidder's offer for that Project(s)/Group(s).

1.3 The miscellaneous pumps and drives covered under this specification for project are as per Annexure-1 of this section. HT drives, wherever applicable and irrespective of motor ratings, shall be issued free of cost by BHEL. The details of pumps with HT drives shall be as per Annexure-2 of this section.

1.4 The Capacity, Head, Materials of construction, Mandatory spares and other particulars of these pumps, are detailed in Data Sheet-A at Section-ID of the specification.

1.5 For detailed scope of supply & services refer Standard technical Specification for Horizontal Centrifugal pumps specified under Section-II of this specification.

1.6 Electrical scope between BHEL and Vendor for Miscellaneous pumps and drives of this specification shall be as per Section-IB of this specification.
LT drives shall be energy efficient as per subsequent clauses mentioned elsewhere in the specification. **However wherever IE2 compliant motors are applicable same shall be provided with Premium Efficiency class-IE3 compliance (refer Specific Technical requirements-Electrical Section).**


1.7 **DELIVERY & DOCUMENT SUBMISSION SCHEDULE:**
Delivery & Document submission schedule of miscellaneous pumps shall be as per NIT requirement.

1.8 Evaluation and LD criterion w.r.t. Auxiliary Power is defined at clause 4.0 of Section IIA of this specification. In case bidder quotes Aux. power less than Benchmark Auxiliary Power, then quoted Aux. power shall be replaced with Benchmark Auxiliary Power for both evaluation as well as LD purposes.

2.0 Horizontal Pumps:

2.1 Additional Specific requirements for Horizontal pumps shall be as per end customer's specification attached as Annexure-3 in this section-IA.

2.2 In case, shaft sleeve is threaded a water slinger shall be provided on the Pump Shaft to avoid ingress of leaked water (if any due to failure of sealing arrangement for shaft sleeve) to Bearing.

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2.3 In case of axial split casing Multistage pumps, minimum factor of safety of '2' times shall be considered for bearing capacity selection and pump design.

2.4 Deleted

3.0 Vertical Pumps:

3.1 Additional Specific requirements for Vertical pumps shall be as per end customer's specification attached as annexure-3 in this section-IA.

3.2 All Vertical pump motors shall be designed/capable of withstanding max. run away speed during reverse flow. There are no thrust block for countering pump thrust and pump base plate shall be adequately designed to take the unbalanced forces and moments.

3.3 Following provision shall be provided by bidder to prevent damage due to reverse rotation of the pump motor assembly:

1. Non reversible ratchet mechanism
2. Necessary switch to detect reverse rotation will be provided to prevent motor switching 'ON' while rotating in reverse direction. Alarm will be provided in owners TFT based monitor.

4.0 Mechanical run test along with Performance test shall be carried out on all pumps to determine the vibration levels, noise levels etc. at Vendor works. **Vibration, Noise and Parallel operation run test without hunting and abnormal noise and with flow sharing within 10% of each other at the rated duty point shall also be conducted by vendor at site for All Pumps and as per approved PG Test Procedure, inline with CI no. 3.04 of Section-IIA of this specification.** However, test value at site shall be used for the acceptance of the equipment. Pump vendor shall bring necessary instruments for conductance of site performance test. If the site performance is found not meeting the requirements in any respect as specified, then the equipment shall be rectified or replaced by the vendor, without any commercial implication to BHEL.

5.0 Additional Dispatch Requirements:

MDCC after final inspection shall be provided to vendor subject to submission of following documents along with meeting the other requirements stated in NIT :-


5.1 List of items packed in each box with description & quantity.

5.2 Photograph of each box in open & closed condition.


5.3 Bidder to include handling instructions on Packed Box of each item & in Engineering drg/doc/O&M Manual and packing to be done in such a way to avoid damage of items in transit and long storage at site and same shall be approved during contract stage by BHEL/Customer

6.0 Drawing/Document Submission Schedule:


PACKAGE	BHEL DRG NO	DRG TITLE	Drg Sch for	Remarks
	PE-V7-439-100-N051	TDS AND PERFORMANCE CURVES- MISC. PUMPS (HORIZONTAL)	As per NIT	
	PE-V7-439-100-N052	GENERAL ARRANGEMENT AND CROSS SECTIONAL-PUMPS (HORIZONTAL)		

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MISC.PUMPS (HORIZONTAL)	PE-V7-439-100-N053	TDS AND CURVES OF MOTORS		
	PE-V7-439-100-N054	QP-MISC PUMPS (HORIZONTAL)		
	PE-V7-439-100-N055	QP- MOTORS (HORIZONTAL)		
	PE-V7-439-100-N056	MOTOR TYPE TEST DOC (if applicable) (HORIZONTAL)	As per NIT	
	PE-V7-439-100-N057	O& M MANUAL -HORZ. PUMPS	As per NIT	
	PE-V7-439-100-N058	PG TEST PROCEDURE -HOR. PUMPS (If Applicable)	R-0 within 20 days of Cat-I approval on all Pump & Motor documents (TDS, GA drg & QPs).	
PACKAGE	BHEL DRG NO	DRG TITLE	Drg Sch for	Remarks
MISC.PUMPS (VERTICAL)	PE-V6-439-100-N051	TDS AND PERFORMACE CURVES- MISC. PUMPS (VERTICAL)	As per NIT	
	PE-V6-439-100-N052	GENERAL ARRANGEMENT AND CROSS SECTIONAL-PUMPS (VERTICAL)		
	PE-V6-439-100-N053	TDS AND CURVES OF MOTORS		
	PE-V6-439-100-N054	QP-MISC PUMPS (VERTICAL)		
	PE-V6-439-100-N055	QP- MOTORS (VERTICAL)		
	PE-V6-439-100-N056	MOTOR TYPE TEST DOC (if applicable) (VERTICAL)	As per NIT	
	PE-V6-439-100-N057	O& M MANUAL -VERT. PUMPS	As per NIT	
	PE-V6-439-100-N058	PG TEST PROCEDURE -VERT. PUMPS (If Applicable)	R-0 within 20 days of Cat-I approval on all Pump & Motor documents (TDS, GA drg & QPs).	

Note: Drawings submitted shall be complete in all respects with revised drawing submitted incorporating all comments. Any incomplete drawing submitted shall be treated as non-submission with delays to bidder's account. For any clarification / discussion required to complete the drawings, the bidder shall himself depute his personnel to BHEL for across the table discussions/ finalizations / submissions of drawings

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<p>7.0 Following to be complied by the bidder:</p> <p>a. Supplier to submit detailed 'Bill of Material' (BoM) at the time of drawing/document submission after placement of PO. Each item of the BoM to be uniquely identified with item code no. or item serial no.</p> <p>b. Supplier to ensure that all items which will find separate mention in the packing list are covered in this detailed BoM.</p> <p>c. Supplier to give following undertaking in the BoM"</p> <p>"The BoM provided herewith completes the scope (in content and intent) of material supply under PO no.-----, dated -----.</p> <p>Any additional material which may become necessary for the intended application of the supplied items(s)/package will be supplied free of cost in most reasonable time."</p>				

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Annexure-1

List of Miscellaneous Pumps and drives for :

1X800 MW TSGENCO KOTHAGUDAM TPS STAGE –VII, PALONCHA (FGD Pkg.)

Sl. No.	Pump Description	Total Qty.	Type of Pumps
A.	Horizontal Pumps		
1	FGD ECW (DMCW) PUMPS	2 nos.	Horizontal
2	FGD ACW PUMPS	2 nos.	Horizontal
B.	Vertical Pumps		
1	FGD MAKE-UP WATER PUMPS	2 nos.	Vertical

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<p style="text-align: right;">Annexure-2</p> <p>Following HT drives for 1X800 MW TSGENCO KOTHAGUDAM TPS STAGE –VII, PALONCHA (FGD Pkg.), irrespective of Motor ratings shall be issue free, by BHEL:</p> <p>NIL</p>				

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- d) Adequate provision shall be made in each of the pump sumps so as to facilitate insertion of isolation gates as and when required. Gates shall be fabricated of mild steel, shall be of watertight type and shall preferably be of identical size/dimensions to facilitate interchangeability. Sump gates shall generally be accessible by the pump house overhead crane.
- e) The respective pump house shall also accommodate the following equipment/facilities, as applicable.
 - i. All auxiliary equipment related to pump sets such as discharge piping complete with valves and specialties, electric motor drives etc.
 - ii. Ventilation system for the entire pump house.
 - iii. Separate bays for unloading and maintenance.
 - iv. All necessary electrical equipment and accessories as required for this system.
 - v. Overhead Crane complete with all accessories, as specified in Volume-III F, Section-II of this specification.
 - vi. Sump pumps, as specified in Volume-III F, Section-I of this specification.
 - vii. Fixed Screens and accessories located suitably.
 - viii. Necessary toilets and operator's cabins with drinking water facility.
- f) Other general layout criteria as specified in Volume IIA of this specification shall also be adhered to while designing the pump house.

5.14.00 All Horizontal and Vertical Pumps of Plant Water System shall have 10% margin on capacity and 20% margin on Total Dynamic Head.

6.00.00 **DESIGN AND CONSTRUCTION**

ANNEXURE-3

6.01.00 **Horizontal Pumps**

6.01.01 **Pump Casing**

Pump casing shall be provided with adequate number of vents and priming connections with valves unless the pump is made self-venting and priming. Casing drain, as required, shall be provided complete with drain valves.

Pump design must ensure that the nozzles are capable of withstanding external reactions not less than those specified in API-610.

In cases where an expansion joint is located at pump discharge, the pump assembly will be subjected to an additional thrust which will be transmitted to

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- the foundation. This additional thrust shall be taken into consideration during pump design.
- 6.01.02 Impeller
- The rotor assembly shall be dynamically balanced and designed with critical speed substantially above the operating speed.
- 6.01.03 Wearing Rings
- Replaceable type wearing rings shall be furnished to prevent damage to impeller and casing.
- 6.01.04 Shaft
- Shaft size shall be selected considering that the critical speed shall be away from the operating speed as recommended in applicable Code/Standard. The critical speed shall also be at least 10% away from runaway speed.
- 6.01.05 Shaft Sleeves
- Renewable type fine finished shaft sleeves shall be provided at the stuffing boxes/mechanical seals. Length of the shaft sleeves must extend beyond the other faces of gland packing or seal end plate so as to distinguish between the leakage past shaft and shaft sleeve and that past the seals/glands.
- Shaft sleeves shall be properly fastened to the shaft to prevent any leakage or loosening. Shaft and shaft sleeve assembly should ensure concentric rotation.
- 6.01.06 Bearings
- Bearings shall be easily accessible without disturbing the pump assembly. A drain plug shall be provided at the bottom of each bearing housing.
- Heavy duty sleeve/ball/roller type bearings shall be provided to take care of the radial loads.
- In case of sleeve type radial bearings, axial thrust shall be absorbed in suitable hydraulic devices and/or thrust bearings.
- Bearings and hydraulic devices (if provided for balancing axial thrust) shall be of adequate design for taking the entire pump load arising from all probable conditions of continuous operation. Life of the bearings shall be guided by the design standard of the pump. Thrust bearing shall be capable of running continuously at maximum load.
- 6.01.07 The bearings shall be oil/grease lubricated. Suitable lubricating arrangement for the bearings shall be furnished with the pump complete with all accessories like pump, filters, pipings, fittings, valves, interlocking and supervising instruments etc. as necessary. The design shall be such that the bearing lubricant does not contaminate the liquid being pumped.

6.01.08 Stuffing Boxes

Stuffing box design shall permit replacement of packing without removing any part other than the gland.

Stuffing boxes shall be sealed/cooled by the fluid being pumped. All necessary pumps, piping, fittings, valves, instruments etc. as required for safe and trouble-free operation of the pumps shall be included in the scope of supply.

6.01.09 Mechanical Seals

Mechanical seals shall be provided if specified in the Annexure attached with this section. The pump supplier shall co-ordinate with the seal maker in establishing the circulation rate for maintaining a stable film at the seal face in the chamber. The seal piping system shall form an integral part of the pump assembly.

For the seals under vacuum service, the seal design must ensure sealing against atmospheric pressure, even when the pumps are not operating.

6.01.10 Drive Unit

The pumps shall be driven by electric motor directly coupled. A heavy duty flexible coupling along with coupling guard shall be provided between the pump and drive unit. For details regarding specification of drive unit Volume-V of this specification will be referred.

Unless otherwise specified drive unit power rating shall be the maximum of the following requirements.

- a) 15% (for LT motor) or 10% (for HT motor) margin over the pump shaft input power at the rated duty point.
- b) 5% margin over the maximum pump shaft input power required within the "Range of Operation".
- c) Pump shaft input power required considering the overloading of the pump assuming single pump operation in the event of tripping of one or more of the pumps operating in parallel.

6.02.00 **Vertical Pumps**

Pumps shall be of vertical shaft, complete with bowl, column pipe, discharge head and base plate with all accessories, as applicable. General design and constructional features of the pumps shall be as follows:

6.02.01 Bowl Assembly

This will be either a single or multi-stage centrifugal, mixed flow or axial flow type with discharge co-axial with shaft. Type of impeller shall be chosen on the basis of the pump specific speed and the characteristics of the handling fluid.

Pump(s) shall have provision for adjustment of impellers in vertical direction

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from an accessible location, preferably at the housing (where separate thrust bearing for the pump is provided). The adjustment mechanism must take into consideration the extension of the line shaft due to hydraulic down thrust, weight of the shaft and impeller.

6.02.02 Discharge Head

Pump(s) shall be either above floor or below floor discharge type, as specified in the annexure, attached to this section.

In case, expansion joint is to be used at the pump discharge, pump base plate shall either be adequately designed to take the unbalanced forces and moments from the use of such expansion joint or a separate thrust block at the pump discharge head shall be provided to transmit these forces to the external supporting structure. Calculation of thrust load shall be done considering the highest pressure seen by the pump and internal diameter of the arch of the expansion bellow.

6.02.03 Column pipe

Column pipe shall be flanged and of bolted connection. Column pipes shall be designed for full internal vacuum.

In case the annexure ask for the pump with below floor discharge, and the water level is at or above the discharge valve level, the column pipe piece located at the intermediate floor level shall be provided with suitable floor sealing device.

In case of multi-piece column pipe and shaft assembly, the design shall permit raising/lowering of the pump assembly piece by piece without any difficulty. Any fixtures, clamps, etc. necessary for such purpose shall be supplied by the Contractor under this section. The Contractor shall also submit a write-up describing clearly the procedure of handling the pump.

6.02.04 Impeller shaft, line shaft and head shaft

Shaft size shall be selected on the basis of maximum torque to be applied on the pump shaft.

Critical speed of the shaft shall be sufficiently away from the pump operating speed and in no case shall lie between 90% and 110% of the rated speed.

Impeller shaft shall be guided by bearings provided in each bowl or above and below the impeller shaft assembly. The butting faces of the shaft shall be machined square to the assembly and the shaft shall be chamfered at the edges.

Line shaft may be of single or multiple pieces as required. In case of multiple pieces, line shaft shall be coupled as per the standard practice of the manufacturer.

For screwed coupling, screw directions shall permit tightening of the joint during pump operation.

Replaceable shaft sleeves shall be furnished at applicable locations, particularly under stuffing box and at other locations, as considered necessary.

6.02.05 Shaft enclosing tube

Shaft enclosing tube shall be required, unless self lubricated (and cooled) type of shaft bearings are asked for. Length of the shaft enclosing tube shall be in conformity with the shaft piece lengths.

6.02.06 Seal rings

Replaceable seal/wear rings both on impeller and on casing shall be provided in case it is asked for in the annexure.

6.02.07 Bearings

a) Shaft bearings

Adequate number of properly designed bearings shall be provided for smooth and trouble-free operation of the pump. Number of bearings shall consider the number of shaft pieces used and the critical speed of the shaft. Bearings shall be either lubricated by external clear water/oil/grease or self lubricated as specified in the Annexure.

In case of external water/oil lubrication, complete lubrication arrangement shall be furnished with the pump. If the annexure calls for pre-lubrication of the shaft bearings, pre-lubrication tank and other accessories shall be within the scope of supply of the Bidder/ Contractor.

b) Thrust Bearing

Thrust bearing of adequate size and capacity shall be provided to take the vertical thrust of the impeller arising out of the pump operation and dead weight of the rotating components. Life of the thrust bearing shall be guided by the design standard of the pump. Thrust bearing shall be capable of running continuously at maximum load.

Thrust bearings shall be either grease or oil lubricated. Lubrication arrangement shall be such that the lubricant does not contaminate the handling fluid. The arrangement shall also be adequate to protect the bearing, while the pump coast down to stop in case of power failure of the station. Pre-lubrication of the thrust bearing, if recommended by the pump manufacturer, shall be taken care of in designing the lubrication system.

Cooling of the thrust bearing if necessary, shall be done by the handling fluid/external water, depending on the fluid handled.

Location of the thrust bearing may be at the pump body or at the driver, or at both depending on the requirement of annexure or as per

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the recommendation of the pump manufacturer (and approved by Purchaser).

6.02.08 Reverse Rotation

Following provision shall be provided to prevent damage due to reverse rotation of the pump motor assembly:

1. Non reversible ratchet mechanism
2. Necessary switch to detect reverse rotation will be provided to prevent motor switching 'ON' while rotating in reverse direction. Alarm will be provided in owners TFT based monitor.

6.02.09 Drive Unit

- a) The pump will be driven by electric motor.

A heavy duty coupling shall be provided between the drive unit and the driven equipment (except for belt drive).

- b) Unless otherwise specified in annexure, drive element power rating shall be the maximum of the following requirements.
- i. 15% (for LT motor) or 10% (for HT motor) margin over the pump shaft input power at the rated working condition.
 - ii. 5% margin over the maximum pump shaft input power required within its operating range including the shut off point.
 - iii. Pump shaft input power required considering overloading of the pump assuming single pump operation in the event of tripping of the other pump(s) operating in parallel.
- c) The drive equipment shall preferably be air cooled. In case the pumping fluid is water, free of abrasive and corrosive matter, the same can be used for cooling purpose. The arrangement shall be within the scope of the equipment supplier.

~~6.03.00 For design and construction of piping, Section IV and Section V of Volume IIIE shall be referred to.~~

~~6.04.00 For design and construction of tanks, Section IV of Volume IIIE of this volume shall be referred to.~~

~~6.05.00 For design and construction of reservoirs, Volume VII shall be referred to.~~

7.00.00 **CONTROL & INSTRUMENTATION**

Complete instrumentation and control system including all accessories shall be provided for safe, reliable and trouble-free operation of the plant. For details Bidder shall refer to volume VI, Specification for Controls & Instrumentation.

8.00.00 **INSPECTION AND TESTING**

8.01.00 The Contractor shall carry out the following specific tests and inspections to ensure that the equipment furnished shall conform to the requirements of this section and in accordance with relevant codes and standards. Test certificates for all tests shall be submitted to the Owner for approval.

8.02.00 **Horizontal Pumps**

8.02.01 Material Identification and Testing

- i) All materials used for pump construction shall be of tested quality. Material shall be tested as per the relevant standards. Components on which material test has been done shall be stamped for identification.
- ii) Tests for each pump included under this section shall also include but shall not be limited to the following:
 - The entire surface of the impeller castings shall be subjected to Dye Penetration Test as per ASTM Specification no.: E165-65.
 - Shaft shall be subjected to Dye Penetration and Ultrasonic Tests.
 - Wearing rings shall be subjected to Dye Penetration Test.
 - Verification of material, witnessing of pouring, casting and inspection of finalised fabricated/cast castings.
 - Inspection of finished castings for impeller and verification of materials.
 - Inspection of pump shaft and verification of material.
 - Witnessing of NDT/review of NDT reports.
 - Static balancing test for impeller and dynamic balancing of complete rotating parts as per ISO- 1940.
 - Complete inspection of assembled pump

8.02.02 Hydrostatic Testing

The pump casing and all other applicable pressure parts shall be hydrostatically tested at 150% of the pump shut-off pressure. Pressure shall be maintained for a period of not less than one (1) hour. While arriving at the

above values maximum suction pressure shall be taken into account.

8.02.03 Dynamic Balancing

All rotating components shall be statically and dynamically balanced. Dynamic balancing tests shall be carried out at a speed not less than the rated rpm of the pump. Test procedure and acceptance limits shall be guided by the relevant testing codes and standards.

8.02.04 Performance Test at Shop

- i) Each pump shall have to be tested to determine the performance curves of the pumps. These tests are to be conducted in presence of Purchaser's representative as per the requirements of the Standards of Hydraulic Institute of USA (ASME-Power Test Code PTC 8.2/BS EN ISO 9906) or any other equivalent standard but the tolerances on head, discharge and power shall be as specified in HIS, USA. Prior to performance test, the pump supplier shall furnish the procedures and methods of testing to the Purchaser for approval.
- ii) Performance tests are to be conducted to cover the entire range of operation of the pumps. These shall be carried out to span 130% of rated capacity upto pump shut-off condition. A minimum of five combinations of head and capacity are to be achieved during testing to establish the performance curves, including the design capacity point, shut-off point and the two extremities of the range of operation as specified in the annexure. After completion of performance test, all pumps shall be stripped down for inspection of internals.
- iii) Tests shall be conducted at the rated rpm.

Mechanical run test shall be carried out on all pumps to determine the vibration levels, noise levels etc. This test shall be conducted at site also. However, test value at site shall be used for the acceptance of the equipment.

8.03.00 **Vertical Pumps**

8.03.01 Material Identification and Testing

- i) Material identification and testing shall include, but shall not be limited to the following components :
 - Bowls and suction bells.
 - Impeller and wearing rings.
 - Shafts and shaft sleeves.
 - Couplings.
 - Bearings.
 - Column pipes.

- Discharge heads.
- Bowl Assembly.
- Any other components in the pump assembly.

ii) Tests shall also include but shall not be limited to the following:

- The entire surface of the impeller castings shall be subjected to Dye Penetration Test as per ASTM-E-165.
- Shaft shall be subject to Dye penetration and Ultrasonic test.
- Wearing rings shall be subjected to Dye Penetration Test.
- Witnessing of NDT/review of NDT reports.
- Static balancing test for impeller and dynamic balancing of complete rotating parts as per ISO-1940.
- Complete inspection of assembled pump.

8.03.02 Dynamic Balancing

Rotating components of the pump shall be statically and dynamically balanced. Dynamic balancing tests shall be carried out for the impeller at a speed not less than the rated rpm of the pump. Test procedure and acceptance limits shall be guided by the relevant testing codes and standards.

8.03.03 Hydrostatic Testing

Hydrostatic test shall be done for the following components (as minimum) at 150% of shut-off pressure. Pressure shall be maintained for a period of not less than one (1) hour. While arriving at the above values, maximum suction pressure shall be taken into account.

- Bowls/Suction bells.
- Column pipe.
- Discharge head.
- Any other applicable pressure parts.

8.03.04 Performance Test at Shop

- i) Each pump shall have to be tested to determine its performance curves. These tests are to be conducted in presence of Purchaser's representative as per the requirements of the Standards of Hydraulic Institute of USA (ASME-Power Test Code PTC 8.2/BS-599) or any other equivalent standard but the tolerances on head, discharge and power shall be as specified in HIS, USA.

- ii) Performance tests are to be conducted to cover the entire range of operation of the pumps. These shall be carried out to span 130% of rated capacity upto pump shut-off condition. A minimum of five (5) combinations of head and capacity are to be achieved during testing to establish the performance curves, including the design capacity point, shut-off point and the two extremities of the range of operation specified. After completion of performance test, all pumps shall be stripped down for inspection of internals.
- iii) Tests shall be conducted at the rated rpm.
- iv) The Bidder shall submit in his proposal the facilities available at his works to conduct performance testing.
- v) Mechanical run test shall be carried out on all pumps to determine the vibration levels, noise levels etc. This test shall be conducted at site also. However, test value at site shall be used for the acceptance of the equipment.
- vi) Reports and test certificates of above tests shall be submitted to the Purchaser for approval.

9.00.00 **DRAWINGS, DATA, CURVES AND INFORMATION**

The Bidder shall submit the following along with his formal proposal besides the different information plate required as indicated elsewhere in this specification

- ~~9.01.00 Piping and instrumentation diagram of Plant water system.~~
- ~~9.02.00 General arrangement drawing of Jackwell pump house, raw water transfer pump house, clarified water pump house.~~
- ~~9.03.00 General arrangement of clarified water reservoir.~~
- ~~9.04.00 General Arrangement drawing of service water, potable water tank, DM water storage tank and condensate storage tank.~~

9.05.00 **Horizontal Pumps**

9.05.01 Drawings

- a) General arrangement and outline drawings showing the principal dimensions, weight and location of the suction and discharge connections of the pumps offered. Details of lubrication and sealing arrangement shall also be included.
- b) Typical cross-section drawing showing various components of the pumps offered, materials of construction etc.

9.05.02 Data and Curves

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- a) Determination of pump total dynamic head at rated capacity as per guidelines specified in Section-I of this Volume. Detailed calculations for computing static head and frictional losses shall be furnished by the Bidder.
- b) Anticipated performance curves showing the following characteristics:
 - i. Capacity vs. head
 - ii. Capacity vs. power
 - iii. Capacity vs. efficiency
 - iv. System resistance curves
- c) Speed vs. torque curve of the pump corresponding to recommended mode of pump starting superimposed on speed vs. torque curves of the drive unit corresponding to 80%, 90%, 100% of the rated voltage (applicable only in the cases of pumps with drive motor power rating of 100 KW and above).
- d) Completely filled-in Technical Proposal Particulars enclosed under Volume-IX of this specification.
- e) Details of manufacturing and testing facilities in pump manufacturer's works and illustrative literature regarding the pumps offered.

9.06.00 Vertical Pumps

9.06.01 Drawings/Data

- a) Determination of respective pump total dynamic head and capacity as per guidelines of this specification. Detailed calculations for obtaining static head and frictional losses shall be submitted by the Bidder.
- b) Outline drawings of the pump showing the various dimensions, suction and discharge locations.
- c) Typical cross sectional drawing of the pump to be supplied, showing various components, bearings, seal rings etc. and materials of construction for all items.
- d) Lubrication arrangement drawings for external lubrication.

9.06.02 Anticipated performance curves and test curves for:

- a) Capacity Vs Head.
- b) Capacity Vs. Power & Capacity Vs. Efficiency.
- c) System resistance curves.
- d) Speed Vs. torque requirement of the pump (for pump sets with drive motor rating of 100 KW or more) together the drive motor speed-torque characteristic.

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- 9.07.00 Completely filled up schedules enclosed under Volume-IX of this specification.
- 9.08.00 Descriptive and illustrative literature regarding the pumps offered.
- 9.09.00 A comprehensive write-up or brochure regarding the details of manufacturing and testing facilities in the shop of the manufacturer.
- 9.10.00 A write-up describing clearly the procedure for installing the pump with its column pipe - piece by piece and also for overhauling the pump in a like manner. A diagram showing the required pump house crane hook lift above the pump operating floor has also to be furnished.
- 9.11.00 The successful Bidder shall furnish the following drawings/data/ manuals for Purchaser/Engineer's approval after award of the contract.
- 9.11.01 Final versions of all the drawings, documents as specified in the clauses above.
- 9.11.02 Principal dimensions of the pump sump indicating clearance dimensions for the suction bell from back wall and side walls, minimum submergence required for the pump etc.
- 9.11.03 Pump foundation details along with all design loads with static and dynamic loads, direction and points of application.
- 9.11.04 Pump and drive sealing, bearing lubrication and cooling arrangement drawing.
- 9.11.05 Drive data.
- 9.11.06 Test reports, test certificates, performance curves and other particulars.
- 9.11.07 Instruction Manuals.
- 9.11.08 Any other applicable drawings and documents as specified in Volume-IIA of this specification.

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- 4.03.01 Specification for application of paints for external surfaces protection of vessels / tanks / equipment / piping / fittings / valves etc. to be installed indoor shall be as follows :
- Surface preparation shall be done either manually or by any other approved method.
 - Primer Coat shall consist of one coat (minimum DFT of 50 microns) of chlorinated rubber based zinc phosphate.
 - Intermediate Coat (or Under Coat) shall consist of one coat (minimum DFT of 50 microns) of chlorinated rubber based paint pigmented with Titanium Dioxide.
 - Top Coat shall consist of one coat (minimum DFT of 50 microns) of chlorinated rubber paint of approved shade and colour with glossy finish.
 - Total DFT of paint system shall not be less than 150 microns.
- 4.03.02 Specification for application of paints for external surfaces protection of vessels / tanks / equipment / piping / fittings / valves etc to be installed **outdoor** shall be as follows :
- Surface preparation shall be done by means of sand blasting, which shall conform to Sa 2-1/2 Swiss Standard.
 - Primer Coat shall consist of one coat (minimum DFT of 100 microns) of epoxy resin based zinc phosphate primer.
 - Intermediate Coat (or Under Coat) shall consist of one coat (minimum DFT of 100 microns) epoxy resin based paint pigmented with Titanium Dioxide.
 - Top Coat shall consist of one coat (minimum DFT of 75 microns) of epoxy paint of approved shade and colour with glossy finish. Additional one coat (minimum DFT of 25 microns) of Finish Coat of polyurethane shall be provided.
 - Total DFT of paint system shall not be less than 300 microns.
- 4.03.03 Specification for application of paints for external surfaces protection of steel pipes and fittings which are **buried underground / laid inside a huge pipe & or submerged Under Water and laid under Pipe Trenches** (in road/rail/pipe or trench crossings) shall be as follows :

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	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001	
		SECTION: I	
		SUB-SECTION: IB	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1	OF 1

SPECIFIC TECHNICAL REQUIREMENTS
SUB-SECTION – IB
SPECIFIC TECHNICAL REQUIREMENTS (ELECTRICAL)

	ELECTRICAL EQUIPMENT SPECIFICATION FOR MISCELLANEOUS PUMPS KOTHAGUDEM FGD	SPECIFICATION NO. VOLUME NO.: SECTION: I, Sub-section-IB REV NO.: 00 DATE: 23.02.22 SHEET : 1 OF 1
-----------------------------------------------------------------------------------	----------------------------------------------------------------------------------------------	------------------------------------------------------------------------------------------------------------------------------

SPECIFIC TECHNICAL REQUIREMENTS: ELECTRICAL

1.0 EQUIPMENT & SERVICES TO BE PROVIDED BY BIDDER/ PURCHASER

- a) Services and equipment as per “Electrical Scope between BHEL and Vendor”.
- b) Any item/work either supply of equipment or erection material which have not been specifically mentioned but are necessary to complete the work for trouble free and efficient operation of the plant shall be deemed to be included within the scope of this specification. The same shall be provided by the bidder without any extra charge.
- c) Supply of mandatory spares as specified in the specifications of mechanical equipments.
- d) Electrical load requirement for **MISC PUMPS**.
- e) All equipment shall be suitable for the power supply fault levels and other climatic conditions mentioned in the enclosed project information.
- f) Bidder to furnish list of makes for each equipment at contract stage, which shall be subject to customer/BHEL approval without any commercial and delivery implications to BHEL.
- g) Various drawings, data sheets as per required format, Quality plans, calculations, test reports, test certificates, operation and maintenance manuals etc shall be furnished as specified at contract stage. All documents shall be subject to customer/BHEL approval without any commercial implication to BHEL.
- h) Motor shall meet minimum requirement of motor specification.
- i) Vendor to clearly indicate equipment locations and local routing lengths in their cable listing furnished to BHEL.
- j) Cable BOQ worked out based on routing of cable listing provided by the vendor for “both end equipment in vendor’s scope” shall be binding to the vendor with +10 % margin to take care of slight variation in routing length & wastages.

2.0 EQUIPMENT & SERVICES TO BE PROVIDED BY PURCHASER FOR ELECTRICAL & TERMINAL POINTS:

Refer “Electrical Scope between BHEL and Vendor”.

3.0 DOCUMENTS TO BE SUBMITTED ALONG WITH BID

- 3.1 The electrical specification without any deviation from the technical/ quality assurance requirements stipulated shall be deemed to be complied by the bidder in case bidder furnishes the overall compliance of package technical specification in the form of compliance certificate/ No deviation certificate.
- 3.2 No technical submittal such as copies of data sheets, drawings, write-up, quality plans, type test certificates, technical literature, etc, is required during tender stage. Any such submission even if made, shall not be considered as part of offer.

4.0 LIST OF ENCLOSURES

- 4.1 Electrical Scope Between BHEL & Vendor.
- 4.2 Electrical Load Data Format.
- 4.3 Technical Specification for A.C. & D.C. Motors.
- 4.4 Data Sheet- C
- 4.5 General Technical Requirements for LV Motors
- 4.6 Standard Quality Plan.
- 4.7 Motor Sub Vendor List

STANDARD ELECTRICAL SCOPE BETWEEN BHEL AND VENDOR

PACKAGE: MISCELLANEOUS PUMP

PROJECT: KOTHAGUDEM FGD

<u>S.NO</u>	<u>DETAILS</u>	<u>SCOPE SUPPLY</u>	<u>SCOPE E&C</u>	<u>REMARKS</u>
1.	415 V MCC	BHEL	BHEL	415 V AC (3 PHASE 4 WIRE) supply shall be provided by BHEL based on load data provided by vendor at contract stage for all equipment supplied by vendor as part of contract. Any other voltage level (AC/DC) required will be derived by the vendor.
2.	Local Push Button Station (for motors)	BHEL	BHEL	Located near the motors.
3.	Power cables, control cables and screened control cables	BHEL	BHEL	Incoming cable from BHEL supplied MCC will be informed by BHEL. Screened control cable between DCS & field equipment will also be informed by BHEL. Vendor shall provide lugs & glands accordingly.
4.	Cable trays, accessories & cable trays supporting system	BHEL	BHEL	
5.	Cable glands and lugs for equipments supplied by Vendor	Vendor	BHEL	1. Double compression Ni-Cr plated brass cable glands 2. Solder less crimping type heavy duty tinned copper lugs for power and control cables.
6.	Conduit and conduit accessories for cabling between equipments supplied by vendor	BHEL	BHEL	
7.	Equipment grounding & lightning protection	BHEL	BHEL	
8.	Below grade grounding	BHEL	BHEL	
9.	LT Motors with base plate and foundation hardware	Vendor	BHEL	Makes shall be subject to BHEL approval at contract stage.
10.	Mandatory spares	Vendor	-	Vendor to quote as per specification.
11.	Recommended O & M spares	Vendor	-	As per specification
12.	Any other equipment/material/service required for completeness of system but not specified above (to ensure trouble free and efficient operation of the system).	Vendor	BHEL	
13.	Electrical equipment GA drawing	Vendor	-	For necessary interface review.

NOTES:

1. Make of all electrical equipments/items supplied shall be reputed make & shall be subject to approval of BHEL after award of contract.
2. All QPs shall be subject to approval of BHEL after award of contract without any commercial implication.

VOLUME: V-A

SECTION-II

**TECHNICAL SPECIFICATION
FOR
A.C. & D.C. MOTORS**

- 1.00.00 **SCOPE**
- 1.01.00 This section covers the general requirements of the drive motors for power station auxiliary equipment.
- 1.02.00 Motors shall be furnished in accordance with both this general specification and the accompanying driven equipment specification.
- 1.03.00 In case of any discrepancy, the driven equipment specification shall govern.
- 2.00.00 **CODES & STANDARDS**
- 2.01.00 All motors shall conform to the latest applicable IS, IEC and CBIP Standards/ Publications except when otherwise stated herein or in the driven equipment specification.
- 2.02.00 Major standards, which shall be followed, are listed below other applicable Indian Standards for any component part even if not covered in the listed standards shall also be followed:
- i) IS-325
 - ii) IS-12615
 - iii) IEC-60034
- 3.00.00 **SERVICE CONDITIONS**
- 3.01.00 The motors will be installed in hot, humid and tropical atmosphere highly polluted at places with coal dust and/or fly ash.
- 3.02.00 Unless otherwise noted, electrical equipment/system design shall be based on the service conditions and auxiliary power supply given in the annexure to this specification.
- 3.03.00 For motor installed outdoor and exposed to direct sunrays, the effect of solar heat shall be considered in the determination of the design ambient temperature.
- 4.00.00 **TYPE AND RATING**
- 4.01.00 **A.C. Motors**
- 4.01.01 Motors shall be general purpose, constant speed, squirrel cage, three/single phase, induction type.

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- 4.01.02 All motors shall be rated for continuous duty. They shall also be suitable for long period of inactivity.
- 4.01.03 LT motor & HT motor name-plate rating at 50°C shall have at least 15% margin and 10% margin respectively over the input power requirement of the driven equipment at rated duty point unless stated otherwise in driven equipment specification.
- 4.01.04 The motor characteristics shall match the requirements of the driven equipment so that adequate starting, accelerating, pull up, break down and full load torques are available for the intended service.
- 4.01.05 Motors efficiency class shall be IE3 as per latest version of IEC-60034.
- 4.02.00 **D.C. Motors**
- 4.02.01 D.C. motor provided for emergency service shall be shunt/compound wound type.
- 4.02.02 Motor shall be sized for operation with fixed resistance starter for maximum reliability.
- Starter panel complete with all accessories shall be included in the scope of supply.
- 5.00.00 **PERFORMANCE**
- 5.01.00 **Running Requirements**
- 5.01.01 Motor shall run continuously at rated output over the entire range of voltage and frequency variations as given in the annexure.
- 5.01.02 The motor shall be capable of operating satisfactorily at full load for 5 minutes without injurious heating with 75% rated voltage at motor terminals.
- 5.01.03 The motor shall be designed to withstand momentary overload of 60% of full load torque for 15 second without any damage.
- 5.02.00 **Starting Requirements**
- Motor shall be designed for direct online starting at full voltage. Breakaway starting current as percentage of full load current for various motor rating shall not exceed the given below-
- | | | |
|---------------------|---|---------------------------------------------|
| Motors up to 1500kW | - | 600% subject to IS tolerance of plus 20%. |
| Motors above 1500kW | - | 450% not subject to any positive tolerance. |
- 5.02.01 The motor shall be capable of withstanding the stresses imposed if started at 110% rated voltage.

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- 5.02.02 Motor shall start with rated load and accelerate to full speed with 80% rated voltage at motor terminals except mill motor. Mill motor shall start with rated load and accelerate to full speed at 85% of the rated voltage at the motor terminals.
- 5.02.03 a) Two hot starts in succession with motor initially at normal running temperature.
- b) Pump motor subject to reverse rotation shall be designed to withstand the stresses encountered when starting with shaft rotating at 125% rated speed in reverse direction.
- 5.02.04 The motors shall be designed to withstand 120% of rated speed for 2 minutes without any mechanical damage.
- 5.03.00 **Stress During Bus Transfer**
- 5.03.01 The motor may be subjected to sudden application of 150% rated voltage during bus transfer, due to the phase difference between the incoming voltage and motor residual voltage.
- 5.03.02 The motor shall be designed to withstand any torsional and/or high current stresses, which may result, without experiencing any deterioration in the normal life and performance characteristics.
- 5.04.00 **Locked Rotor Withstand Time**
- 5.04.01 The locked rotor withstand time under hot condition at 110% rated voltage shall be more than motor starting time by at least 3 seconds for motors up to 20 seconds starting time and by 5 seconds for motor with more than 20 seconds starting time.
- 5.04.02 Starting time mentioned above is at minimum permissible voltage of 80% rated voltage.
- 5.04.03 Hot thermal withstand curve shall have a margin of at least 10% over the full load current of the motor to permit relay setting utilising motor rated capacity.
- 6.00.00 **SPECIFIC REQUIREMENTS**
- 6.01.00 **Enclosure**
- 6.01.01 All motor enclosures for outdoor, semi-outdoor & indoor application shall conform to the degree of protection IP-55 unless otherwise specified. Motor for outdoor or semi-outdoor service shall be of weather-proof construction with canopy.
- 6.01.02 For hazardous area approved type of increased safety enclosure shall be furnished.
- 6.02.00 **Cooling**
- 6.02.01 The motor shall be self ventilated type, either totally enclosed fan cooled IC 411(TEFC), totally enclosed tube ventilated IC 511(TETV) or closed air circuit air- cooled IC 611(CACA).

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- 6.02.02 For large capacity motors not available with above type of cooling may be accepted with IC 81W or IC 91W, closed air circuit water cooled (CACW) subject to the approval of the owner.
- 6.03.00 **Winding and Insulation**
- 6.03.01 All insulated winding shall be of copper.
- 6.03.02 All motors shall have class F insulation but limited to class B temperature rise.
- 6.03.03 Windings shall be impregnated to make them non-hygroscopic and oil resistant.
- 6.04.00 **Tropical Protection**
- 6.04.01 All motors shall have fungus protection involving special treatment of insulation and metal against fungus, insects and corrosion.
- 6.04.02 All fittings and hardwares shall be corrosion resistant.
- 6.05.00 **Bearings**
- 6.05.01 Motor shall be provided with antifriction bearings, unless sleeve bearings are required by the motor application. Bearings shall be rated for minimum service life of 40,000Hrs.
- 6.05.02 Vertical shaft motors shall be provided with thrust and guide bearings. Thrust bearing of tilting pad type is preferred.
- 6.05.03 Bearings shall be provided with seals to prevent leakage of lubricant or entrance of foreign matters like dirt, water etc. into the bearing area.
- 6.05.04 Sleeve bearings shall be split type, ring oiled, with permanently aligned, close running shaft sleeves.
- 6.05.05 Grease lubricated bearings shall be pre-lubricated and shall have provisions for in-service positive lubrication with drains to guard against over lubrication. LT motors 15kW and above shall be provided with external greasing arrangement.
- 6.05.06 Oiled bearing shall have an integral self cooled oil reservoir with oil ring inspection ports, oil sight glass with oil level marked for standstill and running conditions and oil fill and drain plugs.
- 6.05.07 Forced lubricated or water cooled bearing shall not be used without prior approval of Owner.
- 6.05.08 Lubricant shall not deteriorate under all service conditions. The lubricant shall be limited to normally available types with IOC equivalent.
- 6.05.09 Bearings shall be insulated as required to prevent shaft current and resultant bearing damage.
- 6.06.00 **Noise & Vibration**

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- 6.06.01 All HT motors shall be provided with vibration pads for mounting of vibration detectors. Vibration monitoring devices shall be provided on DE and NDE side in x&y direction with remote DCS monitoring, alarm and tripping.
- 6.06.02 The maximum double amplitude vibrations for HT motors upto 1500 rpm shall be 25 microns and 15 microns upto 3000 rpm. For 415V motors, maximum double amplitude vibrations upto 1500 rpm shall be 40 microns and 15 microns upto 3000 rpm.
- 6.06.03 The noise level shall not exceed 85db (A) at 1.5 meters from the motor.
- 6.07.00 **Motor Terminal Box**
- 6.07.01 Motor terminal box shall be detachable type and located in accordance with Indian Standards clearing the motor base- plate/ foundation
- 6.07.02 Terminal box shall be capable of being turned 360 Deg. in steps of 180 Deg. for HT motors and 90 Deg. for LT motors unless otherwise approved.
- 6.07.03 The terminal box shall be split type with removable cover with access to connections and shall have the same degree of protection as motor.
- 6.07.04 The terminal box shall have sufficient space inside for termination/connection of XLPE insulated armoured aluminium cables.
- 6.07.05 Terminals shall be stud or lead wire type, substantially constructed and thoroughly insulated from the frame.
- 6.07.06 The terminals shall be clearly identified by phase markings, with corresponding direction of rotation marked on the non-driving end of the motor.
- 6.07.07 The terminal box shall be capable of withstanding maximum system fault current for a duration of 0.25 sec.
- 6.07.08 For 11000V and 3300V motor, the terminal box shall be phase-segregated type. The neutral leads shall be brought out in a separate terminal box (not necessarily phase segregated type) with shorting links for star connection.
- 6.07.09 Motor terminal box shall be furnished with suitable cable lugs and double compression brass glands to match with cable used.
- 6.07.10 The gland plate for single core cable shall be non-magnetic type.
- 6.07.11 Minimum clearances to be provided between phase to phase and phase to earth shall be as under-
- | Voltage Rating of Motor | | Minimum Ph-Ph & Ph-Earth clearance |
|-------------------------|---|------------------------------------|
| 0.415 kV | : | 25 mm |
| 3.3 kV | : | 65 mm |
| 11.0 kV | : | 140 mm |

Note: In case it is not possible to maintain these clearances, the live parts shall be totally insulated from earth and other Phases. Adequate clearances shall be provided for cable connections.

6.08.00 **Grounding**

6.08.01 The frame of each motor shall be provided with two separate and distinct grounding pads complete with tapped hole, GI bolts and washer.

6.08.02 The grounding connection shall be suitable for accommodation of ground conductors as follows:

Rating		Conductor Size	
Above	Up to		
-----	5.5 kW	:	8 SWG GI Wires.
5.5 kW	22 kW	:	25mm X 4mm GS Flat.
23 kW	55 kW	:	40mm X 6mm GS Flat.
56kW	174kW	:	50mm X 8mm GS Flat.
175kW	ABOVE	:	75mm X 10mm GS Flat.

6.08.03 The cable terminal box shall have a separate grounding pad.

6.09.00 **Minimum Cable Size for LT & HT Motors shall as be as follows-**

a) For 415V, 3-Ph, LT Motors-

Rating		:	Cable Size
Above	Up to		
-----	5.5 kW	:	1R X 3C X 6 Sq.mm
5.5 kW	11 kW	:	1R X 3C X 10 Sq.mm
11 kW	22 kW	:	1R X 3C X 35 Sq.mm
22 kW	37.5 kW	:	1R X 3C X 70 Sq.mm.
37.5kW	55 kW	:	1R X 3C X 150 Sq.mm
55 kW	75 kW	:	1R X 3C X 300 Sq.mm
75 kW	110kW	:	2R X 3C X 150 Sq.mm
110 kW	175kW	:	2R X 3C X 300 Sq.mm

b) For 3.3kV & 11kV, 3-Ph, HT Motors-

Rating		:	Cable Size
Above	Up to		

175 kW	1000 kW	:	1R X 3C X 240 Sq.mm
1000 kW	2000 kW	:	2R X 3C X 240 Sq.mm
2000 kW	4500 kW	:	2R X 3C X 300 Sq.mm
4501 kW	10,000 kW	:	9R X 1C X 1000 Sq.mm.

Note: During detail engineering if higher cable size is required same shall be provided.

6.10.00 **Rating Plate**

In addition to the minimum information required by IS, the following information shall be shown on motor rating plate :

- a) Temperature rise in Deg.C under rated condition and method of measurement.
- b) Degree of protection.
- c) Bearing identification no. and recommended lubricant.
- d) Location of insulated bearings.

7.00.00 **ACCESSORIES**

7.01.00 **General**

Accessories shall be furnished, as listed below, or if otherwise required by driven equipment specification or application.

7.02.00 **Space Heater**

7.02.01 Motor of rating 30 kW and above shall be provided with space heaters, suitably located for easy removal or replacement.

7.02.02 The space heater shall be rated 240 V, 1 Phase, 50Hz and sized to maintain the motor internal temperature above dew point when the motor is idle.

7.02.03 Minimum Cable Size for space heater shall be as listed-

- i) For LT motors: 2.5 sq.mm, 2-Core copper cable complying with IS-1554(Part-1).
- ii) For HT motors: 6 sq.mm, 2 Core aluminium cable complying with IS-1554(Part-1).

7.03.00 **Temperature Detectors**

7.03.01 All 11000V and 3300V motors shall be provided with twelve (12) nos. simplex type winding temperature detectors, four (4) nos. per phase.

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- 7.03.02 11000V and 3300V motor bearing shall be provided with duplex type temperature detectors.
- 7.03.03 The temperature detector mentioned above shall be resistance type, 3 wire, platinum wound, 100 Ohms at 0°C.
- 7.03.04 Leads of all simplex type motor winding RTDS and motor bearing RTDS shall be wired up to respective switchgear metering & protection compartment. From which one set of RTDS will be connected to numerical protection relay and another set shall be kept free for DDCMIS connectivity.
- 7.03.05 0.5 sq.mm annealed tinned copper conductor complying with IS-1554(Part-1). shall be used for RTD/BTD wiring.
- 7.04.00 **Indicator/Switch**
- 7.04.01 Dial type local indicator with alarm contacts shall be provided for the following:
- a) 11000 V and 3300V motor bearing temperature.
 - b) Hot and cold air temperature of the closed air circuit for CACA and CACW motor.
- 7.04.02 Flow switches shall be provided for monitoring cooling water flow of CACW motor and oil flow of forced lubrication bearing, if used. CACW motor shall be provided with water leakage detector with remote alarm and tripping.
- 7.04.03 Alarm switch contact rating shall be minimum 2.0 A at 220V D.C. and 10A at 240V A.C.
- 7.05.00 **Current Transformer for Differential Protection**
- 7.05.01 Motor 1000 kW and above shall be provided with three differential current transformers mounted over the neutral leads within the enclosure.
- 7.05.02 The arrangement shall be such as to permit easy access for C.T. testing and replacement. Current transformer characteristics shall match Owner's requirements to be intimated later.
- 7.06.00 **Accessory Terminal Box**
- 7.06.01 All accessory equipment such as space heater, temperature detector, current transformers etc., shall be wired to and terminated in terminal boxes, separate from and independent of motor (power) terminal box.
- 7.06.02 Accessory terminal box shall be complete with double compression brass glands and pressure type terminals to suit owner's cable connections.
- 7.07.00 **Drain Plug**
- Motor shall have drain plugs so located that they will drain the water, resulting from the condensation or other causes from all pockets of the motor casing.

7.08.00 Lifting Provisions

Motor weighing 25 Kg. or more shall be provided with eyebolt or other adequate provision of lifting.

7.09.00 Dowel Pins

The motor shall be designed to permit easy access for drilling holes through motor feet or mounting flange for installation of dowel pins after assembling the motor and driven equipment.

7.10.00 Painting

PL. REFER PAINTING SCHEDULE OF MECHANICAL SPECIFICATION

8.00.00 TESTS

Routine and Type Tests are to be conducted in presence of customer's representative as per IS:325 and in addition, any special test called for in the driven equipment specification shall be performed and required copies of test certificates are to be furnished for approval. In addition, following tests shall have to be carried out on the motors in presence of OWNER's representative on 3.3kV/11kV motors.

- a. Impulse test by 1.2 / 50 micro sec. On sample coil of Stator winding insulation as type test as per IEC-60034, part -15 test voltages as under :

Voltage rating of motor	Impulse Test Voltage
3.3 kV	18 kV peak
11 kV	49 kV peak

- b. Tan delta, charging current and dielectric loss measurements on each phase of motor stator winding as routine test.
- c. Polarization Index Test as per IS: 7816 as routine test
- d. Test for suitability of IPW– 55(Weather proof) as per IS 4691 as type test. Type test certificate for first numeral shall be acceptable in lieu to test, provided the test motor is identical to motor being supplied. Second numeral test shall be carried out on one motor of each type and rating.
- e. Fault Withstand Test for main terminal box as type test. Type test certificate shall be acceptable, if the test is conducted on exactly identical terminal box.
- f. Test for noise level as routine test.
- g. Test for vibration as routine test.

**Telangana State Power Generation Corporation Ltd
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- h. Tan delta measurement on coils.
- i. Surge withstand test for inter turn insulation.
- j. Test to diagnose rotor bar failure during manufacture.
- k. Over speed test as routine test.
- l. Temperature rise test.

Temperature rise under normal condition above ambient temperature shall be limited to-

Specified Design Ambient temperature	Thermometer Method	Resistance Method
50 deg.C	60 deg.C	70 deg.C
45 deg.C	65 deg.C	75 deg.C
40 deg.C	70 deg.C	80 deg.C

Tests indicated at (h), (i), (j) shall be carried out during manufacture of the coils and shall be furnished for verification.

9.00.00 DRAWINGS, DATA & MANUALS

9.01.00 Drawings, Data & Manuals shall be submitted in triplicate with the bid and in quantities and procedures as specified in General Conditions of Contract and/or elsewhere in the specification for approval and subsequent distribution after the issue of 'Letter of Intent'.

9.02.00 To be Submitted with the bid

- a) List of the motors
- b) Individual motor data sheet as per format of the proposal data sheets.
- c) Scheme & write-up on forced lubrication system, if any
- d) Type test report

9.03.00 To be submitted for Owner / Purchaser's Approval and Distribution

All relevant drawings and data pertaining to the equipment like GTP, GA drawing, foundation plan, QAP, etc. shall be submitted by the Bidder for approval of Owner/Owner's consultant. ~~Also refer clause no. 1.19.02(u) of Section I of Volume V A: Technical Specifications for Electrical Equipment & Accessories.~~

ANNEXURE-A

DESIGN DATA

1.0 AUXILIARY POWER SUPPLY

Supply	Description	Consumer
H.V. Supply	11000 V, 3Ø, 3W, 50 Hz, Non-effectively earthed Fault level 44 kA symm. for 1 sec.	Motors 1500 kW & above
M.V. Supply	3300 V, 3Ø, 3W, 50 Hz, Non-effectively earthed Fault level 40 kA symm. for 1 sec.	Motors 175 kW and Up to less than 1500 kW.
L.V. Supply (i)	415V, 3Ø, 3W, 50 Hz effectively earthed Fault level 50 kA symm. for 1 sec.	Motors above 0.2kW and below 175kW.
	240V, 1Ø, 2W, 50 Hz effectively earthed	Lighting, Space heat- ing , A.C supply for Contr- ol & protective devices.
D.C. Supply	220V, 2W, unearthed Fault level 25* kA. for 1 sec.	D.C. alarm, control & protective devices

* Indicative only, the actual value will be decided by the Bidder, after substantiating the same by calculation.

Note-

- 415V or 3.3 kV may be adopted by the bidder for the drives in the range of 160-210 kW.
- 3.3 kV AC supply for CHP conveyor motors of rating above 160 kW is to be used.
- The voltage rating of the drives indicated above is for basic guideline. Minor variations can be accepted on case to case basis based on techno-economic considerations of the various sub-systems.
- Voltage rating for special purpose motors viz, VFD and screw compressors, shall be as per manufacturer's standard. All the motors ratings on Stacker/ reclaimer shall be 415V ac supply only.

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LV MOTORS

DATA SHEET-A

SPECIFICATION NO.

VOLUME

SECTION

I, Sub-section-IB

REV NO. 00

DATE 23.02.22

SHEET 1 OF 2

1.0	Design ambient temperature	:	50 °C
2.0	Maximum acceptable kW rating of LV motor	:	Upto 175KW
3.0	Installation (Indoors/ Outdoors)	:	As required
4.0	Degree of Protection	:	IP55 (Motor for outdoor or semi-outdoor service shall be of weather-proof construction with canopy).
5.0	Cooling	:	TEFC/ TETV/ CACA
6.0	Details of supply system		
	a) Rated voltage (with variation)	:	415V \pm 10%
	b) Rated frequency (with variation)	:	50 Hz (Variation: +5% TO -5%)
	c) Combined voltage & freq. variation	:	10% (sum of absolute values)
	d) System fault level at rated voltage	:	50 kA for 1 sec
	e) Short time rating for terminal box	:	50 kA for 0.25 sec
	f) LV System grounding	:	Solidly
7.0	Class of insulation	:	Class 'F', with temp rise limited to class B.
8.0	Minimum voltage for starting (As percentage of rated voltage)	:	80% of rated voltage
9.0	Power cables data	:	Shall be given during Detailed engg.
10.0	Earth Conductor Size & Material	:	Shall be given during Detailed engg.
11.0	Space heater supply (30KW & ABOVE)	:	240 V, 1 Φ , 50 Hz
12.0	Rating up to which Single phase motor	:	Acceptable below 0.20 Kw
13.0	TYPE OF STARTER PROVIDED IN MCC	:	DOL
14.0	Locked rotor current		
	a) Limit as percentage of FLC	:	600% subject to IS tolerance of plus 20%.
	b) Permissible tolerance, if any	:	
15.0	Additional tests	:	As per QP
16.0	ACCEPTABLE NOISE LEVEL	:	85dB at 1.5m
17.0	Makes	:	AS PER SUB VENDOR LIST
18.0	Terminal box	:	Turned 360 Deg. in steps of 90 Deg.
19.0	Paint shade	:	Shade 631 of IS-5
20.0	Efficiency class	:	IE3
21.0	LOCKED ROTOR WITHSTAND TIME	:	The locked rotor withstand time under hot condition at 110% rated voltage shall be more than motor starting time by at least 3 seconds for motors up to 20 seconds starting time and by 5 seconds for motor with more than 20 seconds starting time.

NOTE:

1. Also detailed Customer spec. for Motors is to be referred as enclosed with technical spec.

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	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001	
		SECTION: I	
		SUB-SECTION: ID	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1	OF 1

SPECIFIC TECHNICAL REQUIREMENTS

SUB-SECTION – IC

SPECIFIC TECHNICAL REQUIREMENTS (C&I)

1 x 800 MW KOTHAGUDEM STTP

Specifications of Reverse Rotation Monitoring System		
A) Specifications for Indicator		
1	Service	Reverse Rotation Monitor
2	Speed Range	0 – 1500 RPM
3	Indicator Electronics	The Indicator will have cards like signal conditioner cards power supply cards, microprocessor cards using latest state of the art microcontroller technology and will be replaceable individually by the user at site.
4	Power Supply	240 V AC
5	Front Plate Indication	Digital Indication of the rotation speed, Digital Indication of Normal, Reverse and Power On
6	No. of Contacts	4 NO + 4 NC
7	Rating Contacts	5 Amps at 240 V AC 50 Hz
8	Outputs	4-20mA corresponding to the speed of the rotation range
9	Casing	Metallic Panel Mounting Type
10	Dimensions	Casing : 192 mm x 96 mm x 160 mm Cutout : 188 mm x 92 mm x 160 mm
	Vendor will provide a complete user and troubleshooting Manual of the indicator containing brief write up about the system features and working principle along with details of the cards	
B) Specification for Probes		
1	No. of Probes	3 Nos. (For each Reverse Rotation Monitor)
2	Type of Probe	Non contact type probes which can sense the reverse rotation Within 30 degrees of motion
3	Probe dia	M 30 x 1.5 with optional accessories of mounting arrangements
4	Probe length	65 mm
5	Power Supply	Each Probe is powered from the remotely mounted indicator with +12V DC
6	Sensitivity of the Probes	The probes will be capable of sensing the shaft rotation in a gap of 2 or 8 mm
7	Extension Cable	Cable of 3 meters will be supplied with each probe for Connection of the probe with the local Junction Box
8	Junction Box	A local Junction Box suitable for installation in harsh coastal environment will be provided by vendor. The Junction will have terminals suitable for connection of the Cable from remotely mounted indicator and the cables from the Proximity Sensors. Necessary glands, sealing will be provided to prevent entry of insects, dust, ash, etc.
9	Probe Construction	The probe will be suitable for working in harsh coastal environment
10	Mounting of the Probe	The probe will be mounted suitably using locknuts suitable for the probe
11	Target hole / key projection	Pump supplier should provide hole / slot/ projection on the shaft for Proximeter sensing and size of the hole / projection should be informed to vendor

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	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001	
		SECTION: I	
		SUB-SECTION: ID	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1	OF 1

SPECIFIC TECHNICAL REQUIREMENTS

SUB-SECTION – ID

DATASHEET-A

735230/2022/PS-PEM-MSE

DATA SHEET - A

SPECIFICATION NO:

PE-TS-439-100-N001, REV-0

MISCELLANEOUS PUMPS (HORIZONTAL)

SECTION: I D

REV : 00, DATED 04.03.2022

HORIZONTAL CENTRIFUGAL PUMPS

PROJECT:

1X800MW KOTHAGUDEM TPS UNIT-12 (FGD), TELANGANA

Sl. No.	DESCRIPTION	FGD ECW PUMPS HORIZONTAL PUMPS	FGD ACW PUMPS HORIZONTAL PUMPS
1.0	SERVICE		
1.1	Total number of Pumps for Project	2	2
1.2	Number of working(W) & Standby(S) pumps	1W+1S	1W+1S
1.3	Liquid Handled (refer water analysis enclosed herein)	pH corrected DM Water	Clarified water with CoC 5
1.4	Location (Indoor / Outdoor)	Outdoor	Outdoor
1.5	Duty	Continuous	Continuous
1.6	No. of pumps working in parallel	0	0
1.7	Specific gravity	1	1
1.8	System design pressure (kg/sq. cm), g	10	10
2.0	DESIGN PARAMETERS		
2.1	Design/Rated capacity each, M ³ /hr	175	176
2.2	Total dynamic head (MWC) at Rated Capacity	45	23
2.3	Suction Pressure(MWC)	Flooded Suction	Flooded suction
2.4	Design Temperature (°C)	60	60
2.5	Maximum permissible speed of pump (RPM)	1500	1500
2.6	Max. limit on shut off head Corresponding to pump TDH (MWC) at 51.5 Hz	Not to exceed 80 MWC	Not to exceed 50 MWC
2.7	Operating range	-----30-130% of design duty point flow-----	
2.8	Motor rating	Drive unit power rating shall be the maximum of the following requirements: a) Pump shaft input power required considering the overloading of the pump assuming single pump operation in the event of tripping of one or more of the pumps operating in parallel. b) 15% (for LT motor) or 10% (for HT motor) margin over the pump shaft input power at the rated duty point. c) 5% margin over the maximum pump shaft input power required within the 'Range of Operation'.	
2.9	Permissible tolerance in rated capacity & TDH	no negative tolerance	
2.10	Permissible tolerance in efficiency at rated capacity(%)	no negative tolerance	
2.11	Performance/Design Standard	HIS / IS 5120	
3.0	CONSTRUCTION FEATURES		
3.1	Pump type	Horizontal centrifugal type	Horizontal centrifugal type
3.2	Impeller type	Closed	Closed
3.3	Casing type	Horizontal Axial split type	Horizontal Axial split type
3.4	Coupling type	Flexible Spacer type	Flexible Spacer type
3.5	Sealing arrangement	Gland packing initially & Mechanical seal finally after commissioning	Gland Packing
3.6	Type of Lubrication	Self Liquid / Grease	Self Liquid / Grease
3.7	Pump characteristics	Non Overloading type & stable	Non Overloading type & stable
3.8	Drain Plugs, vent with valve, lifting lugs, priming connection, coupling guard, Positioning dowels, Companion flanges with nuts, bolts & gaskets	Required	Required
4.0	MATERIALS OF CONSTRUCTION		
4.1	Casing	ASTM-A-351 CF 8M	2.5% Ni Cl to IS: 210 Gr FG-260
4.2	Impeller	ASTM-A-351 CF 8M / SS316	ASTM-A-351 CF 8M / SS316
4.3	Shaft	SS 316	SS 316
4.4	Shaft Sleeves	SS 410	SS 410
4.5	Impeller Wearing rings	SS 316	SS-316
4.6	All Fasteners	Stainless Steel	Stainless Steel
4.7	Gland/Seal Cover	SS 316	2.5% Ni Cl to IS: 210 Gr FG-260
4.8	Lantern Ring	SS 316	SS316
4.9	Mech. seal	Manufacturer standard	NA
4.10	Gland Packing	Teflon Impregnated (Asbestos Free)	Teflon Impregnated (Asbestos Free)
4.11	Base Plate	MS fabricated IS-2062 (min. thk.-10 mm) Epoxy Coated	
4.12	Stuffing Box	ASTM A 351 CF 8M	2.5% Ni Cl to IS: 210 Gr FG-260

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DATA SHEET - A

SPECIFICATION NO:

PE-TS-439-100-N001, REV-0

MISCELLANEOUS PUMPS (HORIZONTAL)

SECTION: I D

REV : 00, DATED 04.03.2022


HORIZONTAL CENTRIFUGAL PUMPS

PROJECT:


1X800MW KOTHAGUDEM TPS UNIT-12 (FGD), TELANGANA

Sl. No.	DESCRIPTION	FGD ECW PUMPS	FGD ACW PUMPS
4.13	Casing Wearing rings (If applicable)	SS 316	SS316
4.14	Coupling	SS316	SS316
4.15	Connecting Pipe material (for deciding counterflange material)	Carbon Steel to IS 1239 (Heavy Grade) / IS:2062 GR. E 250B, Plates rolled & welded as per IS 3589.	Carbon Steel to IS 1239 (Heavy Grade) / IS:2062 GR. E 250B, Plates rolled & welded as per IS 3589.
5.0	MANDATORY SPARES FOR PUMP-MOTOR SET		
5.1	Key for Impeller	1 no. for each application and ratings of pumps	-
5.2	Bearings	1 set (comprising of drive and non-drive end) for each application and ratings of pumps	-
5.3	Wear ring for shaft and impeller	1 Set for each application and ratings of pumps	-
5.4	Mechanical Seal with Sleeves	1 Set for each application and ratings of pumps	-
5.5	Coupling	1 No. for each application and ratings of pumps	1 Nos.
5.6	Shaft Sleeve	-	1 No.
5.7	Impeller wear ring	-	1 No.
5.8	Casing wear ring	-	1 No.
5.9	Gland Packing	-	1 No.
5.10	Lantern Ring	-	1 No.
Mandatory Spare Note: 1. One(1) set consists of quantity required for complete replacement for one(1) Pump of each type/size. Also the 'set' would include all components/hardware required to replace the item. 2. Wherever the quantities have been indicated for each type, size, thickness, material, radius, range etc. these shall cover all the items supplied and installed and the break up for these shall be furnished in the bid. 3. In case spares indicated in the list are not applicable to the particular design offered by the bidder, the bidder should offer spares applicable to offered design with quantities generally in line with the approach followed as above. 4. Each spare shall be clearly marked and labeled on the outside of the packing with its description. When more than one spare part is packed in single case, a general description of the contents shall be shown on the outside of such case and a detailed list enclosed. All cases, containers and other packages must be suitably marked and numbered for the purpose of identification.			
6.0	BID EVALUATION RATE		
6.1	Bid evaluation rate	INR 2.0 Lacs/KW	INR 2.0 Lacs/KW
6.2	Maximum permissible efficiency for Bid evaluation		
6.2.1	Pump Efficiency	70	75
6.2.2	Motor Efficiency	93	92.9
Notes :			
1	Material of construction for other components not specified above shall be similarly selected in line with the above for the duty intended and subject to approval.		
2	For items stated as not applicable by bidder, shall have to be supplied without any cost implication to BHEL in the event they are found to be applicable during detail engineering stage.		
3	For all HT motor driven pumps (wherever applicable), bidder shall provide flat surface with dimensions 60 MM x60 MM on bearing Housing for mounting vibration measuring block and a key slots of dimensions 30MM (L) X 15 MM (W) X 3 MM (D) on each pump shaft or some other suitable location which shall be confirmed during detail engineering by BHEL for Phase Marker.		
4	Wherever SS material is coming in contact with non SS material, suitable isolation (rubber etc.) shall be provided to avoid galvanic corrosion.		

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DATA SHEET - A		SPECIFICATION NO.:	PE-TS-439-100-N001
	MISCELLANEOUS PUMPS (VERTICAL)	REV. NO.: 00	DATE : 04/03/2022
	1X800 MW TSGENCO KOTHAGUDAM TPS STAGE -VII,PALONCHA (FGD Pkg.)	SECTION:	I D
	SI. No.	FGD MAKE-UP WATER PUMPS	
1.0	SERVICE		
1.1	Total no. of pumps for Project	2	
1.2	No. of working & standby pumps	1W+1S	
1.3	Liquid Handled (ref. water analysis enclosed herein)	Clarified water	
1.4	Location	Clarified Water P/H	
1.4.1	Indoor / Outdoor	Indoor	
1.5	Duty	Continuous	
1.6	Specific gravity	1	
1.7	No. of pumps working in parallel	-	
1.8	System design pressure (kg/sqcm), g	10	
2.0	DESIGN PARAMETERS		
2.1	Design capacity each, M ³ /hr	150	
2.2	Total dynamic head (MWC) (Developed Pump head at Min WL, excluding Pumps Internal frictional losses upto discharge)	50	
2.3	• Suction Pressure(MWC)	Submerged Suction	
	• Floor Level- for Pump Mounting	RL 106.3M	
	• Min. W.L.	RL 99.3M	
	• Max. W.L.	RL 104.5M	
	• Sump Invert Level	RL 96.8M	
	• Crane Hook Level	RL 112.7M (tentative)	
	• Crane Capacity Available	2.5 Ton	
2.4	Design Temperature (°C)	60	
2.5	Maximum permissible speed of pump (RPM)	1500	
2.6	Max. limit on shut off head Corresponding to pump TDH (MWC) at 51.5 Hz	Not to exceed 90 MWC	
2.7	Pump Discharge - above floor / below floor	Above Floor	
2.8	Operating range	30% to 130% of rated capacity	
2.9	Motor rating	Drive unit power rating shall be the maximum of the following requirements: a) Pump shaft input power required considering the overloading of the pump assuming single pump operation in the event of tripping of one or more of the pumps operating in parallel. b) 15% (for LT motor) or 10% (for HT motor) margin over the pump shaft input power at the rated duty point. c) 5% margin over the maximum pump shaft input power required within the 'Range of Operation'.	
2.10	Permissible tolerance in rated capacity & TDH	no negative tolerance	
2.11	Permissible tolerance in efficiency at rated capacity(%)	no negative tolerance	
2.12	Performance/Design Standard	HIS / IS1710	
2.13	Discharge pipe (ODXTHK),(mmxmm)	166.5X5.4	
2.14	Suction Specific Speed Limit (US Units)	Shall be limited to 9000 US units	
2.15	Noise level	85 dBA (max)	
3.0	CONSTRUCTION FEATURES		
3.1	Pump type	Vertical Turbine Wet Pit Type	
3.2	Impeller type	Closed	
3.3	Casing type	Vertical Turbine Type	
3.4	Coupling type	Flexible	
3.5	Sealing arrangement	Self Water / Gland packing	
3.6	Type of gland lubrication and sealing	By Self Water	
3.7	Pump characteristics	Non Overloading type & stable	
3.8	Drain Plugs, vent with valve, lifting lugs, etc.	To be Provided by OEM	
3.9	Thrust Bearing location	Separate for pump and motor	
3.10	Reverse flow through pump to be considered for pump design	YES	
3.11	Thrust bearing to be designed for pump shut off operation	YES	
3.12	Bearing cooling	By Self Water / Grease	
4.0	MATERIALS OF CONSTRUCTION		

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DATA SHEET - A		SPECIFICATION NO.:	PE-TS-439-100-N001
 MISCELLANEOUS PUMPS (VERTICAL)		REV. NO.: 00	DATE : 04/03/2022
1X800 MW TSGENCO KOTHAGUDAM TPS STAGE -VII,PALONCHA (FGD Pkg.)		SECTION:	I D
Sl. No.	DESCRIPTION	FGD MAKE-UP WATER PUMPS	
4.1	Casing & Suction Bell	2% Ni Cl to IS 210 GR FG-260	
4.2	Column Pipe	IS-2062 (MS) (Min. 10mm thick) with 300 micron epoxy coating inside and outside	
4.3	Minimum column pipe thickness, mm	10 mm	
4.4	Impeller	ASTM A-351 CF8M / SS316	
4.5	Shaft/ Line Shaft	SS 410	
4.6	Shaft Sleeves	SS 410 (Hardened)	
4.7	Shaft Coupling	SS 410 (Hardened)	
4.8	Wearing rings	SS-410	
4.9	Wetted fasteners	SS-316	
4.10	Fasteners (others)	SS-316	
4.11	Gland plate	2% Ni Cl to IS 210 GR FG-260	
4.12	Lantern Ring (if applicable)	SS-316	
4.13	Intermediate stage bearings	Cutless Rubber Bearing with bronze retainer	
4.14	Mech. seal	NA	
4.15	Gland Packing (Asbestos Free)	Braided Impregnated Teflon (Asbestos Free)	
4.16	Base/ Sole Plate	Fabricated steel to IS-2062 with epoxy coating	
4.17	Thrust pad	Carbon Steel with White Metal Lining	
4.18	Thrust bearing cooling system Piping & Valves (as applicable)	SS	
4.19	Connecting Pipe material (for deciding counterflange material)	Piping shall be Carbon Steel conforming to IS:1239 (Heavy Grade).	
5.0	MANDATORY SPARES FOR PUMP-MOTOR SET		
5.1	Spares for Pumps		
5.1.1	Casing wear rings	1 Set for each type	
5.1.2	Impeller wear rings	1 Set for each type	
5.1.3	Shaft sleeves	1 Set for each type	
5.1.4	Shaft coupling	1 Set for each type	
5.1.5	Shaft nuts and keys	1 Set for each type	
5.1.6	Lantern rings	1 Set for each type	
5.1.7	Bearings Various types as applicable	Complete 1(One) Set (one set means total requirements for one Pump) for each type	
5.1.8	Coupling set (between pump and motor) with accessories	1 Set for each type	
Mandatory Spare Note: 1. One(1) set consists of quantity required for complete replacement for one(1) Pump of each type/size. Also the 'set' would include all components/hardware required to replace the item. 2. Wherever the quantities have been indicated for each type, size, thickness, material, radius, range etc. these shall cover all the items supplied and installed and the break up for these shall be furnished in the bid. 3. In case spares indicated in the list are not applicable to the particular design offered by the bidder, the bidder should offer spares applicable to offered design with quantities generally in line with the approach followed as above. 4. Each spare shall be clearly marked and labeled on the outside of the packing with its description. When more than one spare part is packed in single case, a general description of the contents shall be shown on the outside of such case and a detailed list enclosed. All cases, containers and other packages must be suitably marked and numbered for the purpose of identification.			
6.0	Bid Evaluation		
6.1	Bid evaluation rate	Rs.2.0 Lacs/KW	
6.2	Maximum permissible efficiency for Bid evaluation		
6.2.1	Pump Efficiency	75	
6.2.2	Motor Efficiency	93	
Notes :			
1	Material of construction for other components not specified above shall be similarly selected in line with the above for the duty intended and subject to approval.		
2	For items stated as not applicable by bidder, shall have to be supplied without any cost implication to BHEL in the event they are found to be applicable during detail engineering stage.		
3	For all HT motor driven pumps (wherever applicable), bidder shall provide flat surface with dimensions 60 MM x60 MM on bearing Housing for mounting vibration measuring block and a key slots of dimensions 30MM (L) X 15 MM (W) X 3 MM (D) on each pump shaft or some other suitable location which shall be confirmed during detail engineering by BHEL for Phase Marker.		
4	Wherever SS material is coming in contact with non SS material, suitable isolation (rubber etc.) shall be provided to avoid galvanic corrosion.		

ANNEXURE-II**TREATED WATER QUALITY**

(DESIGN ANALYSIS OF CLARIFIED WATER)

[After addition of 50 ppm Alum, 20 ppm Lime ,1 ppm Polyelectrolyte and
5 ppm Chlorine on 100% purity basis)]**DESIGN ANALYSIS OF CLARIFIED WATER:**

CONSTITUENTS	As	CONTENT	
Calcium	CaCO ₃	128.9	ppm
Magnesium	CaCO ₃	53.52	ppm
Sodium	CaCO ₃	73.44	ppm
Potassium	CaCO ₃	1.02	ppm
Iron in Soln.	Fe	0.1	ppm
Hydrogen (FMA)	CaCO ₃	-	ppm
TOTAL CATIONS (except iron)	CaCO ₃	256.88	ppm
Bicarbonate	CaCO ₃	143.4	ppm
Carbonate	CaCO ₃	0.53	ppm
Hydroxide	CaCO ₃	0.02	ppm
Sulphate	CaCO ₃	59.85	ppm
Chloride	CaCO ₃	50.82	ppm
Nitrate	CaCO ₃	1.21	ppm
Phosphate	CaCO ₃	-	ppm
Fluoride	CaCO ₃	1.05	ppm
TOTAL ANIONS	CaCO ₃	256.88	ppm
Reactive Silica	SiO ₂	10	ppm
Total Suspended Solid	CaCO ₃	10 ppm for normal condition	15 ppm (overload condition)
Conductivity at 25 deg C		450	Microsiemens/cm (max)
pH value at 25 ⁰ C	-	7.62	
Turbidity		Not to exceed 15	NTU (max) 10 NTU for normal condition

DM WATER ANALYSIS

Passivated DM water shall have
PH value of 8.5 to 9.5.

Water Quality at the outlet of MB Exchanger:

Total Electrolyte	0.1 ppm, max.
Total SiO ₂	0.01 ppm SiO ₂ , max.
Iron as Fe	Nil
Free CARBON DI-OXIDE ppm as CARBON DI-OXIDE	Nil
Total Hardness	Nil
pH value at 25 ⁰ C	6.8 - 7.2
Conductivity, micro mho/cm	< 0.1 at 25 ⁰ C


735230/2022/PS-PEM-MSE

2022/PS-PEM-MISE		SPEC. NO.: PE-TS-439-100-N001	
	TITLE: TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SECTION: II	
		SUB-SECTION: IIA	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1 OF 1	
SPECIFIC TECHNICAL REQUIREMENTS			

SUB-SECTION - IIA

STANDARD TECHNICAL SPECIFICATION (MECHANICAL)

- STANDARD TECHNICAL SPECIFICATION FOR MISC. PUMPS (HORIZONTAL) INCLUDING DATASHEET-C
- STANDARD TECHNICAL SPECIFICATION FOR MISC. PUMPS (VERTICAL) INCLUDING DATASHEET-C
- STANDARD QUALITY PLANS

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1.00.00

GENERAL INFORMATION

1.01.0

The general guidelines as illustrated in the subsequent clauses of this section shall be applicable for horizontal centrifugal pumps to be procured under the scope of this package.

1.02.0

It is not the intent to specify herein all the details of design and manufacture. However, the equipment shall conform in all respects to high standards of design, engineering and workmanship, and shall be capable of performing the required duties in a manner acceptable to Engineer/Owner who will interpret the meaning of drawings and specifications and shall be entitled to reject any component or material, which in his judgement is not in full accordance herewith.

1.03.0

The omission of specific reference to any component/accessory necessary for the proper performance of Miscellaneous Pumps and drives shall not relieve the bidder of the responsibility of providing such facilities to complete the supply of equipment at quoted prices.

1.04.0

BHEL's / Customer's representative shall be given full access to the shop in which the equipment are being manufactured or tested and all test records shall be made available to him.

1.05.0

The equipment covered under this specification shall not be dispatched unless the same have been finally inspected, accepted and shipping release issued by BHEL/Customer.

2.00.00

CODES AND STANDARDS

2.01.00

In addition to the requirements spelt out elsewhere in the specification, the equipment to be provided under this section shall specifically conform to the following codes, standards, specifications and regulations, as applicable, including all the latest amendments subsequent to the year of publication as mentioned below.

2.01.01

IS-1520/1980:

Horizontal Centrifugal pumps for clear, cold and fresh water.

2.01.02

IS-5120/1977:

Technical requirements for Rotodynamic special Purpose pumps.

2.01.03

IS-5639/1970:

Pumps for handling chemicals & corrosive liquids.

2.01.04

IS-5659/1970:

Pumps for process water.

2.01.05


IS-6536/1972:


Pumps for handling volatile liquids.


2.01.06

IS-9137/1978:

Code for acceptance tests for centrifugal, mixed flow and axial flow pumps- Class 'C'.

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2.01.07	ISO 3555/1977: BS 5316/1977 Part 2	Acceptance test for centrifugal, mixed flow and axial flow pumps - Class 'B' tests.	
2.01.08	ISO 2548/1973: BS 5316/1976 Part 1	- Do - Class 'C' tests.	
2.01.09	API-610/1989:	Centrifugal pumps for general refinery services.	
2.01.10	HIS	Hydraulic Institute Standards, USA	
2.01.11	PTC 8.2/1965:	Power Test Codes - Centrifugal pumps.	
2.01.12	ASTM-1-165-55	Standard Methods for Liquid Penetration Inspection.	
2.02.00	In case of any contradiction with the above standards and annexure, the stipulations in the annexure shall prevail and shall be binding on the bidder.		
3.00.00	SCOPE OF SUPPLY & SERVICES:		
3.01.00	The miscellaneous pumps and drives scope shall be as specified in Data Sheet A /Section IA.		
3.02.00	The Capacity, Head, Materials of construction and other particulars of pumps are detailed in Data Sheet A of the specification.		
3.03.00	Accessories: All the pumps under this specification shall be complete with following standard/special accessories.		
3.03.01	Standard accessories: a) LT Electric drives/motors (as applicable) with cable gland and lugs at motor end. (The bare HT drive motors and LT motors not in bidder's scope of supply, wherever required supplied as free issue by BHEL refer Cl. 5.08.00). b) Pump motor coupling along with coupling guard. c) Common base plate for pumps and motor. d) Self contained lubrication system along with all internal piping, valves, fittings, specialties etc. as required.		

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<p>e) Counter flanges for suction/ discharge nozzles along with fixing nuts, bolts and gaskets.</p> <p>f) Anchor bolts, nuts, seating steel works, shims etc. as necessary for mounting the pump-motor unit on civil foundations.</p> <p>g) Suitable vent (with valves)/ lifting/ handling attachments for the pump/ motor/ accessories.</p> <p>h) Suitable drain connections with isolating valves as applicable.</p> <p>i) Supply of first fill of lubricants with topping requirements for one year of operation after commissioning and handing over of equipment.</p> <p>j) Set of “Special” Tools & Tackles for Pumps and motors, if any.</p> <p>k) Erection and commissioning spares, “on as required” basis.</p> <p>l) Bidder shall provide various drawings, data, calculations, test reports/ certificates, operation and maintenance manuals, As-built drawings, etc. as specified and as necessary.</p> <p>m) Mandatory spares as specified in respective Data Sheet-A of this section.</p> <p>3.04.00 Services included in Bidder’s Scope:</p> <p>3.04.01 The pumps shall be guaranteed to meet the performance requirements specified vide Data Sheet -A and also for trouble free operation after commissioning. Schedule of performance guarantees (Section-IIIA) duly filled and signed shall be furnished with the bid.</p> <p>3.04.02 Pumps with Mechanical seal shall be supplied with gland packing arrangement initially to site and gland packing arrangement shall be replaced by vendor with mechanical seal arrangement at site after commissioning of the pumps with gland packing. However Mechanical seal shall be dispatched along with main supply for this purpose. Shaft sleeve and any other item required for satisfactory operation of Mechanical seal after replacement at site shall be provided by the pump supplier without any cost implication to BHEL.</p> <p>3.04.03 The pumps erected by the purchaser shall be checked by the bidder for correctness of their installation, alignment, etc. at site prior to their commissioning.</p> <p>3.04.04 After commissioning of pumps at site, site performance test for Noise, vibration and parallel running of pumps of all pumps for each unit/project shall be conducted by pump vendor at project site to ensure that the pumps meet the specified requirements. Pump vendor shall bring necessary instruments for conductance of site performance test.</p>			

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If the site performance is found not meeting the requirements in any respect as specified, then the equipment shall be rectified or replaced by the vendor, without any commercial implication to BHEL.

Note: Applicability of conducting PG test at site by vendor as per above clause shall be applicable if indicated in Section-1A.

If conductance of PG test of pumps at site for Noise, vibration and parallel running of pumps of all pumps for each unit/project is not in bidders scope and same is conducted by BHEL/ customer. In such cases also, if the site performance is found not meeting the requirements in any respect as specified, then the equipment shall be rectified or replaced by the vendor, without any commercial implication to BHEL.

3.04.05 Performance Guarantees for pumps shall stand valid till the satisfactory completion of performance testing by BHEL and its acceptance by purchaser / customer.

3.05.00 Works excluded from Bidder's Scope:

- a) All HT motors and those LT Motors which are specifically excluded.
- b) Civil foundation
- c) Suction/ discharge pipe works
- d) MCC/ Switchgear/Power supply
- e) Power and Control Cables, unless specifically specified in Electrical/ Systems portion of the specification.
- f) Erection of equipments.

4.00.00 BID EVALUATION CRITERIA & LIQUIDATED DAMAGES FOR SHORTFALL:


4.01.00 The bids received shall be evaluated for power consumption at inlet to the motors, in respect of pumps specified in Data Sheet-A (working pump only viz. not the standby), for the purpose of price comparisons as briefed below:


The bid evaluation shall be done at the rate as specified in Data Sheet A per one (1) KW Power consumption, per working pump as follows.


$$KW = \frac{Q \times H \times S}{P \times M \times 367.2}$$


Where Q = Rated capacity M³/hr
 H = Rated TDH, MWC
 P = Pump Efficiency
 M = Motor Efficiency.
 S = Specific Gravity of fluid handled

4.02.00 The efficiencies for pumps and motors for arriving at benchmark power for Bid Evaluation shall be as indicated in Data Sheet A for various pumps.

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<p>No advantage shall be given to the bidder for Aux. Power quoted lower than the Bench mark values calculated with KW calculation formula at Cl. 4.01.00 <i>above, considering the bid evaluation efficiencies for pump and motor as indicated in Data Sheet-A.</i> However the bids shall be evaluated as above if the Aux. Power quoted are higher than Bench mark values.</p> <p>NOTE:</p> <p>1. Efficiencies for HT motors and LT motors not in bidder's scope, for bid evaluation purpose shall be taken based on the maximum value as furnished in Data Sheet A.</p> <p>2. During contract stage the Guaranteed power consumption of Pumps with BHEL supplied drives (HT/LT) for successful bidder shall be reworked by BHEL as below:</p> <p>Revised guarantee power consumption shall be as per KW calculation formula at Cl. 4.01.00 <i>above, where P = pump efficiency guaranteed by bidder and M = motor efficiency as per approved datasheet of the supplied HT/LT motor.</i></p> <p>4.03.00 Liquidated damages for shortfall in Guaranteed KW</p> <p>The above guaranteed power consumption shall be demonstrated by the successful bidder during performance testing at works/ site.</p> <p>For pumps with BHEL supplied drives, the power consumption shall be compared with the reworked guarantee power consumption, defined as per note no. 2 of Cl. 4.02.00 above for the purpose of shortfall.</p> <p>The liquated damages @ twice the bid evaluation rate as above per KW per working pump shall be levied in the event of failure of bidder to demonstrate the guaranteed power consumption.</p> <p>5.00.00 TECHNICAL REQUIREMENTS:</p> <p>5.01.00 The pumps shall meet the technical requirements of Section-I as well as Section-II. In the event of any contradiction of Section-II with Section-I, the Section-I will prevail.</p> <p>5.02.00 The pumps shall be Electric motor driven.</p> <p>5.03.00 The Pumps shall conform to HIS. It is bare minimum requirement, however, any other equivalent or stringent standard is also acceptable, if, all the requirements of HIS are also met.</p> <p>5.04.00 The horizontal pumps shall be Horizontal split casing type with speeds not exceeding 1500 RPM or as indicated in Data Sheet-A.</p> <p>5.05.00 No negative tolerance shall be permitted in rated capacity & TDH.</p> <p>5.06.00 No negative tolerance shall be permitted in efficiency at rated capacity.</p>			

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5.07.00	The shut off head of pumps shall be more than pump rated TDH and percentage variation may vary depending on the specific speed of the pump as under: i. 10-15% for pumps of specific speed up to 1000 US units, ii. 15-20% for pumps of specific speed in the range of 1000 to 2000 US units, iii. 20-40% for pumps of specific speed in the range of 2000 to 4000 US units, iv. Above 50% for pumps of specific speed in the range of 4000 to 7000 US units.		
5.08.00	All HT motors and those LT motors which are not in bidder's scope of supply: bare motors only, shall be supplied as free issue by BHEL through BHEL, based on ratings and TS (Torque - Speed) curve selected and furnished by the bidders along with their un-priced bid. The responsibility for satisfactory operation for combined performance of pumps & motors shall rest with the bidder only as if, the drive motors also have been supplied by the bidder. Couplings, base plate, foundation bolts, any other fittings, etc. as required shall be supplied by the bidders only. BHEL shall supply one number of each type of drive motors (where drive motor is not in bidder's scope of supply) for shop testing of pumps with job motors. All other motors shall be dispatched by BHEL directly to project sites.		
5.09.00	For all HT motor driven pumps, BHEL has envisaged vibration-monitoring system in their own scope. The bidder shall make provisions for mounting following on the pump/ pump shaft: <ul style="list-style-type: none">• Purchaser's probes in both DE/NDE bearings of pumps• Key slots on pump shaft and flat surface on bearing housing for mounting vibration measuring block with dimensions as specified in Data Sheet A.• Other components as finalized during detailing.• For mounting of above on the HT motors & specifically excluded LT motors, same shall be taken care by BHEL.		
5.10.00	The pumps shall be capable of developing the required total head at rated capacity for continuous operation. The pumps shall operate satisfactorily at any point on the Q-H characteristic curve over a range of 0% to 130% capacity and shall be suitable for continuous operation between 30% to 130% capacity.		
5.11.00	Selection of the pumps shall be such that the design point shall be met even with negative manufacturing tolerance.		
5.12.00	The total head capacity curve shall be continuously rising towards the shut off, the pumps shall preferably be non-overloading type and stable.		
5.13.00	The pumps shall be capable of running over the entire range of NPSH conditions required without any noise, vibration or cavitations. The prevailing suction pressures for various pumps are indicated in Data Sheet-A for suitable mechanical design of pumps.		

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5.14.00	The pumps shall be of stiff shaft design. The minimum internal clearances should be sufficiently more than the maximum static deflection of the shaft. Shaft size selected must take into consideration the critical speed as specified in API-610.		
5.15.00	Pumps and motors shall run smooth without undue noise and vibration. The vibration shall be within vibration norms for testing as per American National Standard for 'Rotodynamics Pump' for Vibration Measurement and allowable values, Doc. ANSI/ HIS 9.6.4-2009. The applicable vibration limits for each pump, shall be indicated in the Technical Data sheet to be furnished by the successful bidder after award of LOI/ PO. The noise level shall be limited to 85 dB at distance of 1.0M.		
5.16.00	Pumps of a particular category shall be identical and shall be suitable for parallel operation with equal load division. Components of identical pumps shall be interchangeable.		
5.17.00	After installation, the guaranteed values of noise, vibration and parallel operation of pumps shall be tested and verified. If the site performance is found not meeting the requirements in any respect as specified, then the equipment shall be rectified or replaced by the vendor, at his own cost.		
5.18.00	High reliability of the pumps is an essential requirement and therefore it gets weightage over its efficiency. It is therefore essential that the bidder choose a standard proven model from the range of pumps manufactured.		
5.19.00	The offered pumps shall be of proven design meeting the experience-qualifying requirement of their operation at two sites for a minimum period of one year or as specified in technical PQR. Any deviation to this criterion shall be suitably highlighted in the deviations schedule.		
5.20.00	The bearings shall be self-water lubricated, no external water supply shall be available. The cooling/ lubrication water for bearings, etc. shall be tapped from the pump discharge and supplied thru' bidder's integral pipe work. If water handled by pump is dirty/ not suitable for lubrication/ cooling, the bidder shall provide requisite strainer/ filters, tanks, motorized valves, etc. after the tap off for the required service, the arrangement provided shall be subject to Purchaser's approval.		
6.00.00	MANDATORY SPARES:		
6.01.00	Bidder to provide the Mandatory spares listed vide Data Sheet-A. Unit price of mandatory spares shall be furnished in price Schedule.		
6.02.00	Bidder shall include the cost of Mandatory Spares, unless specified otherwise in Sec-IA of the specification or NIT.		

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7.00.00 OTHER REQUIREMENTS:

7.01.00 The quality of water handled by various pumps shall be as per Data Sheet-A.


7.02.00 The materials of construction for various components specified are the minimum requirements and materials of construction for other components not specified shall be similarly selected by the bidder for the intended duty.


7.03.00 The makes of various bought out items of bidder (i.e. motor, bearings, mechanical seal etc.) shall be subject to purchaser's approval in the event of order.


7.04.00 Painting for Pumps


- The surface of SS, Gun metal, brass, bronze and non-metallic component shall not be applied with any painting.
- The Steel surface to be applied with painting shall be thoroughly cleaned before applying painting by brushing, shop blasting etc. as per the agreed procedure.
- For all the steel surfaces inside the (indoor installation) building, a coat of red oxide primes of min. thickness DFT of 50 microns followed up with under coat of Synthetic Enamel paint of min. thickness DFT of 50 microns shall be applied. The top coat shall consist of two coats each of min. thickness DFT of 50 microns of synthetic enamel paint and thus total DFT shall be min. 200 microns.
- For all the steel surfaces exposed to (outdoor installation) atmosphere, a coat of chlorinated rubber based zinc phosphate primer of min. thickness DFT of 50 microns followed up with under coat of chlorinated rubber paint of min. thickness DFT of 50 microns shall be applied. Then, intermediate coat consisting of one coat of chlorinated rubber based paint pigmented with Titanium di-oxide with min. thickness DFT of 50 microns and top coat shall consist of two coats each of min. thickness DFT of 50 microns of chlorinated rubber paint shall be provided. Total DFT of paint system shall be min. 200 microns.


7.05.00 It is mandatory for the bidder to submit along with the bid, the deviations if any – whether major or minor in the schedule of deviations only. In the absence of deviations listed in the “Schedule of deviations, the offer shall be deemed to be full conformity with the specification, “not-withstanding” anything else stated elsewhere in bidder’s offer. The implied/indirect deviations shall not be binding on the purchaser.


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8.00.00	PERFORMANCE REQUIREMENTS		
8.01.00	Performance requirements for the pumps shall be as guided in Data sheet - A enclosed with Section-I.		
8.02.00	Pump(s) shall preferably be designed to have the best efficiency at flow within $\pm 10\%$ of the specified duty point flow. The pumps shall be suitable for continuous operation at any point within the "Range of Operation" as stipulated in the Data Sheet - A attached with Section-I.		
8.03.00	Pump(s) shall preferably have a continuously rising head-capacity characteristics from the specified duty point towards shut-off point, the maximum being at shut-off to enable parallel operation. Under all circumstances, the 'range of operation' of the pumps shall exclude any unstable operating zone of the head-capacity curve.		
8.04.00	Wherever specified in the Data Sheet - A, pumps of each category shall be suitable for parallel operation. The head vs. capacity, the BHP vs. capacity characteristics etc. shall be identical to ensure equal load sharing and trouble-free operation of any pump when the other pump(s) working in parallel with it trip.		
8.05.00	The pump set along with drive motor shall run smooth without undue noise and vibration. Acceptable vibration limits shall be guided by the HIS of USA. Refer clause 5.15.00 above for permissible limits.		
9.00.00	DESIGN AND CONSTRUCTION		
9.01.00	Pump Casing		
9.01.01	Pump casing shall be provided with adequate number of vents and priming connections with valves unless the pump is made self-venting and priming. Casing drain, as required, shall be provided complete with drain valves. It shall be provided with a connection for suction and discharge pressure gauge as standard feature.		
9.01.02	Pump design must ensure that the nozzles are capable of withstanding external reactions not less than those specified in API-610.		
9.01.03	In case where an expansion joint is located at pump discharge, the pump assembly will be subjected to an additional thrust which will be transmitted to the foundation. This additional thrust shall be taken into the consideration of pump design.		
9.02.00	Impeller		
9.02.01	The Impeller assembly shall be dynamically balanced and designed with critical speed substantially above the operating speed.		


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9.03.00	Wearing Rings		
9.03.01	Replaceable type wearing rings shall be furnished to prevent damage to impeller and casing.		
9.04.00	Shaft		
9.04.01	Shaft size shall be selected considering that the critical speed shall be away from the operating speed as recommended in applicable Code/Standard. The critical speed shall be at least 30% higher than the rated speed.		
9.05.00	Shaft Sleeves		
9.05.01	Renewable type fine finished shaft sleeves shall be provided at the stuffing boxes/mechanical seals. Length of the shaft sleeves must extend beyond the other faces of gland packing or seal end plate so as to distinguish between the leakage past Shaft and shaft sleeve and that past the seals/glands.		
9.05.02	Shaft sleeves shall be properly fastened to the shaft to prevent any leakage or loosening. Shaft sleeve assembly should ensure concentric rotation.		
9.06.00	Bearings		
9.06.01	Bearings shall be easily accessible without disturbing the pump assembly. A drain shall be provided at the bottom of each bearing housing.		
9.06.02	Heavy-duty sleeve/ball/roller type bearings shall be provided to take care of the radial loads.		
9.06.03	In case of sleeve type radial, axial thrust shall be absorbed in suitable hydraulic devices and/or thrust bearings.		
9.06.04	Bearings and hydraulic devices (if provided for balancing axial thrust) shall be of adequate design for taking the entire pump load arising from all probable conditions of continuous operation. Life of the bearings shall be guided by the design standard of the pump. Antifriction bearings of standard type, if provided, shall be selected for a minimum life 20,000 hrs. of continuous operation at maximum axial and radial loads at rated speed. Thrust bearing shall be capable of running continuously at maximum load.		
9.06.05	The bearing shall be oil/grease lubricated. Suitable lubricating arrangement for the bearings shall be furnished with the pump complete with all accessories like pump, filters, piping, fittings, valves, interlocking and supervising instruments etc. as necessary. The design shall be such that the bearing lubricant does not contaminate the liquid being pumped.		
9.06.06	Bearing housing for HT motor driven pumps shall have provision for mounting temperature measuring device.		

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9.06.07	Bearings of reputed makes are to be provided, same shall be indicated in Technical Data sheet to be furnished by the successful bidder after award of LOI/ PO, subject to acceptance of BHEL/ end customer, without any price implication to BHEL.		
9.07.00	Stuffing Boxes		
9.07.01	Stuffing box design shall permit replacement of packing without removing any part other than the gland.		
9.07.02	Stuffing boxes shall be sealed/cooled by the fluid being pumped/external clear water, as specified in the Annexure. All necessary pumps, piping, fittings, valves, instruments etc. as required for safe and trouble-free operation of the pumps and as specified in the Annexure shall be included in the scope of supply.		
9.08.00	Mechanical Seals		
9.08.01	Mechanical seals (cartridge type) shall be provided if specified in the Data Sheet-A of this section. The pump supplier shall co-ordinate with the seal maker in establishing the direct circulation rate for maintaining a stable film at the seal in the chamber. The seal piping system shall form an integral part of the pump assembly.		
9.08.02	When handling liquids near boiling point, suitable arrangement for external cooling shall be provided so as to prevent flashing at the seal faces.		
9.08.03	For the seals under vacuum service, the seal design must ensure sealing against atmospheric pressure, even when the pumps are not operating.		
9.08.04	Pumps with Mechanical seal shall be supplied with gland packing arrangement initially to site and gland packing arrangement shall be replaced by vendor with mechanical seal arrangement at site after commissioning of the pumps with gland packing. However Mechanical seal shall be dispatched along with main supply for this purpose. The special tools (if any) required for above shall be arranged by bidder.		
9.08.05	Mechanical seals of reputed makes are to be provided, same shall be indicated in Technical Data sheet to be furnished by the successful bidder after award of LOI/ PO, subject to acceptance of BHEL/ end customer, without any price implication to BHEL.		
9.09.00	Drive Unit		
9.09.01	The pumps shall be driven by electric motor directly coupled as specified in the Data Sheet-A of this section. A heavy duty coupling along with coupling guard shall be provided between the pump and drive unit.		
9.09.02	Unless otherwise specified in Data Sheet-A of this section, drive unit power rating shall be the maximum of the following requirements.		

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<p>a) 16% margin over the pump shaft input power at the rated duty point.</p> <p>b) 10% margin over the maximum pump shaft input power required within the 'Range of Operation'.</p> <p>c) Pump shaft input power required considering the overloading of the pump assuming single pump operation in the event of tripping of one or more of the pumps operating in parallel.</p>			
9.10.00	Coupling for pump & Motor Shaft		
9.10.01	The pump and motor shafts shall be connected with adequately sized flexible coupling of proven design with spacer to facilitate dismantling of the pump without disturbing the motor. Necessary coupling guard shall be provided.		
9.10.02	No. of coupling holes for joining coupling hubs shall be even in number and preferably in multiples of four.		
10.00.00	INSPECTION AND TESTING		
10.01.00	The Quality Plans enclosed in the specification are for bidder's guidance only. The bidder shall comply with these and other minimum requirements specified in the specification and shall furnish his own quality plan in the event of order based on the guidance given as above, for approval by BHEL/Customer.		
10.02.00	The Bidder shall carry out the following specific tests inspections to ensure that the equipment furnished lies in strict conformance with the specification and also in accordance with applicable codes/standards and good engineering practice.		
<p>a) Identification and Testing</p> <p>i) All materials used for pump construction shall be of tested quality. Material shall be tested as per the relevant standard and test certificates shall be made available to the Owner.</p> <p>ii) 100% PMI (Process Material Identification) inspection for material grade of pump casing, shaft and impeller shall be done by vendor & certification shall be submitted for review of BHEL. Further BHEL reserves the right to conduct random & independent PMI inspection on pump casing, shaft and impeller to ascertain the grade of material during inspection at vendor works.</p> <p>iii) Tests for each pump included under this section shall include but not be limited to the following:</p>			

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<ul style="list-style-type: none"> - The entire surface of the impeller / casing / diffuser castings shall be subjected to Dye Penetration Test as per ASTM Specification no.:1-165-65. - Shaft coupling & other active components shall be subjected to Dye Penetration and Ultrasonic Tests. - Wearing rings, shaft sleeves shall be subjected to Dye Penetration Test. - Fabricated components of pumps shall be subjected to Dye Penetration test on weld. - Verification of material, witnessing of pouring, casting and inspection of finished fabricated/castings. - Inspection of finished castings for impeller and verification of materials. - Inspection of pump shaft and verification of material. - Witnessing of NDT/review of NDT reports. - Static balancing test for impeller and dynamic balancing of complete rotating parts as per ISO- 1940 to grade 6.3 or better. - Complete Inspection of assembled pump. 			
b) Hydraulic Testing			
<p>The pump casing shall be hydrostatically tested at maximum of the following:</p> <ol style="list-style-type: none"> i. 2 times the TDH (Total Dynamic Head) at rated capacity (or) ii. 1.5 times the shut-off pressure (or) iii. System Design pressure indicated in Data Sheet-A of Section-I. <p>The HT pressure shall be maintained for a period of not less than 30 minutes. During testing there should not be any pressure drop & leakage.</p>			
c) Performance Test at Shop			
<ol style="list-style-type: none"> i) Each pump shall have to be tested to determine the performance curves of the pumps. These tests are to be conducted in presence of Owner's representative as per the requirements of the Standards of Hydraulic Institute of USA (ASME-Power Test Code PTC 8.2/BS-599) or any other equivalent standard. ii) Performance tests are to be conducted to cover the entire range of operation of the pumps at rated speed. These shall be carried out to span 130% of rated capacity up to pump shut-off condition. A minimum of five combinations of 			

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<p>head and capacity are to be achieved during testing to establish the performance curves, including the design capacity point, shut-off point and the two extremities of the range of operation as specified in the annexure. After completion of performance test, all pumps shall be stripped down for inspection of internals.</p>			
<p>iii) Tests shall be conducted with actual drive motors being furnished.</p>			
<p>iv) NPSH tests are to be conducted for each type at 3% head drop conditions, if specified in the pump approved QP.</p>			
<p>v) All rotating components of the pumps shall be subjected to static and dynamic balancing tests. The assembled rotor will be subjected to dynamic balancing tests.</p>			
<p>vi) Mechanical run test shall be carried out on all pumps to determine the vibration levels, noise levels etc. This test shall be conducted at site also. However, test value at site shall be used for the acceptance of the equipment.</p>			
10.03.00	Inspection of Mandatory/ Recommended spares shall be in line with approved QP for main supply.		
11.00.00	DRAWINGS/ DOCUMENTS DISTRIBUTION SCHEDULE		
11.01.00	After award of LOI, the successful bidder shall submit drawings/documents as per Data Sheet-C.		
11.02.00	The no. of drawings/documents to be submitted shall be as per Data Sheet-C.		
12.00.00	The various Sections-I's & II's along with Data Sheets attached in this specification together with the specification for Miscellaneous Pumps shall be complied with by the bidders.		
13.00.00	Bidder to submit all drawing/ documents in soft as well as hard copy in the event of order as per schedule indicated in section-IA.		
<p>Within one (1) week of receipt of BHEL comments a technical representative from Bidder's works shall come for meeting with BHEL along with revised documents to resolve all issues and incorporate all comments in the soft copy here only for further submission to customer.</p>			
<p>Further on receipt of customer's comments on the documents a technical representative from Bidder's works shall come for meeting with Customer to resolve all issues and incorporate all comments in the soft copy here only and further resubmission of same to Customer. The representative shall be available here till Category-I approval of all the drawings and documents.</p>			

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14.00.00 Guarantee for all pumps shall at least remain valid for 18 months from the Unit commissioning date or as specified in NIT.

15.00.00 The following documents only shall be furnished by the bidder with his offer:

- Compliance certificate duly signed and stamped (enclosed at Section-IIIB).
- GA drawings of pumps and motors with following: (shall be only for reference purpose, same shall not be reviewed/commented by purchaser at this stage and shall be subject to approval only during contract).
 - Civil static & dynamic loads.
 - Foundation details.
- Guarantee Schedule duly signed and stamped (enclosed at Section-IIIA).
- Technical deviation schedule (if reqd.) (enclosed at Section-IIIC).
- Data for drive Motor (HT/LT- which is not in bidder's scope of supply - as applicable): Load torque speed curves of the pumps, selected motor rating, rpm, GD^2 of driven equipment.
- Unpriced copy of the price bid shall be furnished along with the technical bid.

Apart from above no other Drgs./Docs./Data sheets etc. are required to be submitted at bid stage and even if furnished shall not be taken cognizance of.


In case of any deviation from this technical specification, the same shall be indicated in the schedule of deviations as per Section-IIIC or NIT. In the absence of duly filled schedules it will be assumed that the bid strictly conforms to the specification.

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DATA SHEET – C**Drawings / documents distribution schedule to be followed by successful Bidder:**


- 1.0** Drawings/documents submission schedule, shall be as per Section-IA.
The successful bidder shall submit at least following drawings/ documents:
- 1.1** Fully dimensioned outline general arrangement drawings of the pump and motor assembly. This drawing should include foundation base plate/sole plate details as applicable, civil foundation, anchor bolt details, loading data (Static and Dynamic), points of connections of external piping, cables and mounting of devices furnished by the supplier and details for Gap between Coupling Shafts, Float & details for axial/radial tolerance allowed etc. which are required for erecting agency during erection of pump.
- 1.2** Cross sectional drawing of the equipment showing the details of assembly of components and their material of construction with standard applicable codes.
- 1.3** Technical datasheet as per Datasheet-B (Section-IIID) including characteristic curves of pumps showing the following:
- Flow Vs Head
 - Flow Vs Power
 - Flow Vs Efficiency
 - Flow Vs NPSHR/ minimum submergence
- 1.4** QAP for pump and QAP for motors (if applicable).
- 1.5** GA, Datasheet, Curves etc. for drive motor (as applicable).
- 1.6** Operation and maintenance manual.
- 1.7** Lubrication arrangement drawings for external lubrication (if applicable).
- 1.8** PG test procedure as per clause 3.04.04 (if applicable).
- 1.9** Motor type test document (if applicable).
- 2.0** Within the stipulated time period as per vendor's drawings/ documents schedule as per NIT, the O&M Manual comprising of minimum following shall be submitted:
- Drawings of components & details as deemed necessary.
 - Instruction manual for erection, operation & maintenance.
 - Storage instruction.
- 3.0** Before dispatch of the equipment the bidder shall furnish the following.
- Material test certificates.
 - Shop test reports & certificates.
 - Fulfilment of packing instructions as indicated in Section-IA of this specification.
- 4.0** Distribution of drawings / documents for all projects:


The no. of copies of drawing/ documents to be submitted by the successful bidder, after the award of the contract shall be as per Section-IA or as specified in NIT.

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1.00.00	GENERAL INFORMATION		
1.01.0	The general guidelines as illustrated in the subsequent clauses of this section shall be applicable for vertical pumps to be procured under the scope of this package.		
1.02.0	It is not the intent to specify herein all the details of design and manufacture. However, the equipment shall conform in all respects to high standards of design, engineering and workmanship, and shall be capable of performing the required duties in a manner acceptable to Engineer/Owner who will interpret the meaning of drawings and specifications and shall be entitled to reject any component or material, which in his judgement is not in full accordance herewith.		
1.03.0	The omission of specific reference to any component/accessory necessary for the proper performance of Miscellaneous Pumps and drives shall not relieve the bidder of the responsibility of providing such facilities to complete the supply of equipment at quoted prices.		
1.04.0	BHEL's / Customer's representative shall be given full access to the shop in which the equipment are being manufactured or tested and all test records shall be made available to him.		
1.05.0	The equipment covered under this specification shall not be dispatched unless the same have been finally inspected, accepted and shipping release issued by BHEL/Customer.		
2.00.00	CODES AND STANDARDS		
2.01.00	In addition to the requirements spelt out elsewhere in the specification, the equipment to be provided under this section shall specifically conform to the following codes, standards, specifications and regulations, as applicable, including all the latest amendments subsequent to the year of publication as mentioned below.		
2.01.01	IS-1710/1989:	Vertical Turbine Pumps for Clear, Cold and Fresh Water.	
2.01.02	IS-5120/1977:	Technical requirements for Rotodynamic special purpose pumps.	
2.01.03	IS-5639/1970:	Pumps for handling chemicals & corrosive liquids.	
2.01.04	IS-5659/1970:	Pumps for process water.	
2.01.05	IS-6536/1972:	Pumps for handling volatile liquids.	
2.01.06	IS-9137/1978:	Code for acceptance tests for centrifugal, mixed flow and axial flow pumps- Class 'C'.	

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2.01.07	BS 5316	Acceptance tests for Centrifugal, mixed flow Part-I/1976 and axial flow pumps - Class 'C' Tests (ISO 2548/1973)		
2.01.08	BS 5316	Acceptance tests for Centrifugal, mixed flow Part-II/1977 and axial flow pumps - Class 'B' Tests (ISO 3555/1977)		
2.01.09	ANSI B 73.2M 1984	Vertical inline centrifugal pumps for chemical process		
2.01.10	API-610/1989:	Centrifugal pumps for general refinery services.		
2.01.11	HIS	Hydraulic Institute Standards, USA		
2.01.12	PTC 8.2/1965:	Power Test Codes - Centrifugal pumps.		
2.01.13	ASTM-1-165-55	Standard Methods for Liquid Penetration Inspection.		
2.02.00	In case of any contradiction with the above standards and annexure, the stipulations in the annexure shall prevail and shall be binding on the bidder.			
3.00.00	SCOPE OF SUPPLY & SERVICES:			
3.01.00	The miscellaneous pumps and drives scope shall be as specified in Data Sheet-A /Section IA.			
3.02.00	The Capacity, Head, Materials of construction and other particulars of pumps are detailed in Data Sheet-A of the specification.			
3.03.00	Accessories:			
	All the pumps under this specification shall be complete with following standard/special accessories.			
3.03.01	Standard accessories:			
	a)	LT Electric drives/motors (as applicable) with cable gland and lugs at motor end. (The bare HT drive motors and LT motors not in bidder's scope of supply, wherever required supplied as free issue by BHEL refer Cl. 5.08.00).		
	b)	Pump motor coupling along with coupling guard.		
	c)	Common base/sole plate for pumps and motor.		
	d)	Thrust block assembly (Thrust pads, attachments) for transferring the pump thrust to concrete thrust block (concrete thrust block in purchaser scope), as per clause 5.23.00.		

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<p>e) Thrust bearing temperature measurement devise to be provided.</p> <p>f) Self contained lubrication system along with all internal piping, valves, fittings, specialties etc. as required.</p> <p>g) Counter flanges for suction/ discharge nozzles along with fixing nuts, bolts and gaskets.</p> <p>h) Anchor bolts, nuts, seating steel works, shims etc. as necessary for mounting the pump-motor unit on Civil foundations.</p> <p>i) Suitable vent (with valves)/ lifting/ handling attachments for the pump/ motor/ accessories.</p> <p>j) Suitable drain connections with isolating valves as applicable.</p> <p>k) Supply of first fill of lubricants with toping requirements for one year of operation after commissioning and handing over of equipment.</p> <p>l) Set of “Special” Tools & Tackles for Pumps and motors, if any.</p> <p>m) Erection and commissioning spares, “on as required” basis.</p> <p>n) Bidder shall provide various drawings, data, calculations, test reports/ certificates, operation and maintenance manuals, As-built drawings, etc. as specified and as necessary.</p> <p>o) Mandatory spares as specified in respective Data Sheet-A of this section.</p>			
3.04.00	Services included in Bidder's Scope:		
3.04.01	The pumps shall be guaranteed to meet the performance requirements specified vide Data Sheet -A and also for trouble free operation after commissioning. Schedule of performance guarantees (Section-IIIA) duly filled and signed shall be furnished with the bid.		
3.04.02	The pumps erected by the purchaser shall be checked by the bidder for correctness of their installation, alignment, etc. at site prior to their commissioning.		
3.04.03	After commissioning of pumps at site, site performance test for Noise, vibration and parallel running of pumps of all pumps for each unit/project shall be conducted by pump vendor at project site to ensure that the pumps meet the specified requirements. Pump vendor shall bring necessary instruments for conductance of site performance test. If the site performance is found not meeting the requirements in any respect as specified, then the equipment shall be rectified or replaced by the vendor, without any commercial implication to BHEL.		

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Note: Applicability of conducting PG test at site by vendor as per above clause shall be applicable if indicated in Section-1A.

If conductance of PG test of pumps at site for Noise, vibration and parallel running of pumps of all pumps for each unit/project is not in bidders scope and same is conducted by BHEL/ customer. In such cases also, if the site performance is found not meeting the requirements in any respect as specified, then the equipment shall be rectified or replaced by the vendor, without any commercial implication to BHEL.

3.04.04 Performance Guarantees for pumps shall stand valid till the satisfactory completion of performance testing by BHEL and its acceptance by purchaser / customer.

3.05.00 Works excluded from Bidder's Scope:

- All HT motors and those LT Motors which are specifically excluded
- Civil foundation
- Suction/ discharge pipe works
- MCC/ Switchgear/Power supply
- Power and Control Cables, unless specifically specified in Electrical/ Systems portion of the specification.
- Erection of equipments.

4.00.00 BID EVALUATION CRITERIA & LIQUIDATED DAMAGES FOR SHORTFALL:

4.01.00 The bids received shall be evaluated for power consumption at inlet to the motors, in respect of pumps specified in Data Sheet-A (working pump only viz. not the standby), for the purpose of price comparisons as briefed below:


The bid evaluation shall be done at the rate as specified in Data Sheet A per one (1) KW Power consumption, per working pump as follows.


$$KW = \frac{Q \times H \times S}{P \times M \times 367.2}$$


Where Q = Rated capacity M³/hr
 H = Rated TDH, MWC
 P = Pump Efficiency
 M = Motor Efficiency.
 S = Specific Gravity of fluid handled


4.02.00 The efficiencies for pumps and motors for arriving at benchmark power for Bid Evaluation shall be as indicated in Data Sheet A for various pumps.


No advantage shall be given to the bidder for Aux. Power quoted lower than the Bench mark values calculated with KW calculation formula at Cl. 4.01.00 above, *considering the bid evaluation efficiencies for pump and motor as indicated in Data Sheet-A.* However the


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<p>bids shall be evaluated as above if the Aux. Power quoted are higher than Bench mark values.</p> <p>NOTE:</p> <p>1. Efficiencies for HT motors and LT motors not in bidder's scope, for bid evaluation purpose shall be taken based on the maximum value as furnished in Data Sheet A.</p> <p>2. During contract stage the Guaranteed power consumption of Pumps with BHEL supplied drives (HT/LT) for successful bidder shall be reworked by BHEL as below:</p> <p>Revised guarantee power consumption shall be as per KW calculation formula at Cl. 4.01.00 above, where P = pump efficiency guaranteed by bidder and M = motor efficiency as per approved datasheet of the supplied HT/LT motor.</p> <p>4.03.00 Liquidated damages for shortfall in Guaranteed KW</p> <p>The above guaranteed power consumption shall be demonstrated by the successful bidder during performance testing at works/ site.</p> <p>For pumps with BHEL supplied drives, the power consumption shall be compared with the reworked guarantee power consumption, defined as per note no. 2 of Cl. 4.02.00 above for the purpose of shortfall.</p> <p>The liquidated damages @ twice the bid evaluation rate as above per KW per working pump shall be levied in the event of failure of bidder to demonstrate the guaranteed power consumption.</p> <p>5.00.00 TECHNICAL REQUIREMENTS:</p> <p>5.01.00 The pumps shall meet the technical requirements of Section-I as well as Section-II. In the event of any contradiction of Section-II with Section-I, the Section-I will prevail.</p> <p>5.02.00 The pumps shall be Electric motor driven.</p> <p>5.03.00 The Pumps shall conform to HIS. It is bare minimum requirement, however, any other equivalent or stringent standard is also acceptable, if, all the requirements of HIS are also met.</p> <p>5.04.00 The type of Vertical pumps shall be as follows (if specifically not indicated otherwise in Data Sheet-A):</p> <p>a) Vertical turbine type pumps with 1500rpm. (if no. of stages ≤ 5) shall be preferred.</p> <p>b) If stages of vertical turbine pumps are more than 5, then sump pump construction shall be preferred with 1500 rpm speeds.</p> <p>c) For pumps with maximum speed 3000rpm, sump pump construction is also acceptable.</p> <p>5.05.00 No negative tolerance shall be permitted in rated capacity & TDH.</p>			


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5.06.00	No negative tolerance shall be permitted in efficiency at rated capacity.		
5.07.00	The shut off head of pumps shall be more than pump rated TDH and percentage variation may vary depending on the specific speed of the pump as under: i. 10-15% for pumps of specific speed up to 1000 US units, ii. 15-20% for pumps of specific speed in the range of 1000 to 2000 US units, iii. 20-40% for pumps of specific speed in the range of 2000 to 4000 US units, iv. Above 50% for pumps of specific speed in the range of 4000 to 7000 US units.		
5.08.00	All HT motors and those LT motors which are not in bidder's scope of supply: bare motors only, shall be supplied as free issue by BHEL through BHEL, based on ratings and TS (Torque - Speed) curve selected and furnished by the bidders along with their un-priced bid. The responsibility for satisfactory operation for combined performance of pumps & motors shall rest with the bidder only as if, the drive motors also have been supplied by the bidder. Couplings, base plate, foundation bolts, any other fittings, etc. as required shall be supplied by the bidders only. BHEL shall supply one number of each type of drive motors (where drive motor is not in bidder's scope of supply) for shop testing of pumps with job motors. All other motors shall be dispatched by BHEL directly to project sites.		
5.09.00	For all HT motor driven pumps, BHEL has envisaged vibration-monitoring system in their own scope. The bidder shall make provisions for mounting following on the pump/ pump shaft: <ul style="list-style-type: none">• Purchaser's probes in both DE/NDE bearings of pumps• Key slots on pump shaft and flat surface on bearing housing for mounting vibration measuring block with dimensions as specified in Data Sheet A.• Other components as finalized during detailing.• For mounting of above on the HT motors & specifically excluded LT motors, same shall be taken care by BHEL.		
5.10.00	The pumps shall be capable of developing the required total head at rated capacity for continuous operation. The pumps shall operate satisfactorily at any point on the Q-H characteristic curve over a range of 0% to 130% capacity and shall be suitable for continuous operation between 30% to 130% capacity.		
5.11.00	Selection of the pumps shall be such that the design point shall be met even with negative manufacturing tolerance.		
5.12.00	The total head capacity curve shall be continuously rising towards the shut off, the pumps shall preferably be non-overloading type and stable.		
5.13.00	The pumps shall be capable of running over the entire range of submergence/ NPSH requirement conditions required without any noise, vibration or cavitations.		


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<p>The prevailing suction pressures for various pumps are indicated in Data Sheet-A for suitable mechanical design of pumps.</p>			
5.14.00	<p>The pumps shall be of stiff shaft design. The minimum internal clearances should be sufficiently more than the max. static deflection of the shaft. Shaft size selected must take into consideration the critical speed as specified in API-610.</p>		
5.15.00	<p>Pumps and motors shall run smooth without undue noise and vibration.</p> <p>The vibration shall be within vibration norms for testing as per American National Standard for 'Rotodynamics Pump' for Vibration Measurement and allowable values, Doc. ANSI/ HIS 9.6.4-2009. The applicable vibration limits for each pump, shall be indicated in the Technical Data sheet to be furnished by the successful bidder after award of LOI/ PO.</p> <p>The noise level shall be limited to 85 dB at distance of 1.0M.</p>		
5.16.00	<p>Pumps of a particular category shall be identical and shall be suitable for parallel operation with equal load division. Components of identical pumps shall be interchangeable.</p>		
5.17.00	<p>After installation, the guaranteed values of noise, vibration and parallel operation of pumps shall be tested and verified. If the site performance is found not meeting the requirements in any respect as specified, then the equipment shall be rectified or replaced by the vendor, at his own cost.</p>		
5.18.00	<p>High reliability of the pumps is an essential requirement and therefore it gets weightage over its efficiency. It is therefore essential that the bidder choose a standard proven model from the range of pumps manufactured.</p>		
5.19.00	<p>The offered pumps shall be of proven design meeting the experience-qualifying requirement of their operation at two sites for a minimum period of one year or as specified in technical PQR. Any deviation to this criterion shall be suitably highlighted in the deviations schedule.</p>		
5.20.00	<p>The bearings shall be self-water lubricated, no external water supply shall be available. The cooling/ lubrication water for bearings, etc. shall be tapped from the pump discharge and supplied thru' bidder's integral pipe work.</p>		
5.21.00	<p><u>If water handled by pump is sea water/ dirty/ not suitable for lubrication/ cooling:</u></p>		
5.21.01	<p>The bearing lubrication/cooling may be specifically reviewed by bidders for the suitability with water analysis enclosed with Data Sheet-A of this section.</p> <p>These pumps shall necessarily be provided with Thordan type line shaft bearings even if the other type of bearings are claimed suitable by the manufacturers.</p>		


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<p>The bidder's shall satisfactorily establish the adequacy of self water lubrication if provided, for similar rating pumps installed for the duty condition in the event of order. In absence of adequate documentary evidence to the satisfaction level of BHEL, the bidder shall provide force water lubrication as per clause 5.21.02 below without any cost implication.</p>			
5.21.02	<p>In the event, the forced water lubrication is envisaged by the bidder, the following minimum requirements shall be complied with further details subject to Purchaser's approval during detailed engineering after the award of order.</p> <p>One set of common water lubrication system shall be provided separately for each type of pumps. The lubricating system shall provide continuous lubrication to all the pumps during operation and the minimum requirements shall be as follows:</p> <ul style="list-style-type: none">• 2X100 % duty self cleaning strainers of suitable size and mesh opening shall be installed on the common pump discharge and outlet shall be led to 1 no. 6 hrs. storage or min. 10 M3 capacity tank of carbon steel MOC, to be placed on roof of pump house .• 2X100 % duty horizontal centrifugal lubricating pumps with TDH more than the shut off head of the subject pumps shall be provided. The capacity of each pump shall be sufficient to lubricate all of the subject pumps including 10% margin on capacity and head to suit requirement with 10 % margin with head.• These horizontal pumps shall take suction from the overhead Sintex tank as explained above.• Associated piping, fittings, Tank inlet motor operated valve, lubricating pumps suction & discharge isolating valves, motorised/ solenoid valves (as per purchaser's approval), lubricating pumps discharge check valves and lubricating pipe isolating valve at inlet to each of subject pump, etc. as required shall be provided.• Instrumentation – Level Gauge, high level & low level switches for tank, pressure gauges at suction & discharge of each lubricating water pumps, low pressure switch on lubricating pipe at inlet to each of subject pump for subject pump start interlock, pressure switch on lubricating pipe at common discharge of subject pump for start up of stand by pump etc., as required subject to purchaser's approval shall be provided.		


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<ul style="list-style-type: none">Bidder shall supply any other equipment/ instrument required for proper functioning of the lubricating system, as deemed necessary during contract without any price implication to BHEL.Bidder shall also provide a relay based local control panel for proper functioning of the above system. The system shall be suitable for fully automatic operation as per approved write-up during detailed stage.Subject pumps shall be provided with shaft enclosing tube in the event above Lubrication system is envisaged by bidder. MOC for shaft enclosing tube shall be equivalent/ superior to MOC for column pipe for subject pump. <p>The complete forced water lubrication as above – if applicable, shall be in bidder's scope. Bidder to inform in schedule of deviation at bid submission stage, if fresh water is required for forced water lubrication system.</p>			
5.22.00	For Vertical pumps no thrust block is being provided except for pumps of projects, specified in Sec-IA of this specification. Bidder to design the pump foundation system (base plate/ sole plate, discharge head, foundation bolts etc.) capable of transferring the pump thrust to the concrete pump foundation itself.		
5.23.00	If specified in Sec-IA of specification, thrust block assembly (Thrust pads, attachments) for transferring the pump thrust to concrete thrust block (concrete thrust block in purchaser scope) to be provided by bidder.		
6.00.00	MANDATORY SPARES:		
6.01.00	Bidder to provide the Mandatory spares listed vide Data Sheet-A. Unit price of mandatory spares shall be furnished in price Schedule.		
6.02.00	Bidder shall include the cost of Mandatory Spares, unless specified otherwise in Sec-IA of the specification or NIT.		
7.00.00	OTHER REQUIREMENTS:		
7.01.00	The quality of water handled by various pumps shall be as per Data Sheet-A.		
7.02.00	The materials of construction for various components specified are the minimum requirements and materials of construction for other components not specified shall be similarly selected by the bidder for the intended duty.		


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7.03.00	The makes of various bought out items of bidder (i.e. motor, bearings etc.) shall be subject to purchaser’s approval in the event of order.		
7.04.00	Painting for Pumps		
	a) The surface of SS, Gun metal, brass, bronze and non-metallic component shall not be applied with any painting.		
	b) The Steel surface to be applied with painting shall be thoroughly cleaned before applying painting by brushing, shop blasting etc. as per the agreed procedure.		
	c) For all the steel surfaces inside the (indoor installation) building, a coat of red oxide primes of min. thickness DFT of 50 microns followed up with under coat of Synthetic Enamel paint of min. thickness DFT of 50 microns shall be applied. The top coat shall consist of two coats each of min. thickness DFT of 50 microns of synthetic enamel paint and thus total DFT shall be min. 200 microns.		
	d) For all the steel surfaces exposed to (outdoor installation) atmosphere, a coat of chlorinated rubber based zinc phosphate primer of min. thickness DFT of 50 microns followed up with under coat of chlorinated rubber paint of min. thickness DFT of 50 microns shall be applied. Then, intermediate coat consisting of one coat of chlorinated rubber based paint pigmented with Titanium di-oxide with min. thickness DFT of 50 microns and top coat shall consist of two coats each of min. thickness DFT of 50 microns of chlorinated rubber paint shall be provided. Total DFT of paint system shall be min. 200 microns.		
7.05.00	It is mandatory for the bidder to submit along with the bid, the deviations if any – whether major or minor in the schedule of deviations only. In the absence of deviations listed in the “Schedule of deviations, the offer shall be deemed to be full conformity with the specification, “not-withstanding” anything else stated elsewhere in bidder’s offer. The implied/indirect deviations shall not be binding on the purchaser.		
8.00.00	PERFORMANCE REQUIREMENTS		
8.01.00	Performance requirements for the pumps shall be as guided in Data sheet - A enclosed with Section-I.		
8.02.00	Pump(s) shall preferably be designed to have the best efficiency at flow within ± 10% of the specified duty point flow. The pumps shall be suitable for continuous operation at any point within the “Range of Operation” as stipulated in the Data Sheet - A attached with Section-I.		

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8.03.00	<p>Pump(s) shall preferably have a continuously rising head-capacity characteristics from the specified duty point towards shut-off point, the maximum being at shut-off to enable parallel operation.</p> <p>Under all circumstances, the ‘range of operation’ of the pumps shall exclude any unstable operating zone of the head-capacity curve.</p>		
8.04.00	<p>Wherever specified in the Data Sheet - A, pumps of each category shall be suitable for parallel operation. The head vs. capacity, the BHP vs. capacity characteristics etc. shall be identical to ensure equal load sharing and trouble-free operation of any pump when the other pump(s) working in parallel with it trip.</p>		
8.05.00	<p>The pump set along with drive motor shall run smooth without undue noise and vibration. Acceptable vibration limits shall be guided by the HIS of USA. Refer clause 5.15.00 above for permissible limits.</p>		
9.00.00	<p>DESIGN AND CONSTRUCTION</p> <p>Pumps shall be of vertical shaft, complete with bowl, column pipe, discharge head and base plate with all accessories. General design and constructional features of the pumps shall be as follows:</p>		
9.01.00	<p>Bowl Assembly</p>		
9.01.01	<p>This will be either a single or multi-stage centrifugal, mixed flow or axial flow type with discharge co-axial with shaft. Type of impeller shall be chosen on the basis of the pump specific speed and the characteristics of handling fluid.</p>		
9.01.02	<p>Pumps (s) shall have provision for adjustment of impellers in vertical direction from an accessible location, preferably at the housing (where separate thrust bearing for the pump is provided). The adjustment mechanism must take into consideration the extension of the line shaft due to hydraulic down thrust, weight of the shaft and impeller.</p>		
9.02.00	<p>Discharge Head</p>		
9.02.01	<p>Pump (s) shall have above/below floor discharge, as specified in the Data Sheet-A, attached to this section.</p>		
9.03.00	<p>Column pipe</p>		
9.03.01	<p>Column pipe shall be flanged and of bolted connection. Column pipes shall be designed for full internal vacuum.</p>		
9.03.02	<p>In case of multi-piece column pipe and shaft assembly, the design shall permit raising/lowering of the pump assembly piece by piece without any difficulty. Any fixtures, clamps, etc. necessary for such purpose shall be supplied by the Bidder under this section.</p>		

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<p>The bidder shall also submit a write-up describing clearly the procedure of handling the pump.</p>			
9.04.00	Impeller shaft, line shaft and head shaft		
9.04.01	Shaft size shall be selected on the basis of maximum torque to be applied on the pump shaft.		
	The critical speed shall be at least 30% higher than the rated speed.		
9.04.02	Impeller shaft shall be guided by bearings provided in each bowl or above and below the impeller shaft assembly. The butting faces of the shaft shall be machined square to the assembly and the shaft shall chamfered at the edges.		
9.04.03	Line shaft may be single or multiple pieces as required. In case of multiple pieces, line shaft shall be coupled as per the standard practice of the manufacture. For screwed coupling, directions shall permit tightening of the joint during pump operation.		
9.04.04	Replaceable shaft sleeves shall be furnished at applicable location, particularly under stuffing box and at other locations, as considered necessary.		
9.05.00	Shaft enclosing tube		
	Shaft enclosing tube shall be required, unless self lubricated (and cooled) type of shaft bearings are asked for. Length of the shaft enclosing tube shall be in conformity with the shaft piece lengths.		
9.06.00	Seal rings		
	Replaceable seal/wear rings both on impeller and on casing shall be provided in case it is asked for in this specification.		
9.07.00	Bearings		
9.07.01	Shaft bearings		
	Adequate number of properly designed bearings shall be provided for smooth and trouble free operation of the pump. Number of bearings shall consider the number of shaft pieces used and the critical speed of the shaft. Bearings shall be either lubricated by external clear water/oil/grease or self lubricated as specified in the Data Sheet-A of this section.		
	In case of external water/oil lubrication, complete lubrication arrangement shall be furnished with the pump. In case of forced water lubrication of the shaft bearings, the system and other accessories shall be in the scope of supply of Bidder as per clause 5.21.02.		
9.07.02	Thrust Bearing		

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<p>Thrust bearing of adequate size and capacity shall be provided to take the vertical thrust of the impeller arising out of the pump operation and dead weight of the rotating components. Life of the thrust bearing shall be guided by the design standard of the pump. Thrust bearing shall be capable of running continuously at maximum load.</p> <p>Thrust bearing shall be either grease or oil lubricated. Lubrication arrangement shall be such that the lubricant does not contaminate the handling fluid. The arrangement shall also be adequate to protect the bearing, while the pump coast down to stop in case of power failure of the station. Pre-lubrication of the thrust bearing, if recommended by the pump manufacturer, shall be taken care of in designing the lubrication system.</p> <p>For thrust bearing, provision for temperature measurement shall be provided.</p> <p>Cooling of the thrust bearing, if necessary, shall be done by the handling fluid/external water, depending on the fluid handled.</p> <p>Location of the thrust bearing may be at the pump body or at the driver, or at both depending on the requirement indicated in this specifications or as per the recommendation of the pump manufacturer (and approved by Purchaser).</p>			
9.07.03	Bearings of reputed makes are to be provided, same shall be indicated in Technical Data sheet to be furnished by the successful bidder after award of LOI/ PO, subject to acceptance of BHEL/ end customer, without any price implication to BHEL.		
9.08.00	Reverse Rotation		
9.08.01	If indicated at Section-IA of the specification, the pump impeller and other rotating components shall be designed for reverse rotation, when subject to reverse flow at rated pump discharge head.		
9.09.00	Drive Unit		
9.09.01	The pumps shall be driven by electric motor directly coupled as specified in the Data Sheet-A of this section. A heavy duty coupling along with coupling guard shall be provided between the pump and drive unit.		
9.09.02	Unless otherwise specified in Data Sheet-A of this section, drive unit power rating shall be the maximum of the following requirements.		
	a) 16% margin over the pump shaft input power at the rated duty point.		
	b) 10% margin over the maximum pump shaft input power required within the ‘Range of Operation’.		
	c) Pump shaft input power required considering the overloading of the pump assuming		

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single pump operation in the event of tripping of one or more of the pumps operating in parallel.			
9.09.03	All Vertical pump motors shall be designed/capable of withstanding max. run away speed during reverse flow through pump.		
10.00.00	INSPECTION AND TESTING		
10.01.00	The Quality Plans enclosed in the specification are for bidder's guidance only. The bidder shall comply with these and other minimum requirements specified in the specification and shall furnish his own quality plan in the event of order based on the guidance given as above, for approval by BHEL/Customer.		
10.02.00	The Bidder shall carry out the following specific tests inspections to ensure that the equipment furnished lies in strict conformance with the specification and also in accordance with applicable codes/standards and good engineering practice.		
a) Identification and Testing			
i) All materials used for pump construction shall be of tested quality. Material shall be tested as per the relevant standard and test certificates shall be made available to the Owner. Material identification and testing shall include, but shall not be limited to the following components:			
<ul style="list-style-type: none">• Bowls and suction bells• Impeller and wearing rings• Shafts and shaft sleeves• Couplings• Bearings• Column pipes• Discharge heads• Bowl Assembly			
ii) 100% PMI (Process Material Identification) inspection for material grade of pump casing, shaft and impeller shall be done by vendor & certification shall be submitted for review of BHEL. Further BHEL reserves the right to conduct random & independent PMI inspection on pump casing, shaft and impeller to ascertain the grade of material during inspection at vendor works.			
iii) Tests for each pump included under this section shall include but not be limited to the following:			
<ul style="list-style-type: none">- The entire surface of the impeller / casing / diffuser castings shall be subjected to Dye Penetration Test as per ASTM Specification no.:1-165-65.			

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- Shaft coupling & other active components shall be subjected to Dye Penetration and Ultrasonic Tests.
- Wearing rings, shaft sleeves shall be subjected to Dye Penetration Test.
- Fabricated components of pumps shall be subjected to Dye Penetration test on weld.
- Verification of material, witnessing of pouring, casting and inspection of finished fabricated/castings.
- Inspection of finished castings for impeller and verification of materials.
- Inspection of pump shaft and verification of material.
- Witnessing of NDT/review of NDT reports.
- Static balancing test for impeller and dynamic balancing of complete rotating parts as per ISO- 1940 to grade 6.3 or better.
- Complete Inspection of assembled pump.

b) Hydraulic Testing


Bowls/ Suction bells, Columns pipe, Discharge head and any other applicable pressure parts shall be hydrostatically tested at maximum of the following:


- i. 2 times the TDH (Total Dynamic Head) at rated capacity (or)
- ii. 1.5 times the shut-off pressure
- iii. System Design pressure indicated in Data Sheet-A of Section-I.

The HT pressure shall be maintained for a period of not less than 30 minutes. During testing there should not be any pressure drop & leakage.

c) Performance Test at Shop

- i) Each pump shall have to be tested to determine the performance curves of the pumps. These tests are to be conducted in presence of Owner's representative as per the requirements of the Standards of Hydraulic Institute of USA (ASME-Power Test Code PTC 8.2/BS-599) or any other equivalent standard.
- ii) Performance tests are to be conducted to cover the entire range of operation of the pumps at rated speed. These shall be carried out to span 130% of rated capacity up to pump shut-off condition. A minimum of five combinations of head and capacity are to be achieved during testing to establish the performance curves, including the design capacity point, shut-off point and the two extremities of the range of operation as specified in the annexure. After

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<p>completion of performance test, all pumps shall be stripped down for inspection of internals.</p> <p>iii) Tests shall be conducted with actual drive motors being furnished.</p> <p>iv) Minimum submergence/ NPSH required tests are to be conducted for each type at 3% head drop conditions, if specified in the pump approved QP.</p> <p>v) All rotating components of the pumps shall be subjected to static and dynamic balancing tests. The assembled rotor will be subjected to dynamic balancing tests.</p> <p>vi) Mechanical run test shall be carried out on all pumps to determine the vibration levels, noise levels etc. This test shall be conducted at site also. However, test value at site shall be used for the acceptance of the equipment.</p>			
10.03.00	Inspection of Mandatory/ Recommended spares shall be in line with approved QP for main supply.		
11.00.00	DRAWINGS/ DOCUMENTS DISTRIBUTION SCHEDULE		
11.01.00	After award of LOI, the successful bidder shall submit drawings/documents as per Data Sheet-C.		
11.02.00	The no. of drawings/documents to be submitted shall be as per Data Sheet-C.		
12.00.00	The various Sections-I's & II's along with Data Sheets attached in this specification together with the specification for Miscellaneous Pumps shall be complied with by the bidders.		
13.00.00	Bidder to submit all drawing/ documents in soft as well as hard copy in the event of order as per schedule indicated in section-IA.		
	<p>Within one (1) week of receipt of BHEL comments a technical representative from Bidder's works shall come for meeting with BHEL along with revised documents to resolve all issues and incorporate all comments in the soft copy for further submission to customer.</p> <p>Further on receipt of customer's comments on the documents a technical representative from Bidder's works shall come for meeting with Customer to resolve all issues and incorporate all comments in the soft copy and further resubmission of same to Customer. The representative shall be available here till category I approval of all the drawings and documents.</p>		
14.00.00	Guarantee for all pumps shall at least remain valid for 18 months from the Unit commissioning date or as specified in NIT.		


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15.00.00 The following documents only shall be furnished by the bidder with his offer:

- a) Compliance certificate duly signed and stamped (enclosed at Section-IIIB).
- b) GA drawings of pumps and motors with following: (shall be only for reference purpose, same shall not be reviewed/commented by purchaser at this stage and shall be subject to approval only during contract).
 - Civil static & dynamic loads.
 - Foundation details.
 - Minimum Submergence required.
 - Clearances - Side, Back & Bottom
 - Min. Recommended crane capacity
- c) Guarantee Schedule duly signed and stamped (enclosed at Section-IIIA).
- d) Technical deviation schedule (if reqd.) (enclosed at Section-IIIC).
- e) Data for drive Motor (HT/LT- which is not in bidder's scope of supply - as applicable):
Load torque speed curves of the pumps, selected motor rating, rpm, GD^2 of driven equipment.
- f) Unpriced copy of the price bid shall be furnished along with the technical bid.

Apart from above no other Drgs./Docs./Data sheets etc. are required to be submitted at bid stage and even if furnished shall not be taken cognizance of.

In case of any deviation from this technical specification, the same shall be indicated in the schedule of deviations as per Section-IIIC or NIT. In the absence of duly filled schedules it will be assumed that the bid strictly conforms to the specification.


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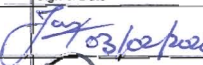
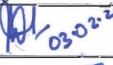


DATA SHEET – C

Drawings / documents distribution schedule to be followed by successful Bidder:


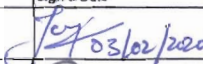
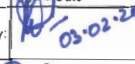

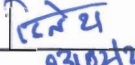
- 1.0** Drawings/documents submission schedule, shall be as per Section-IA.
The successful bidder shall submit at least following drawings/ documents:
- 1.1** Fully dimensioned outline general arrangement drawings of the pump and motor assembly. This drawing should include foundation base plate/sole plate details as applicable, civil foundation, anchor bolt details, loading data (Static and Dynamic), points of connections of external piping, cables and mounting of devices furnished by the supplier and details for Gap between Coupling Shafts, Float & details for axial/radial tolerance allowed etc. which are required for erecting agency during erection of pump.
- 1.2** Cross sectional drawing of the equipment showing the details of assembly of components and their material of construction with standard applicable codes.
- 1.3** Technical datasheet as per Datasheet-B (Section-IIID) including characteristic curves of pumps showing the following:
 - a) Flow Vs Head
 - b) Flow Vs Power
 - c) Flow Vs Efficiency
 - d) Flow Vs NPSHR/ minimum submergence
- 1.4** QAP for pump and QAP for motors (if applicable).
- 1.5** GA, Datasheet, Curves etc. for drive motor (as applicable).
- 1.6** Operation and maintenance manual.
- 1.7** Lubrication arrangement drawings for external lubrication (if applicable).
- 1.8** PG test procedure as per clause 3.04.03 (if applicable).
- 1.9** Motor type test document (if applicable).
- 1.10** Test Procedure for Sump Model Study (if applicable).
- 2.0** Within the stipulated time period as per vendor's drawings/ documents schedule as per NIT, the O&M Manual comprising of minimum following shall be submitted:
 - a) Drawings of components & details as deemed necessary.
 - b) Instruction manual for erection, operation & maintenance.
 - c) Storage instruction.
- 3.0** Before dispatch of the equipment the bidder shall furnish the following.
 - a) Material test certificates.
 - b) Shop test reports & certificates.
 - c) Fulfilment of packing instructions as indicated in Section-IA of this specification.
- 4.0** Distribution of drawings / documents for all projects:


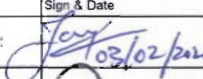
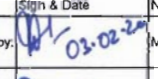
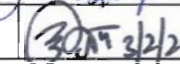
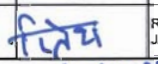
The no. of copies of drawing/ documents to be submitted by the successful bidder, after the award of the contract shall be as per Section-IA or as specified in NIT.


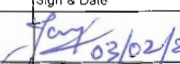
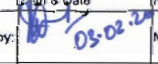
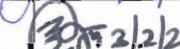

		MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS			QUALITY PLAN				SPEC NO.: PE-TS-XXX-100-N001		DATE	
					CUSTOMER:				QP NO.: PE-QP-999-100-N004		DATE	
					PROJECT:				PO NO.:		DATE	
					ITEM: MISC. PUMPS (HORIZONTAL/VERTICAL)		SYSTEM: CW/ACW/DMCW/PLANT/COMMON		SECTION:		SHEET 1 OF 6	
S. No.	COMPONENT & OPERATION	CHARACTERISTIC	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY **		REMARKS
1	2	3	4	5	6	7	8	9	10	11	12	13
1	RAW MATERIALS											
1.1	CASINGS (INCLUDING BOWLS, DIFFUSERS, STAGE BODIES, DISCH HEAD (IF CAST)), ETC. - (AS APPLICABLE) AND IMPELLER	MECHANICAL AND CHEMICAL PROPS	CR	MECHANICAL AND CHEM. ANALYSIS	ONE/HEAT/BATCH	APPROVED CS DRAWING/DATA SHEET	RELEVANT MATERIAL SPECN.	LAB REPORT/ MTC	✓	P	V	V
1.2	STUFFING BOX, SUCTION BELL, WEARING RINGS, NECK RINGS, SHAFT SLEEVES	MECHANICAL AND CHEMICAL PROPS	MA	MECHANICAL AND CHEM. ANALYSIS	ONE/HEAT/BATCH	APPROVED CS DRAWING/DATA SHEET	RELEVANT MATERIAL SPECN.	LAB REPORT/ MTC	✓	P	V	V
		HARDNESS DIFFERENCE BETWEEN CASING / IMPELLER AND WEARING RING	MA	LAB. TEST	100%	APPROVED CS DRAWING/DATA SHEET	50 BHN MIN.	LAB. REPORT	✓	P	V	V
1.3	BARS/FORGINGS FOR SHAFTS, LINE SHAFTS	1. PHYSICAL & CHEMICAL PROPS	CR	1. MECHANICAL & CHEMICAL ANALYSIS.	1/CAST OR 1/BARS	APPROVED CS DRAWING/DATA SHEET	RELEVANT MATERIAL SPECN.	MILL T.C. OR LAB. REPORT	✓	P	V	V
		2. DIMENSIONS	CR	2. MEASUREMENT	100%	MFR. DRAWING	MFR. DRAWING	INSP. REPORT	✓	P	V	V
		3. INTERNAL DEFECTS FOR 40MM & ABOVE DIA SHAFTS.	CR	3. ULTRA SONIC TEST	100%	ASTM A388 BACK WALL ECHO 100%	DEFECT ECHO MAX 20% OF B.W.E. LOSS OF BACK WALL ECHO 20% MAX	NDT CERTIFICATE	✓	P	V	V
1.4	STRESS RELIEVING/ HEAT TREATMENT OF CASTING OF ALL ABOVE (IF APPLICABLE) / SOLUTION ANNEALING OF SS CASTING	1. VERIFICATION OF HT CHART	MA	VERIFICATION OF SR/HT CHART	ALL BATCHES	RELEVANT MATERIAL SPECN.	RELEVANT MATERIAL SPECN.	CORRELATED SR/HT CHARTS	✓	P	V	V
		2. IGC TEST FOR SS CASTING	MA	LAB. TEST	ONE SAMPLE/ HT BATCH	ASTM A 262	ASTM A 262 Gr A	LAB. REPORT	✓	P	V	V
1.5	SHAFT ENCLOSING TUBES, COLUMN PIPES & DISCHARGE ELBOW	1. MECHANICAL & CHEMICAL PROPS. 2. DIMENSIONS. 3. SURFACE FINISH	MA	1. MECH & CHEM TEST 2. MEASUREMENT 3. VISUAL EXAM	1/BATCH 100% 100%	APPROVED GA DRG/DATA SHEET	RELEVANT MATERIAL SPECN./MFG./ APPROVED DOCS	MFR T.C OR LAB. REPORT	✓	P	V	V
BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL				
ENGINEERING				QUALITY				Sign & Date		Doc No:		
Sign & Date		Name		Sign & Date		Name		Sign & Date		Name		Seal
Prepared by: 03/02/2020		TANUJ MATTA		Checked by: 03/02/2020		MOHIT KUMAR		Seal		Reviewed by:		
Reviewed by: 03/03/2020		AJAY JAIN		Reviewed by: 03/04/2020		RITESH KUMAR JAISWAL		Approved by:				


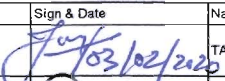
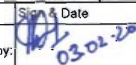
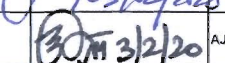
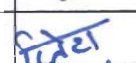
	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS			QUALITY PLAN				SPEC NO.: PE-TS-XXX-100-N001		DATE			
				CUSTOMER				QP NO.: PE-QP-999-100-N004		DATE			
				PROJECT :				PO NO.:		DATE			
				ITEM: MISC PUMPS (HORIZONTAL/VERTICAL)		SYSTEM CW/ACW/DMCW/PLANT/ COMMON		SECTION:		SHEET 2 OF 6			
S. No.	COMPONENT & OPERATION	CHARACTERISTIC	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS	
1	2	3	4	5	6	7	8	9	10	11	12		
					M / C/N								
1.6	PLATE FLANGE, C/FLANGE	1. MECHANICAL & CHEMICAL PROS. 2. DIMENSIONS. 3. SURFACE FINISH	MA	1. MECH & CHEM TEST 2. MEASUREMENT 3. VISUAL EXAM	1/CAST 100% 100%	APPROVED GA DRG./DATA SHEET	RELEVANT MATERIAL SPECN./ MFR. DRG./ APPROVED DOC	MILL TC/ LAB REPORT	✓	P	V	V	CORRELATION REQ. FOR MAT. OTHER THAN IS 2062
1.7	SUCTION STRAINER (IF APPLICABLE)	MECHANICAL & CHEMICAL PROS.	MI	MECH. & CHEMICAL TEST	1/HEAT	APPROVED GA DRG./DATA SHEET	RELEVANT MATERIAL SPECN./ MFR. DRG./ APPROVED DOC	MILL TC/ LAB REPORT	✓	P	V	V	
1.8	MECHANICAL SEAL (IF APPLICABLE)	TYPE, SIZE, MFRS, NO., MAKE	MA	VISUAL EXAM	100%	APPROVED DATASHEET / GA MECH. SEAL	APPROVED DATASHEET		✓	P	V	V	COMPLIANCE TC FOR APPROVED MAKE
1.9	PUMP BEARINGS	TYPE, SIZE, MFRS, NO., MAKE	MA	VISUAL EXAM	100%	APPROVED DATASHEET	APPROVED DATASHEET		✓	P	V	V	COMPLIANCE TC FOR APPROVED MAKE
2.0 IN PROCESS CONTROL													
2.1	ALL COMPONENTS UNDER 1.00 ABOVE	VISUAL DEFECTS, DIMENSIONS	MA	VISUAL EXAM, MEASUREMENT	100%	MFG. DRAWING	MFG. DRAWING	COMPLIANCE TC	✓	P	V	V	
2.2	IMPELLER	CLEANING AND DEBURRING	MA	VISUAL	100%	MFG. DRAWING	MFG. DRAWING		✓	P	V	V	
	IMPELLER	DYNAMIC BALANCING	CR	DYNAMIC BALANCING	100%	ISO 1940	ISO 1940 Gr 6.3	BALANCING CERTIFICATE	✓	P	W	V	WTNESSING ONLY FOR SIZE GREATER THAN 10KW
2.3	IMPELLER-ALL ACCESSIBLE SURFACES, DIFFUSERS	DP TEST	MA	DP TEST ON M/CED AREA	100%	APPENDIX 8 OF ASME SEC. VIII DIV. 1		NDT CERTIFICATE	✓	P	W	V	
2.4	WEARING RING, SHAFT SLEEVES, CASING	DP TEST	MA	DP TEST ON M/CED AREA	100%	APPENDIX 8 OF ASME SEC. VIII DIV. 1		NDT CERTIFICATE	✓	P	V	V	
2.5	SHAFT	DP TEST	MA	DP TEST ON M/CED AREA	100%	ASTM E 165	NO RELEVANT INDICATION ALLOWED	NDT CERTIFICATE	✓	P	W	V	
2.6	CASINGS/ BOWLS, STAGE BODIES, DISCHARGE HEAD (IF CAST), SUCTION HOUSING, COLUMN PIPE DISCHARGE PIPE ETC	LEAK TIGHTNESS	CR	VISUAL	100%	TECHNICAL DATA SHEET AND NOTE 2	NO LEAKAGE FOR TEST DURATION OF 30 MIN.	HT CERTIFICATE	✓	P	W	V	HAMMERING OF CASTINGS WITH WOODEN/ RUBBER Mallet BEFORE HYDRO TEST
BHEL						BIDDER SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL					
ENGINEERING			QUALITY			Sign & Date		Doc No:		Sign & Date			Seal
Prepared by: 			Name: TANUJ MATTA			Checked by: 		Name: MOHIT KUMAR		Reviewed by:			
Reviewed by: 			Name: AJAY JAIN			Reviewed by: 		Name: RITESH KUMAR JAISWAL		Approved by:			

03/04/2020

MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS				QUALITY PLAN				SPEC NO.: PE-TS-XXX-100-N001		DATE			
				CUSTOMER:				QP NO.: PE-QP-999-100-N001		DATE			
				PROJECT				PO NO.:		DATE			
				ITEM: MISC. PUMPS (HORIZONTAL/VERTICAL)		SYSTEM: CW/ACW/DMCW/PLANT/ COMMON		SECTION:		SHEET 3 OF 6			
S. No.	COMPONENT & OPERATION	CHARACTERISTIC	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY **				REMARKS
1	2	3	4	5	6	7	8	9	10	11	12	13	
					M	C/N							
2.7	FABRICATED COMPONENTS												
2.7.1	WELDING PROCEDURE SPECIFICATION	CORRECTNESS	MA	EXAM.	100%	ASME SEC.IX	ASME SEC.IX	QW 482 OF ASME SEC.IX	✓	P	V	V	WELDING PROCEDURE APPROVAL BY BHEL, ALT. 3RD PARTY (LLYODS,BVQI OR EQ.) IS ACCEPTABLE.
2.7.2	WELDING PROCEDURE QUALIFICATION RECORD	WELD SOUNDNESS	MA	VISUAL,PHYS. TESTS RT (AS APPLICABLE)	100%	ASME SEC.IX	ASME SEC.IX	QW 483 OF ASME SEC.IX	✓	P	V	V	
2.7.3	WELDER PERFORMANCE QUALIFICATION	WELD SOUNDNESS	MA	VISUAL,PHYS. TESTS RT (AS APPLICABLE)	100%	ASME SEC.IX	ASME SEC.IX	QW 484 OF ASME SEC.IX	✓	P	V	V	
2.7.4	WELD FIT-UPS	DIMENSION & ALIGNMENT	MA	MEAS:VISUAL EXAM	100%	WPS, MFG. DRAWING	WPS, MFG. DRAWING	IR/LOGBOOK	✓	P	V	V	
2.7.5	ROOT RUNS	SURFACE DEFECTS	MA	PENETRANT TEST	100%	ASTM E 165	NO SURFACE DEFECT	IR/LOGBOOK	✓	P	V	V	
2.7.6	WELDMENTS	SURFACE DEFECTS	MA	PENETRANT TEST	100%	ASTM E 165	ASME-VIII, DIV I	INSPN REPORT	✓	P	W	V	WITNESS BY BHEL & VERIFICATION BY CUSTOMER
BHEL						BIDDER/SUPPLIER			FOR CUSTOMER REVIEW & APPROVAL				
ENGINEERING				QUALITY		Sign & Date		Doc No:		Sign & Date			
Sign & Date		Name		Sign & Date		Name		Sign & Date		Name		Seal	
Prepared by: 		TANUJ MATT		Checked by: 		MOHIT KUMAR		Reviewed by:					
Reviewed by: 		AJAY JAIN		Reviewed by: 		RITESH KUMAR JAISWAL		Approved by:					

MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS				QUALITY PLAN				SPEC NO.: PE-TS-XXX-100-N001		DATE			
				CUSTOMER:				QP NO.: PE-QP-999-100-N004		DATE			
				PROJECT :				PO NO :		DATE			
				ITEM: MISC. PUMPS (HORIZONTAL/VERTICAL)		SYSTEM: CW/ACW/DMCW/PLANT/ COMMON		SECTION		SHEET 4 OF 6			
S. No.	COMPONENT & OPERATION	CHARACTERISTIC	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY **		REMARKS	
1	2	3	4	5	6	7	8	9	* D	10		11	
					M / C/N								
2.7.7	BUTT WELDS	INTERNAL DEFECT	MA	UT/RT	100%	ASME SEC. V	ASME-VIII, DIV I	IR	✓	P	W	V	WITNESSING OF U.T
2.7.8	DICHARGE HEAD, COLUMN PIPE, DISCHARGE PIPE, ETC.	1. LEAK TIGHTNESS 2. DIMENSION	CR	1. HYDROTEST 2. MEASUREMENT	100%	APPROVED DATA SHEET/ APPROVED OP APPROVED GA- CS DRG/MFR DRG.	1. NO LEAKAGE 2. MFR. DRAWING	IR	✓	P	W	V	
3.0	SUB-ASSEMBLY CONTROL												
3.1	ROTOR ASSEMBLY	ECCENTRICITY	MA	MEASUREMENT	100%	APPROVED GA DRG/ MFR.DRAWING	APPROVED GA DRG/ MFR.DRAWING	IR/LOG BOOK	✓	P	V	V	
3.2	ROTOR ASSEMBLY RESIDUAL UNBALANCE	STATIC & DYNAMIC	CR	STATIC & DYNAMIC BALANCING	100%	ISO 1940	ISO 1940 Gr 6.3	BALANCING CERTIFICATE	✓	P	W	V	WITNESSING ONLY FOR SIZE GREATER THAN 10KW
3.3	COMPLETE PUMP ASSEMBLY	COMPLETENESS, CORRECTNESS, CLEANLINESS, CLEARANCES, FREEMESS, ALIGNMENT	MA	VISUAL EXAM MEASUREMENT	100%	APPROVED DRG & MFG STANDARDS	APPROVED DRG & MFG STANDARDS	I.R. & CHECK LISTS	✓	P	V	V	
BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL					
ENGINEERING				QUALITY		Sign & Date		Doc No:					
Sign & Date		Name		Sign & Date		Name		Sign & Date		Name		Seal	
Prepared by: 		TANUJ MATT		Checked by: 		MOHIT KUMAR		Seal		Reviewed by:			
Reviewed by: 		AJAY JAIN		Reviewed by: 		RITESH KUMAR JAISWAL				Approved by:			

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS				QUALITY PLAN			SPEC NO.: PE-TS-XXX-100-0001		DATE		
					CUSTOMER:			QP NO.: PE-QP-999-100-0004		DATE		
					PROJECT:			PO NO		DATE		
					ITEM: MISC. PUMPS (HORIZONTAL/VERTICAL)		SYSTEM: CW/ACW/DMCW/PLANT/ COMMON		SECTION:		SHEET 5 OF 6	
S. No.	COMPONENT & OPERATION	CHARACTERISTIC	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY ** M C N		REMARKS
1	2	3	4	5	6	7	8	9	* D	10	11	
4	FINAL INSPECTION, TESTS & PACKING DESPATCH CONTROL											
4.1	PUMP WITH JOB/SHOP MOTOR ASSEMBLED ON INDIVIDUAL BASE FRAME	1. Q V/S HEAD, 2. Q V/S POWER, 3. Q V/S PUMP EFF. 4. VIBRATION 5. NOISE 6. BEARING TEMP. 7. LEAKAGES	CR	PERFORMANCE TEST	100%	APPD. PERFORMANCE TEST PROCEDURE/ APPD. DATA SHEET/APPD. CURVES FOR VIBRATIONS - AS PER ANSI/HIS 9.8.4-2009 (VALUES AS PER APPROVED DATA SHEET) FOR BEARING TEMP - BEARING HOUSING SHOULD NOT BE UNTOUCHABLY HOT. FOR LEAKAGE - MINOR LEAKAGE (DROP BY DROP) IN CASE OF GLAND PACKING ARRANGEMENT.	I.R., PERF. TEST RECORD, PLOTTED CURVES	✓	P	W	W	* MINIMUM 7 POINTS FROM SHUT-OFF TO MAX. OPERATING FLOW COVERING ENTIRE OPERATION RANGE OF PUMP SHALL BE TAKEN. * CUSTOMER HOLD POINT
		NPSH REQUIRED	CR	NPSH TEST	1/MODEL	APPD. PERFORMANCE TEST PROCEDURE/ APPD. DATA SHEET/APPD. CURVES	IR. NPSH TEST RECORD, PLOTTED CURVES	✓	P	W	W	IF SPECIFIED or INSISTED BY CUSTOMER.
4.2	STRIP DOWN AFTER PERFORMANCE TEST	1. UNDO WEAR TEAR AND RUBBING	MA	VISUAL EXAM AFTER STRIPPING	1/MODEL	NO UNDO WEAR TEAR & RUBBING ON IMPELLER & WEAR RING	INSP. REPORT	✓	P	W	W	WITNESS REQUIRED ONLY WHEN ABNORMAL SOUND OBSERVED DURING PERFORMING TEST.
4.3	COMPLETE PUMP WITH UNIT MOTOR BASE FRAME, COUNTER FLANGES ETC. INCLUDING ALL ACCESSORIES AS PER SECTION C OF SPECN.	COMPLETENESS, CLEANLINESS, OVERALL DIMENSIONS ORIENTATION, WORKMANSHIP AND FINISH	MA	VISUAL EXAM MEASUREMENT	100%	APPD. G.A DRAWING	APPD. G.A DRAWING	INSP. REPORT	✓	P	W	V
BHEL						BIDDER/ SUPPLIER		FOR CUSTOMER REVIEW & APPROVAL				
ENGINEERING:				QUALITY				Sign & Date		Doc No:		
Sign & Date		Name		Sign & Date		Name		Sign & Date		Name		Seal
Prepared by:  03/02/2020		TANUJ MATTA		Checked by:  03-02-20		MOHIT KUMAR		Seal		Reviewed by:		
Reviewed by:  03/02/2020		AJAY JAIN		Reviewed by:  03/02/2020		RITESH KUMAR JAISWAL				Approved by:		

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS			QUALITY PLAN				SPEC NO.: PE-TS-XXX-100-N001		DATE					
				CUSTOMER:				QP NO.: PE-QP-999-100-N004		DATE					
				PROJECT :				PO NO .		DATE					
				ITEM: MISC PUMPS (HORIZONTAL/VERTICAL)		SYSTEM: CW/ACW/DMCW/PLANT/ COMMON		SECTION:		SHEET 6 OF 6					
S. No.	COMPONENT & OPERATION	CHARACTERISTIC	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENTS	ACCEPTANCE NORMS	FORMAT OF RECORD		AGENCY **			REMARKS		
1	2	3	4	5	6	7	8	9	* D	10			11		
					M / C/N										
4.4	PAINTING	1. SURFACE FINISH, DFT, MARKINGS ETC.	MA	VISUAL EXAM MEASUREMENT AESTHETIC	100%	APPD.DRG.	APPD.DOCS	IR.	✓	P	V	V			
4.5	PACKING, MARKING	SOUNDNESS OF PACKING	MI	VISUAL AESTHETIC	100%	TECHNICAL SPECIFICATION/ MFG. STANDARD	TECHNICAL SPECIFICATION/ MFG. STANDARD	PHOTOGRAPHS	✓	P	V		PHOTOGRAPHS OF PACKED MATERIAL TO BE VERIFIED BY BHEL BEFORE ISSUING MOCC		
<p>NOTES:</p> <p>1. AS CAST HEAT MARKS SHALL BE PROVIDED ON CI CASTING LIKE TOP & BOTTOM CASING.</p> <p>2. HYDRO TEST PRESSURE SHALL BE AT LEAST 2(TWO) TIMES THE DUTY POINT (OR) 1.5 TIMES OF SHUT OFF HEAD (OR) SYSTEM DESIGN PRESSURE, WHICHEVER IS HIGHER.</p> <p>3. THIS QAP IS ALSO APPLICABLE FOR SPARES.</p> <p>4. NO WELD REPAIRS PERMISSIBLE ON CI CASTING.</p> <p>5. MATERIAL SHALL BE AS PER APPROVED CROSS SECTION DRG./ DATA SHEET.</p> <p>6. STRIP TEST- IN CASE OF ABNORMAL NOISE OBSERVED DURING PERF. TEST, THOSE PUMP WILL BE STRIPPED DOWN FOR VISUAL INSPECTION OF IMPELLER & WEAR SHALL BE OFFERED FOR VISUAL INSPECTION FOR WEAR / RUBBING MARKS.</p> <p>7. PUMPS WITH MECHANICAL SEAL ARRANGEMENT TO BE TESTED AND SUPPLIED WITH GLAND PACKING ARRANGEMENT. HOWEVER MANUFACTURER TO ENSURE DIMENTIONAL MATCHING OF MECHANICAL SEAL WITH PUMP GA DRAWING.</p> <p>8. BHEL RESERVES THE RIGHT FOR CONDUCTING REPEAT TEST IF REQUIRED.</p> <p>9. PMI (POSITIVE MATERIAL IDENTIFICATION) INSPECTION WITNESS BY "C"/"N" FOR MATERIAL GRADE OF PUMP CASING/BOWL ASSEMBLY, SHAFT, SHAFT SLEEVE, IMPELLER AND COLUMN PIPE (FOR VERTICAL PUMPS) ON RANDOM SAMPLE BASIS. HOWEVER, VENDOR TO CONDUCT 100% PMI AND PROVIDE PMI CERTIFICATES FOR REVIEW BY "C"/"N" DURING INSPECTION AT VENDOR WORKS.</p>															
<p>LEGEND : - * RECORDS, IDENTIFIED WITH "TICK"(✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION.</p> <p>** M: SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, C: MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, N: CUSTOMER</p> <p>P- PERFORM, W- WITNESS, V- VERIFICATION, AS APPROPRIATE</p> <p>MA: MAJOR, MI: MINOR, CR: CRITICAL, MTC - Mill Test Certificate, TC- Test Certificate, IGC- Inter Granular Corrosion.</p> <p>GA - GENERAL ARRANGEMENT DRAWING, CS- CROSS-SECTIONAL DRAWING</p>															
BHEL					BIDDER/ SUPPLIER			FOR CUSTOMER REVIEW & APPROVAL							
ENGINEERING				QUALITY											
Sign & Date		Name		Sign & Date		Name		Doc No:		Sign & Date		Name		Seal	
Prepared by: 		TANUJ MATT A		Checked by: 		MOHIT KUMAR		Reviewed by:							
Reviewed by: 		AJAY JAIN		Reviewed by: 		RITESH KUMAR JAISWAL		Approved by:							

735230/2022/PS-PEM-MSE

	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001	
		SECTION: II	
		SUB-SECTION: IIB	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1	OF 1

STANDARD TECHNICAL REQUIREMENTS**SUB-SECTION - IIB****STANDARD TECHNICAL SPECIFICATION (ELECTRICAL)****STANDARD QUALITY PLAN (ELECTRICAL)**



TITLE :
GENERAL TECHNICAL REQUIREMENTS
FOR
LV MOTORS

SPECIFICATION NO.
 PE-SS-999-506-E101
 VOLUME NO. :
 SECTION **II, Sub-section-IIB**
 REV NO. : **00** DATE : 29/08/2005
 SHEET : 1 OF 1

GENERAL TECHNICAL REQUIREMENTS

FOR
LV MOTORS

SPECIFICATION NO.: PE-SS-999-506-E101 Rev 00

<div><div>बी एच ई एल</div><div>BHEL</div></div>	TITLE : GENERAL TECHNICAL REQUIREMENTS FOR LV MOTORS	SPECIFICATION NO. PE-SS-999-506-E101
		VOLUME NO. : — —
		SECTION II, Sub-section-IIB
		REV NO. : 00 DATE : 29/08/2005
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1.0

INTENT OF SPECIFIATION

The specification covers the design, materials, constructional features, manufacture, inspection and testing at manufacturer’s work, and packing of Low voltage (LV) squirrel cage induction motors along with all accessories for driving auxiliaries in thermal power station.

Motors having a voltage rating of below 1000V are referred to as low voltage (LV) motors.

2.0

CODES AND STANDARDS

Motors shall fully comply with latest edition, including all amendments and revision, of following codes and standards:

IS:325	Three phase Induction motors
IS : 900	Code of practice for installation and maintenance of induction motors
IS: 996	Single phase small AC and universal motors
IS: 4722	Rotating Electrical machines
IS: 4691	Degree of Protection provided by enclosures for rotating electrical machines
IS: 4728	Terminal marking and direction of rotation rotating electrical machines
IS: 1231	Dimensions of three phase foot mounted induction motors
IS: 8789	Values of performance characteristics for three phase induction motors
IS: 13555	Guide for selection and application of 3-phase A.C. induction motors for different types of driven equipment
IS: 2148	Flame proof enclosures for electrical appliance
IS: 5571	Guide for selection of electrical equipment for hazardous areas
IS: 12824	Type of duty and classes of rating assigned
IS: 12802	Temperature rise measurement for rotating electrical machines
IS: 12065	Permissible limits of noise level for rotating electrical machines
IS: 12075	Mechanical vibration of rotating electrical machines

In case of imported motors, motors as per IEC-34 shall also be acceptable.

3.0

DESIGN REQUIREMENTS

3.1

Motors and accessories shall be designed to operate satisfactorily under conditions specified in data sheet-A and Project Information, including voltage & frequency variation of supply system as defined in Data sheet-A

3.2

Motors shall be continuously rated at the design ambient temperature specified in Data Sheet-A and other site conditions specified under Project Information
Motor ratings shall have at least a 15% margin over the continuous maximum demand of the driven equipment, under entire operating range including voltage & frequency variation specified above.

3.3


Starting Requirements


3.3.1


Motor characteristics such as speed, starting torque, break away torque and starting time shall be properly co-ordinated with the requirements of driven equipment. The accelerating torque at any speed with the minimum starting voltage shall be at least 10% higher than that of the driven equipment.


3.3.2

Motors shall be capable of starting and accelerating the load with direct on line starting without exceeding acceptable winding temperature.

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		VOLUME NO. :
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<p>The limiting value of voltage at rated frequency under which a motor will successfully start and accelerate to rated speed with load shall be taken to be a constant value as per Data Sheet - A during the starting period of motors.</p>		
<p>3.3.3 The following frequency of starts shall apply</p> <ul style="list-style-type: none">i) Two starts in succession with the motor being initially at a temperature not exceeding the rated load temperature.ii) Three equally spread starts in an hour the motor being initially at a temperature not exceeding the rated load operating temperature. (not to be repeated in the second successive hour)iii) Motors for coal conveyor and coal crusher application shall be suitable for three consecutive hot starts followed by one hour interval with maximum twenty starts per day and shall be suitable for minimum 20,000 starts during the life time of the motor		
<p>3.4 Running Requirements</p>		
<p>3.4.1 Motors shall run satisfactorily at a supply voltage of 75% of rated voltage for 5 minutes with full load without injurious heating to the motor.</p>		
<p>3.4.2 Motor shall not stall due to voltage dip in the system causing momentary drop in voltage upto 70% of the rated voltage for duration of 2 secs.</p>		
<p>3.5 Stress During bus Transfer</p>		
<p>3.5.1 Motors shall withstand the voltage, heavy inrush transient current, mechanical and torque stress developed due to the application of 150% of the rated voltage for at least 1 sec. caused due to vector difference between the motor residual voltage and the incoming supply voltage during occasional auto bus transfer.</p>		
<p>3.5.2 Motor and driven equipment shafts shall be adequately sized to satisfactorily withstand transient torque under above condition.</p>		
<p>3.6 Maximum noise level measured at distance of 1.0 metres from the outline of motor shall not exceed the values specified in IS 12065.</p>		
<p>3.7 The max. vibration velocity or double amplitude of motors vibration as measured at motor bearings shall be within the limits specified in IS: 12075.</p>		
<p>4.0 CONSTRUCTIONAL FEATURES</p>		
<p>4.1 Indoor motors shall conform to degree of protection IP: 54 as per IS: 4691. Outdoor or semi-indoor motors shall conform to degree of protection IP: 55 as per IS: 4691 and shall be of weather-proof construction. Outdoor motors shall be installed under a suitable canopy</p>		
<p>4.2 Motors upto 160KW shall have Totally Enclosed Fan Cooled (TEFC) enclosures, the method of cooling conforming to IC-0141 or IC-0151 of IS: 6362.</p> <p>Motors rated above 160 KW shall be Closed Air Circuit Air (CACA) cooled</p>		
<p>4.3 Motors shall be designed with cooling fans suitable for both directions of rotation.</p>		

	TITLE : GENERAL TECHNICAL REQUIREMENTS FOR LV MOTORS	SPECIFICATION NO. PE-SS-999-506-E101
		VOLUME NO. :
		SECTION II, Sub-section-IIB
		REV NO. : 00 DATE : 29/08/2005
		SHEET : 3 OF 4
4.4.	Motors shall not be provided with any electric or pneumatic operated external fan for cooling the motors.	
4.5	Frames shall be designed to avoid collection of moisture and all enclosures shall be provided with facility for drainage at the lowest point.	
4.6	In case Class ‘F’ insulation is provided for LV motors, temperature rise shall be limited to the limits applicable to Class ‘B’ insulation. In case of continuous operation at extreme voltage limits the temperature limits specified in table-1 of IS:325 shall not exceed by more than 10°C.	
4.7	Terminals and Terminal Boxes	
4.7.1	Terminals, terminal leads, terminal boxes, windings tails and associated equipment shall be suitable for connection to a supply system having a short circuit level, specified in the Data Sheet-A. Unless otherwise stated in Data Sheet-A, motors of rating 110 kW and above will be controlled by circuit breaker and below 110 kW by switch fuse-contactor. The terminal box of motors shall be designed for the fault current mentioned in data sheet “A”.	
4.7.2	unless otherwise specified or approved, phase terminal boxes of horizontal motors shall be positioned on the left hand side of the motor when viewed from the non-driving end.	
4.7.3	Connections shall be such that when the supply leads R, Y & B are connected to motor terminals A B & C or U, V & W respectively, motor shall rotate in an anticlockwise direction when viewed from the non-driving end. Where such motors require clockwise rotation, the supply leads R, Y, B will be connected to motor terminals A, C, B or U W & V respectively.	
4.7.4	Permanently attached diagram and instruction plate made preferably of stainless steel shall be mounted inside terminal box cover giving the connection diagram for the desired direction of rotation and reverse rotation.	
4.7.5	Motor terminals and terminal leads shall be fully insulated with no bar live parts. Adequate space shall be available inside the terminal box so that no difficulty is encountered for terminating the cable specified in Data Sheet-A.	
4.7.6	Degree of protection for terminal boxes shall be IP 55 as per IS 4691.	
4.7.7	Separate terminal boxes shall be provided for space heaters.. If this is not possible in case of LV motors, the space heater terminals shall be adequately segregated from the main terminals in the main terminal box. Detachable gland plates with double compression brass glands shall be provided in terminal boxes.	
4.7.8.	Phase terminal boxes shall be suitable for 360 degree of rotation in steps of 90 degree for LV motors.	
4.7.9	Cable glands and cable lugs as per cable sizes specified in Data Sheet-A shall be included. Cable lugs shall be of tinned Copper, crimping type.	
4.8	Two separate earthing terminals suitable for connecting G.I. or MS strip grounding conductor of size given in Data Sheet-A shall be provided on opposite sides of motor frame. Each terminal box shall have a grounding terminal.	
4.9	General	

	TITLE : GENERAL TECHNICAL REQUIREMENTS FOR LV MOTORS	SPECIFICATION NO. PE-SS-999-506-E101
		VOLUME NO. :
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		REV NO. : 00 DATE : 29/08/2005
		SHEET : 4 OF 4
<p>4.9.1 Motors provided for similar drives shall be interchangeable.</p> <p>4.9.2 Suitable foundation bolts are to be supplied alongwith the motors.</p> <p>4.9.3 Motors shall be provided with eye bolts, or other means to facilitate safe lifting if the weight is 20Kgs. and above.</p> <p>4.9.4 Necessary fitments and accessories shall be provided on motors in accordance with the latest Indian Electricity rules 1956.</p> <p>4.9.5 All motors rated above 30 kW shall be provided with space heaters to maintain the motor internal air temperature above the dew point. Unless otherwise specified, space heaters shall be suitable for a supply of 240V AC, single phase, 50 Hz.</p> <p>4.9.6 Name plate with all particulars as per IS: 325 shall be provided</p> <p>4.9.7 Unless otherwise specified, the colour of finish shall be grey to Shade No. 631 and 632 as per IS:5 for motors installed indoor and outdoor respectively. The paint shall be epoxy based and shall be suitable for withstanding specified site conditions.</p> <p>5.0 INSPECTION AND TESTING</p> <p>5.1 All materials, components and equipments covered under this specification shall be procured, manufactured, as per the BHEL standard quality plan No. PED-506-00-Q-006/0 and PED-506-00-Q-007/2 enclosed with this specification and which shall be complied.</p> <p>5.2 LV motors of type-tested design shall be provided. Valid type test reports not more than 5 year shall be furnished. In the absence of these, type tests shall have to be conducted by manufacturer without any commercial implication to purchaser.</p> <p>5.3 All motors shall be subjected to routine tests as per IS: 325 and as per BHEL standard quality plan.</p> <p>5.4 Motors shall also be subjected to additional tests, if any, as mentioned in Data Sheet A.</p> <p>6.0 DRAWINGS TO BE SUBMITTED AFTER AWARD OF CONTRACT</p> <p>a) OGA drawing showing the position of terminal boxes, earthing connections etc.</p> <p>b) Arrangement drawing of terminal boxes.</p> <p>c) Characteristic curves: (To be given for motor above 55 kW unless otherwise specified in Data Sheet).</p> <p>i) Current vs. time at rated voltage and minimum starting voltage.</p> <p>ii) Speed vs. time at rated voltage and minimum starting voltage.</p> <p>iii) Torque vs. speed at rated voltage and minimum voltage. For the motors with solid coupling the above curves i), ii), iii) to be furnished for the motors coupled with driven equipment. In case motor is coupled with mechanical equipment by fluid coupling, the above curves shall be furnished with and without coupling.</p> <p>iv) Thermal withstand curve under hot and cold conditions at rated voltage and max. permissible voltage.</p>		

<div><div></div><div><div>MANUFACTURER/ SUPPLIER NAME & ADDRESS</div><div>BIDDER/ ADDRESS</div></div></div>		STANDARD QUALITY PLAN				SPEC. NO :		DATE:	
CUSTOMER :		QP NO.: PE-QP-999-Q-006, REV-02				DATE: 17.04.2020			
PROJECT:		PO NO.:				DATE:			
ITEM: AC ELECT. MOTORS UPTO 55KW (LV (415V))		SYSTEM:				SECTION: II		SHEET 1 of 2	


S. NO.	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY	REMARKS
1	2	3	4	5	6	7	8	9	**	
		1.WORKMANSHIP	MA	VISUAL	M 100% C - N -	MFG. SPEC.	MFG. SPEC.	LOG BOOK	P - M - C - N -	
		2.DIMENSIONS	MA	VISUAL	100%	MFG. DRG./ MFG. SPEC.	MFG. DRG./ MFG. SPEC.	LOG BOOK	P -	
1.0	ASSEMBLY	3.CORRECTNESS COMPLETENESS TERMINATIONS/ MARKING/ COLOUR CODE	MA	VISUAL	100%	MFG.SPEC./	MFG.SPEC.	LOG BOOK	P -	

2.0	PAINING	1.SHADE	MA	VISUAL	SAMPLE	MFG. SPEC/ APPROVED DATASHEET	MFG. SPEC/ APPROVED DATASHEET	LOG BOOK	✓ P V -	
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3.0	TESTS	1.ROUTINE TEST INCLUDING SPECIAL TEST	MA	VISUAL	100%	IS-325 / IS-12615/ APPROVED DATA SHEET	IS-325 / IS-12615/ APPROVED DATA SHEET	TEST/ INSPN. REPORT	✓ P V *	* NOTE -1
		2.OVERALL DIMENSIONS & ORIENTATION	MA	MEASUREME NT & VISUAL	100%	APPROVED DRG/ DATA SHEET	APPROVED DRG/ DATA SHEET	TEST/ INSPN. REPORT	✓ P V *	* NOTE -1 & NOTE-2

BHEL				BIDDER/ SUPPLIER				FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING		QUALITY		Sign & Date		Sign & Date		Doc No:		Sign & Date	
Prepared by:	HEMA KUSHWAHA	Name	HEMA KUSHWAHA	Checked by:	KUNAL GANDHI	Seal		Reviewed by:		Name	Seal
Reviewed by:	PRAVEEN DUTTA	Name	PRAVEEN DUTTA	Reviewed by:	RITESH KUMAR JAISWAL	Seal		Approved by:			

Sub-section-IIB

		MANUFACTURER/ SUPPLIER NAME & ADDRESS		BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN		SPEC. NO :		DATE:	
		CUSTOMER :		PROJECT:		ITEM: AC ELECT. MOTORS UPTO 55KW (LV (415V))		SYSTEM:		SECTION: II	
		3.NAMEPLATE DETAILS		MA		VISUAL		100%		-	
		IS-325 / IS-12615 / APPROVED DATA SHEET		SAME AS COL. 7		TEST/ INSPN. REPORT		✓		P V -	
4.0 PACKING		SURFACE FINISH & COMPLETENESS		MA		VISUAL		100%		100%	
								AS PER MFG. STANDARD / (#)		AS PER MFG. STANDARD / (#)	
								INSPC. REPORT		✓ P W -	
										(REFER NOTE-8)	

NOTES:

1. Routine tests on 100% motors shall be done by the vendor. However, BHEL/ Customer shall witness routine tests on random samples. The sampling plan shall be mutually agreed upon.

2. For exhaust/ventilation fan motors of rating up to 1.5 KW, only routine test certificates shall be furnished for scrutiny.

3. In case test certificates for these tests on similar type, size and design of motor from independent laboratory are available, the same is valid for 5 years.

4. BHEL reserves the right to perform repeat test, if required.

5. After packing and prior to issue MDCC, photographs of items to be despatched shall be sent to BHEL for review.

6. In case of any changes in QP commented by customer at contract stage, same shall be carried out by bidder without any implication to BHEL/ Customer.

7. Project specific QP to be developed based on customer requirement.

8. For export job, BHEL technical specification for seaworthy packing to be followed.

9. Packing shall be suitable for storage at site in tropical climate conditions.

10. Latest revision/ year of issue of all the standards (IS/ ASME/ IEC etc.) indicated in QP shall be referred.

LEGENDS:

*RECORDS, IDENTIFIED WITH "TICK"(✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION,

** M: SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, B: MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, C: CUSTOMER,


P: PERFORM, W: WITNESS, V: VERIFICATION, AS APPROPRIATE

MA: MAJOR, MI: MINOR, CR: CRITICAL

D: DOCUMENTATION

BHEL				BIDDER/ SUPPLIER				FOR CUSTOMER REVIEW & APPROVAL			
ENGINEERING		QUALITY		Sign & Date		Sign & Date		Doc No:		Sign & Date	
Prepared by:	HEMA KUSHWAHA	Name	HEMA KUSHWAHA	Checked by:	KUNAL GANDHI	Sign & Date	Name	Seal	Reviewed by:	Approved by:	Seal
Reviewed by:	PRAVEEN DUTTA	Name	PRAVEEN DUTTA	Checked by:	RITESH KUMAR	Sign & Date	Name	Seal	Reviewed by:	Approved by:	Seal


Sub-section-IIB


	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN		SPEC. NO. :	
			CUSTOMER :		QP NO. : PE-OP-999-Q-007, REV-04	
			PROJECT:		PO NO.:	
			ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))		SYSTEM: II	
					DATE:17.04.2020	
					SHEET 1 OF 9	

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check		Reference Document	Acceptance NORMS	FORMAT OF RECORD				AGENCY			
					M	C/N			9	D	M	C	N			
1.0	RAW MATERIAL & BOUGHT OUT CONTROL															
1.1	SHEET STEEL PLATES, SECTION, EYEBOLTS	1.SURFACE CONDITION	MA	VISUAL	100%	-	-	FREE FROM BLANKS, CRACKS, WAVINESS ETC	LOG BOOK		P	-	-			
1.2	HARDWARES	2.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	LOG BOOK		P	-	-			
		3.PROOF LOAD TEST (EYE BOLT)	MA	MECH. TEST	SAMPLE	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	TEST REPORT		P/V	-	-			
		1.SURFACE CONDITION	MA	VISUAL	100%	-		FREE FROM CRACKS, UNEVENNESS ETC.	TEST REPORT		P	-	-			
		2.PROPERTY CLASS	MA	VISUAL	SAMPLES	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	TC		P/V	-	-		PROPERTY CLASS MARKING SHALL BE CHECKED BY THE VENDOR	
1.3	CASTING	1.SURFACE CONDITION	MA	VISUAL	100%	-	MANUFACTURER'S DRG./SPEC	FREE FROM CRACKS, BLOW HOLES ETC.	LOG BOOK		P/V	-	-			
1.4	PAINT & VARNISH	2.CHEM. & PHY. PROP.	MA	CHEM & MECH TEST	1/HEAT NO.	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	TC		P/V	-	-		HEAT NO. SHALL BE VERIFIED	
		3.DIMENSIONS	MA	MEASUREMENT	100%	-	MANUFACTURER'S DRG.	MANUFACTURER'S DRG.	LOG BOOK		P/V	-	-			
		1.MAKE, SHADE, SHELF LIFE & TYPE	MA	VISUAL	100% CONTINUOUS	-	MANUFACTURER'S DRG./SPEC	MANUFACTURER'S DRG./SPEC	LOG BOOK		P/V	-	-			

ENGINEERING				BHEL				QUALITY			
Sign & Date		Name		Sign & Date		Name					
Prepared by:	HEMA KUSHWAHA	Checked by:	HEMA KHUSHWAHA								
Reviewed by:	PRAVEEN DUTTA	Reviewed by:	PRAVEEN DUTTA								


DUITA


HEMA KUSHWAHA
QUALITY ENGINEER
BHEL LIMITED
PO BOX 10000
RAIPUR (C.O.)
JHARKHAND - 826 001






PRAVEEN DUTTA
QUALITY ENGINEER
BHEL LIMITED
PO BOX 10000
RAIPUR (C.O.)
JHARKHAND - 826 001

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:		Sign & Date	Seal
Reviewed by:			
Approved by:			

Sub-section-11B


<div></div> <div>MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS</div>		STANDARD QUALITY PLAN				SPEC. NO.:			
		CUSTOMER :				QP NO.: PE-QP-399-QJ07, REV-04			
		PROJECT:				PO NO.:			
		ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))				SYSTEM:			
						SECTION: II		SHEET 2 OF 9	

SI No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check		Reference Document	Acceptance NORMS	FORMAT OF RECORD		AGENCY				
					6				9		* **		D M C N		
1		3	4	5	100%	-	-	7	8						
1.5	SHAFT (FORGED OR ROLLED)	1. SURFACE COND.	MA	VISUAL	100%	-	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK	P	-	-	-	VENDOR'S APPROVAL IDENTIFICATION SHALL BE MAINTAINED
		2. CHEM. & PHYSICAL PROPERTIES	MA	CHEM. & PHYSICAL TESTS	1/HEAT NO. OR HEAT TREATMENT BATCH NO	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURER'S DRG./ STD.	TC		PV	-	-	-	
		3. DIMENSIONS	MA	MEASUREMENT	100%	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURER'S DRG.	LOG BOOK		PV	-	-	-	
		4.INTERNAL FLAWS	CR	ULTRASONIC TEST	100%	-	ASTM-A388	MANUFACTURER'S STD.	INSPECTION REPORT		PW	V	-	-	FOR DIA OF 55 MM & ABOVE
1.6	SPACE HEATERS, CONNEC- TIONS, CABLE LUGS, CARBON BRUSH TEMP. DETECTORS, RTD, RTD'S	1. MAKE & RATING	MA	VISUAL	100%	-	MANUFACTURER'S DRG./STD.	MANUFACTURER'S DRG./STD.	INSPECTION REPORT		PV	-	-	-	
		2. PHYSICAL COND.	MA	VISUAL	100%	-	MANUFACTURERS DRG./STD.	NO PHYS. DAMAGE. NO ELECTRICAL DISCONTINUITY	INSPECTION REPORT		PV	-	-	-	
		3.DIMENSIONS (WHEREVER APPLICABLE)	MA	MEASUREMENT	SAMPLE	-	MANUFACTURERS DRG./ STD	MANUFACTURER'S DRG./ STD.	INSPECTION REPORT		PV	-	-	-	
		4.PERFORMANCE/ CALIBRATION	MA	TEST	100%	-	MANUFACTURERS DRG./ STD	MANUFACTURER'S DRG./ STD.	TEST REPORT		PV	-	-	-	

ENGINEERING				BHEL		QUALITY	
Sign & Date	Sign & Date	Name	Sign & Date	Sign & Date	Name	Sign & Date	Name
<div></div> HEMA KUSHWAHA	<div></div> HEMA KHUSHWAHA	HEMA KHUSHWAHA	Checked by:	<div></div> KUNAL GANDHI			
Prepared by:	PRAVEEN DUTTA	PRAVEEN DUTTA	Reviewed by:	<div></div> R K JAISWAL			

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:	Sign & Date	Name	Seal
Reviewed by:			
Approved by:			

Sub-section-IIB


	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN					
			SPEC. NO. :		DATE: 17.04.2020			
			CUSTOMER : QP NO.: PE-QP-993-Q407, REV44					
			PROJECT: PO NO.:					
ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))			SYSTEM:		SECTION: II		SHEET 3 OF 9	

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check			Reference Document	Acceptance NORMS	FORMAT OF RECORD				AGENCY			
					M	CN				9	8	7	6	D	M	C	N
1				5				7	8								
1.7	OTHER INSULATING MATERIALS LIKE SLEEVES, BINDING CORDS, PAPERS, PRESS BOARDS ETC.	1. SURFACE COND. ETC. 2.DIMENSION (BORE DIA, WALL THICKNESS, BDV AS REQUIRED, BDV AFTER FOLDING AT 180°	MA	VISUAL	100%	-	-	-	NO VISUAL DEFECTS	TEST REPORT				P/V	-	-	-
1.8	SHEET STAMPING (PUNCHED)	1. SURFACE COND. 2.DIMENSIONS INCLUDING BURRS HEIGHT 3.ACCEPTANCE TESTS	MA	TEST	SAMPLE	-	-	MANUFACTURER'S STD.	MANUFACTURER'S STD.	LOG BOOK AND OR SUPPLIER'S TC				P/V	-	-	-
			MA	VISUAL	100%	-	-	-	NO VISUAL DEFECTS (FREE FROM BURRS)	LOG BOOK				P	-	-	-
			MA	MEASUREMENT	SAMPLE	-	-	MANUFACTURER'S DRG. .	MANUFACTURER'S DRG.	LOG BOOK				P/V	-	-	-
			MA	ELECT. & MECH TESTS	SAMPLE	-	-	MANUFACTURER'S DRG./ STD.	MANUFACTURER'S DRG./ STD.	TC				P/V	-	-	-
1.9	CONDUCTORS	1. SURFACE FINISH 2.ELECT. PROP. & MECH. PROP	MA	VISUAL	100%	-	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK				*P/V	-	-	-
			MA	ELECT. & MECH TEST	SAMPLES	-	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURER'S / SPEC.	TC & VENDOR'S TEST REPORTS				P/V	-	-	-

BHEL				QUALITY			
ENGINEERING							
Prepared by:	Sign & Date	Name	Sign & Date	Name			
	HEMA KHUSHWAHA	HEMA KHUSHWAHA		KUNAL GANDHI			
Reviewed by:	Sign & Date	Name	Sign & Date	Name			
	PRAVEEN DUTTA	PRAVEEN DUTTA		R K JAISWAL			

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:			
	Sign & Date	Name	Seal
Reviewed by:			
Approved by:			

Sub-section-IIB


	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN		SPEC. NO. :	
			CUSTOMER :		QP NO. : PE-QP-999-Q007 , REV-04	
			PROJECT :		PO NO. :	
			ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))		SYSTEM: SECTION: II	
					DATE:17.04.2020	
					SHEET 4 OF 9	

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check			Reference Document	Acceptance NORMS	FORMAT OF RECORD				AGENCY			
					M	C/N				9	8	7	6	5	4	3	2
1.10	BEARINGS	3.DIMENSIONS	MA	MEASUREMENT	SAMPLES	-	-	MANUFACTURER'S DRG./ SPEC.	MANUFACTURERS / SPEC.	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P/V	-	-	-
		1.MAKE & TYPE	MA	VISUAL	100%	-	-	MANUFACTURER'S DRG./ APPROVED DATASHEET	MANUFACTURERS DRG./ APPROVED DATASHEET	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P/V	-	-	-
		2.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	-	APPROVED DATASHEET	APPROVED DATASHEET/ BEARING MANUFACTURER'S CATALOGUES	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P/V	-	-	-
		3.SURFACE FINISH	MA	VISUAL	100%	-	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P/V	-	-	-
1.11	SLIP RING (WHEREVER APPLICABLE)	1.SURFACE COND.	MA	VISUAL	100%	-	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P	-	-	-
		2.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	-	MANUFACTURER'S DRG	MANUFACTURERS DRG	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P	-	-	-
		3.TEMP WITH STAND CAPACITY	MA	ELECT. TEST	SAMPLE	-	-	MANUFACTURER'S STD./ APPROVED DATASHEET	MANUFACTURERS STD./ APPROVED DATASHEET	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P/V	-	-	-
		4.HVIR	MA	DO-	100%	-	-	MANUFACTURER'S STD./ APPROVED DATASHEET	MANUFACTURERS STD./ APPROVED DATASHEET	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P/V	-	-	-
1.12	OIL SEALS & GASKETS	1.MATERIAL OF GASKET	MA	VISUAL	100%	-	-	MANUFACTURER'S DRG/SFCS	MANUFACTURERS DRG/ SFCS.	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P	-	-	-
		2.SURFACE COND.	MA	VISUAL	100%	-	-	-	FREE FROM VISUAL DEFECTS	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P	-	-	-
		3.DIMENSIONS	MA	MEASUREMENT	SAMPLE	-	-	MANUFACTURER'S DRG	MANUFACTURERS DRG	LOG BOOK	LOG BOOK	LOG BOOK	LOG BOOK	P	-	-	-

BHEL				QUALITY			
ENGINEERING		SIGNATURE		NAME		DATE	
Prepared by:	HEMA KUSHWAHA	Checked by:	HEMA KHUSHWAHA	Signature	Name	Seal	
Reviewed by:	PRAVEEN DUTTA	Reviewed by:	PRAVEEN DUTTA	Signature	Name	Seal	

FOR CUSTOMER REVIEW & APPROVAL							
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Reviewed by:		Reviewed by:		Name		Seal	
Approved by:		Approved by:		Name		Seal	

Sub-section-IIB


		MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS				STANDARD QUALITY PLAN				SPEC. NO.			
						CUSTOMER :				QP NO.: PE-QP-999-Q407, REV-04			
						PROJECT:				PO NO.:			
						ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))				SYSTEM:			
										SECTION: II			
										DATE: 17.04.2020			
										SHEET 5 OF 9			

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check			Reference Document	Acceptance NORMS	FORMAT OF RECORD	AGENCY			
1		3	4	5	6			7	8	9	10			
					M	C/N								
2.0	IN PROCESS													
2.1	STATOR FRAME WELDING (IN CASE OF FABRICATED STATOR)	1.WORKMANSHIP & CLEANNESS	MA	VISUAL	100%	-		MANUFACTURER'S DRG	GOOD FINISH	LOG BOOK	P/W			
		2.DIMENSIONS	MA	MEASUREMENT	100%	-		MANUFACTURER'S DRG	MANUFACTURER'S DRG	LOG BOOK	P			
2.2	MACHINING	1.FINISH	MA	VISUAL	100%	-		DO-	GOOD FINISH	LOG BOOK	P			
		2.DIMENSIONS	MA	MEASUREMENT	100%	-		MANUFACTURER'S DRG	MANUFACTURER'S DRG	LOG BOOK	P			
		3.SHAFT SURFACE FLOWS	MA	PT	100%	-		MANUFACTURER'S STD./APPROVED DATASHEET ASHRAE 165	MANUFACTURER'S STD./APPROVED DATASHEET.	LOG BOOK	P			
2.3	PANTING	1.SURFACE PREPARATION	MA	VISUAL	100%	-		MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK	P			
		2.PAINT THICKNESS (BOTH PRIMER & FINISH COAT)	MA	MEASUREMENT BY ELCOMETER	SAMPLE	-		MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK	P			
		3.SHADE	MA	VISUAL	SAMPLE	-		MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK	P			
		4.ADHESION	MA	CROSS CUTTING & TAPE TEST	SAMPLE	-		MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK	P			

BHEL			QUALITY		
ENGINEERING			SIGNATURE		
Prepared by:	Sign & Date	Name	Checked by:	Sign & Date	Name
HEMA KUSHWAHA		HEMA KHUSHWAHA			KUNAL GANDHI
Reviewed by:	Sign & Date	Name	Reviewed by:	Sign & Date	Name
PRABVEEN DUTTA		PRABVEEN DUTTA			R K JAISWAL

BIDDER/ SUPPLIER			FOR CUSTOMER REVIEW & APPROVAL		
Sign & Date			Doc No:		
Seal			Sign & Date		
			Reviewed by:		
			Approved by:		

Sub-section-IIB


	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN		SPEC. NO.:	
			CUSTOMER :		QP NO.: PE-QP-999-Q007, REV:04	
			PROJECT:		PO NO.:	
			ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))		SYSTEM:	
					SECTION: II	
					SHEET 6 OF 9	

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check		Reference Document	Acceptance NORMS	FORMAT OF RECORD		AGENCY				
1	2	3	4	5	6		7	8	9	.	D	M	C	N	
					M	C/N									
2.4	SHEET STACKING	1.COMPLETENESS	MA	MEASUREMENT	SAMPLE	-	MANUFACTURER'S STD.	MANUFACTURER'S STD.	LOG BOOK			P	-	-	
		2.COMPRESSION & TIGHTENING	MA	MEASUREMENT	100%	-		MANUFACTURER'S STD.	MANUFACTURER'S STD.	LOG BOOK			P	-	-
		1.COMPLETENESS	CR	VISUAL	100%	-		MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK			P	-	-
	2.5	WINDING	2.CLEANLINESS	CR	VISUAL	100%	-	MANUFACTURER'S STD./APPROVED DATASHEET	MANUFACTURER'S STD./APPROVED DATASHEET	LOG BOOK			P	-	-
3.IR HV-IR			CR	ELECT. TEST	100%	-	IS-325/IS-12615/IEC-60034 PART-1	IS-325/IS-12615/IEC-60034 PART-1	TEST/INSPC. REPORT	✓		P	V	-	
4.RESISTANCE			CR	ELECT. TEST	100%	-	IS-325/IS-12615/IEC-60034 PART-1	IS-325/IS-12615/IEC-60034 PART-1	TEST/INSPC. REPORT	✓		P	V	-	
5.INTERTURN INSULATION			CR	ELECT. TEST	100%	-	IS-325/IS-12615/IEC-60034 PART-1	IS-325/IS-12615/IEC-60034 PART-1	TEST/INSPC. REPORT			P	-	-	
2.6	IMPREGNATION	1.VISCOSITY	MA	PHY. TEST	AT STARTING	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK			P	-	-	
		2.TEMP. PRESSURE VACUUM	MA	PROCESS CHECK	CONTINUOUS	-		MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK			P	-	-
		3.NO. OF DIPS	MA	PROCESS CHECK	CONTINUOUS	-		MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK	✓		P	V	-
											THREE DIPS TO BE GIVEN				

BHEL				QUALITY			
ENGINEERING		SIGNATURE		SIGNATURE		SIGNATURE	
Prepared by:	HEMA KHUSHWAHA	Name		Sign & Date		Name	
Reviewed by:	PRABVEEN DUTTA	Checked by:	HEMA KHUSHWAHA	Reviewed by:	PRABVEEN DUTTA	Reviewed by:	HEMA KHUSHWAHA
DUITTA				JASWAL			

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:		Sign & Date	
Reviewed by:		Name	
Approved by:		Seal	

Sub-section-IIB

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN		SPEC. NO.:	
			CUSTOMER :		QP NO.: PE-QP-999-Q-007, REV.04	
			PROJECT:		PO NO.:	
			ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))		SYSTEM:	
					DATE:17.04.2020	
					SECTION: II	
					SHEET 7 OF 9	

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check		Reference Document	Acceptance NORMS	FORMAT OF RECORD	AGENCY			
1	2	3	4	5	6		7	8	9	10	11	12	13
					M	CN							
2.7	COMPLETE STATOR ASSEMBLY	4.DURATION 1.COMPACTNESS & CLEANLINESS	MA	PROCESS CHECK VISUAL	CONTINUOUS	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK	✓	P	V	-
			MA	VISUAL	100%	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK		P	-	-
2.8	BRAZING/COMPRESSION JOINT	1.COMPLETENESS 2.SOUNDNESS	CR	VISUAL	100%	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	LOG BOOK		P	-	-
			CR	Mallet TEST & UT	100%	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	TEST/INSPC. REPORT	✓	P	V	-
2.9	COMPLETE ROTOR ASSEMBLY	3.HV 1.RESIDUAL UNBALANCE	MA	ELECT. TEST	100%	-	MANUFACTURER'S STANDARD	MANUFACTURER'S STANDARD	TEST/INSPC. REPORT	✓	P	V	-
			CR	DYN. BALANCE	100%	-	MANUFACTURER'S SPEC./ ISO 1840	MANUFACTURER'S DWG.	LOG BOOK		P	-	-
2.10	ASSEMBLY	2.SOUNDNESS 3.CORRECTNESS OF CASTING	CR	ELECT. (TURNER TEST)	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	TEST/INSPC. REPORT	✓	P	V	-
			MA	MEAS.	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
		1.ALIGNMENT 2.WORKMANSHIP	MA	VISUAL	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
			MA	MEAS.	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
		3.VIB. PLAY	MA	MEAS.	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK	✓	P	V	-
			MA	MEAS.	100%	-	MANUFACTURER'S DRG./ MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
		4.DIMENSIONS	MA	MEAS.	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
			MA	VISUAL	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
		5.CORRECTNESS OF TERMINALS MARKING/ COLOUR CODE	MA	VISUAL	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
			MA	VISUAL	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-
		6. RTD, BTD & SPACE HEATER MOUNTING.	MA	VISUAL	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK	✓	P	V	-
			MA	VISUAL	100%	-	MANUFACTURER'S SPEC.	MANUFACTURER'S SPEC.	LOG BOOK		P	-	-

BHEL			
ENGINEERING		QUALITY	
Sign & Date	Name	Sign & Date	Name
Prepared by: HEMA KUSHWAHA	HEMA KHUSHWAHA	Checked by: RITESH JAIN	KUNAL GANDHI
Reviewed by: PRAVEEN DUTTA	PRAVEEN DUTTA	Reviewed by: R K JAISWAL	R K JAISWAL

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:	Sign & Date	Name	Seal
Reviewed by:			
Approved by:			


Sub-section-11B

MANUFACTURER/ BIDDER SUPPLIER NAME & ADDRESS										STANDARD QUALITY PLAN				SPEC. NO. :	
CUSTOMER : PROJECT:										QP NO.: PE-QP-999-Q-007, REV-04				DATE:17.04.2020	
										PO NO.:					
										SECTION: II				SHEET 8 OF 9	
ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))										SYSTEM:					

SI No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check		Reference Document	Acceptance NORMIS	FORMAT OF RECORD		AGENCY			
					M	C/N			D	*	**	M	C	N
1		3	4	5	1/TYPER/SIZE	1/TYPER/SIZE	IS-325/IS-12615/APPROVED DATASHEET	IS-325/IS-12615/APPROVED DATASHEET	✓	P	W*	-	* NOTE -1	
3.0	TESTS	1.TYPE TESTS INCLUDING SPECIAL TESTS 2.ROUTINE TESTS INCLUDING SPECIAL TEST	MA	ELECT.TEST	100%	-	IS-325/IS-12615/APPROVED DATASHEET	IS-325/IS-12615/APPROVED DATASHEET	✓	P	V³	-	§ NOTE -2	
		3.VIBRATION & NOISE LEVEL	MA	ELECT.TEST	100%	-	IS-12075 / IEC 60034-14 & IS-12065	IS-12075 / IEC 60034-14 & IS-12065	✓	P	V⁵	-	§NOTE -2	
		4.OVERALL DIMENSIONS AND ORIENTATION	MA	MEASUREMENT & VISUAL	100%	100%	APPROVED DRG/DATA SHEET	APPROVED DATASHEET	✓	P	W	-	-	
		5.DEGREE OF PROTECTION	MA	ELECT. & MECH. TEST	1/TYFE/ SIZE	-	IEC 60034-4&IS-12615	APPROVED DATASHEET	✓	P	V	-	TC FROM AN INDEPENDENT LABORATORY, REFER NOTE-3	
		6. MEASUREMENT OF RESISTANCE OF RTD & BTD	MA	ELECT. & MECH. TEST	100%	-	IS-325/IS-12615/IEC-C-60034 PART-1/MS-12802	IS-325/IS-12615/IEC-C-60034 PART-1/MS-12802	✓	P	V³	-	§ NOTE -2	
		7. MEASUREMENT OF SPACE HEATER	MA	ELECT. & MECH. TEST	100%	-	IS-325/IS-12615/IEC-C-60034 PART-1	IS-325/IS-12615/IEC-C-60034 PART-1	✓	P	V⁵	-	§ NOTE -2	
		8. NAME PLATE DETAILS	MA	VISUAL	100%	-	IS-325/IS-12615& DATA SHEET	TEST INSPC. REPORT	✓	P	V³	-	§ NOTE -2	
		9.EXPLOSION PROOFNESS IF SPECIFIED)	MA	EXPLOSION PROOF TEST	1/TYFE	-	IS 2148 / IEC 60079-1	IS 2148 / IEC 60079-1	✓	P	V	-	TC FROM AN INDEPENDENT LABORATORY, REFER NOTE-3	
		10. PAINT SHADE, THICKNESS & FINISH	MA	VISUAL & MEASUREMENT BY ELKOMETER	SAMPLE	SAMPLE	APPROVED DATASHEET	APPROVED DATASHEET	✓	P	WS	-	SAMPLING PLAN TO BE DECIDED BY INSPECTION AGENCY § NOTE -2	

ENGINEERING					BHEL		FOR CUSTOMER REVIEW & APPROVAL					
Prepared by:	HEMA KHUSHWAHA	Name	Sign & Date	Checked by:	Hema Khushwaha	Signature	Date	Reviewed by:	Ritesh Kumar Jaiswal	Signature	Date	Seal
Reviewed by:	PRAVEEN DUTTA	Name	Sign & Date	Checked by:	KUNAL GANDHI	Signature	Date	Reviewed by:	R K JAISWAL	Signature	Date	Seal

Sub-section-IIB

	MANUFACTURER/ BIDDER/ SUPPLIER NAME & ADDRESS		STANDARD QUALITY PLAN				SPEC. NO. :	
			CUSTOMER :				QP NO. : PE-QP-989-Q-007, REV-04	
			PROJECT:				PO NO.:	
			ITEM: AC ELECT. MOTORS 55 KW & ABOVE (LV (415V))				SYSTEM: II	
							DATE: 17/04/2020	
							SHEET 9 OF 9	

Sl No.	Component & Operations	Characteristics	Class	Type of Check	Quantum Of check	Reference Document	Acceptance NORMS	FORMAT OF RECORD	AGENCY
1		3	4	5	6	7	8	9	
					M				
					C/N				
4.0	PACKING	SURFACE FINISH & COMPLETENESS	MA	VISUAL	100%	100%	AS PER MANUFACT. STANDARD / (#)	NSPC, REPORT	

NOTES:

- 1 DEPENDING UPON THE SIZE AND CRITICALLY , WITNESSING BY BHEL SHALL BE DECIDED.
- 2 ROUTINE TESTS ON 100% MOTORS SHALL BE DONE BY THE VENDOR , HOWEVER, BHEL/CUSTOMER SHALL WITNESS ROUTINE TESTS ON RANDOM SAMPLES. THE SAMPLING PLAN SHALL BE MUTUALLY AGREED UPON.
- 3 IN CASE TEST CERTIFICATES FOR THESE TESTS ON SIMILAR TYPE, SIZE AND DESIGN OF MOTOR FROM INDEPENDENT LABORATORY ARE AVAILABLE, THE SAME IS VALID FOR 3 YEARS.
- 4 BHEL RESERVES THE RIGHT TO PERFORM REPEAT TEST, IF REQUIRED.
- 5 AFTER PACKING AND PRIOR TO ISSUE MDCC, PHOTOGRAPHS OF ITEMS TO BE DESPATCHED SHALL BE SENT TO BHEL PURCHASE GROUP FOR REVIEW.
- 6 IN CASE ,ANY CHANGES IN QP COMMENTED BY CUSTOMER AT CONTRACT STAGE SHALL BE CARRIED OUT BY BIDDER WITHOUT ANY IMPLICATION TO BHEL/ CUSTOMER.
- 7 PROJECT SPECIFIC QP TO BE DEVELOPED BASED ON CUSTOMER REQUIREMENT.
- 8 FOR EXPORT JOB, BHEL TECHNICAL SPECIFICATION FOR SEAWORTHY PACKING TO BE FOLLOWED.
- 9 PACKING SHALL BE SUITABLE FOR STORAGE AT SITE IN TROPICAL CLIMATE CONDITIONS.
- 10 LATEST REVISION/ YEAR OF ISSUE OF ALL THE STANDARDS (IS/ ASME/ IEC ETC.) INDICATED IN QP SHALL BE REFERRED.

LEGENDS:

- *RECORDS, IDENTIFIED WITH "TICK"(✓) SHALL BE ESSENTIALLY INCLUDED BY SUPPLIER IN QA DOCUMENTATION.
- ** M: SUPPLIER/ MANUFACTURER/ SUB-SUPPLIER, B: MAIN SUPPLIER/ BHEL/ THIRD PARTY INSPECTION AGENCY, C: CUSTOMER,
- P: PERFORM, W: WITNESS, V: VERIFICATION, AS APPROPRIATE
- MA: MAJOR, MI: MINOR, CR: CRITICAL
- D: DOCUMENT

BHEL			
ENGINEERING		QUALITY	
Sign & Date	Name	Sign & Date	Name
Prepared by: HEMA KUSHWAHA	HEMA KUSHWAHA	Checked by:	KUNAL GANDHI
Reviewed by: PRAVEEN DUTTA	PRAVEEN DUTTA	Reviewed by:	R K JAISWAL

BIDDER/ SUPPLIER	
Sign & Date	
Seal	

FOR CUSTOMER REVIEW & APPROVAL			
Doc No:		Sign & Date	Seal
Reviewed by:			
Approved by:			

Sub-section-IIB

ANNEXURE-I


SUB-VENDOR LIST

The list of approved make of the LT Motors are as mentioned below:

S.No.	LIST OF LT MOTORS
1.	BHARAT BIJLEE LTD.
2.	CROMPTON GREAVES
3.	ASEA BROWN BOVERI
4.	KIRLOSKAR ELECTRIC CO LTD.
5.	NGEF
6.	SIEMENS
7.	MARATHON
8.	GE-POWER
9.	RAJINDRA ELECT INDUSTRIES
10.	LAXMI HYDRAULICS PVT. LTD

However, the final list of makes for the LT Motors is subjected to BHEL/Customer approval, during contract stage, without any commercial implications.

735230/2022/PS-PEM-MSE

	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001
		SECTION: III
		SUB-SECTION:
		REV. NO. 00 DATE 04.03.2022
		SHEET 1 OF 1

STANDARD TECHNICAL REQUIREMENTS**SECTION III****DOCUMENTS TO BE SUBMITTED BY BIDDER**

735230/2022/PS-PEM-MSE



TITLE:

TECHNICAL SPECIFICATION
MISCELLANEOUS PUMPS

STANDARD TECHNICAL REQUIREMENTS

SPEC. NO.: **PE-TS-439-100-N001**SECTION: **IIIA**


SUB-SECTION:

REV. NO. **00** DATE 04.03.2022SHEET **1** OF **1**

SECTION IIIA

GUARANTEE SCHEDULE
(TO BE SUBMITTED ALONG WITH THE BID BY ALL BIDDERS)

735230/2022/PS-PEM-MSE



SPECIFICATION NO.:

PE-TS-439-100-N001, Rev-00

SCHEDULE OF PERFORMANCE GUARANTEES

VOLUME:

--

SECTION:

IIIA

Sheet 1 of 1

1X800MW KOTHAGUDEM TPS UNIT-12 (FGD), TELANGANA

REV. NO.

00

DATE:

03.03.2022

Following parameters are guaranteed for following pumps

Sl. No.	Pump Description	Guaranteed Capacity	Guaranteed TDH	Guaranteed Pump Eff.	Guaranteed Motor Eff.	Guaranteed Power consumption at inlet to motor terminals	Motor Rating	Motor GD ² Value for HT motor only	Pump RPM	T/S Curve attached for HT motor
		(M3/Hr)	(MWC)	%	%	(KW)	(KW)			
	Vertical Pumps									
1	#FGD MAKE UP WATER PUMPS	150	50					NA		NA

Note:

1 # Bid evaluation and LD is applicable for these pumps only as per clause 4.00.00 of Section-IIA, Data Sheet-A of Section-ID and clause 1.8 of Section IA of Technical Specification for pumps.

We the undersigned hereby undertake to meet the performance guarantees as listed in the table above on the conditions as elsewhere specified. Any variation of the specified conditions during official tests will be taken in account by the customer

PARTICULARS OF BIDDER/ AUTHORISED REPRESENTATIVE

NAME	DESIGNATION	SIGNATURE	DATE	COMPANY SEAL
------	-------------	-----------	------	--------------

735230/2022/PS-PEM-MSE



TITLE:

TECHNICAL SPECIFICATION
MISCELLANEOUS PUMPS

STANDARD TECHNICAL REQUIREMENTS

SPEC. NO.: **PE-TS-439-100-N001**SECTION: **IIIB**


SUB-SECTION:

REV. NO. **00** DATE 04.03.2022SHEET **1** OF **1**

SECTION IIIB

COMPLIANCE CERTIFICATE
(TO BE SUBMITTED ALONG WITH THE BID BY ALL BIDDERS)

735230/2022/PS-PEM-MSE

	TECHNICAL SPECIFICATIONS MISCELLANEOUS PUMPS	SPECIFICATION NO.:	PE-TS-439-100-N001, Rev.0		
	1X800 MW TSGENCO KOTHAGUDAM TPS STAGE -VII, PALONCHA (FGD Pkg.)	VOLUME:	--	SECTION:	IIIB
	COMPLIANCE CERTIFICATE	REV. NO.	0	DATE:	04.03.2022

The bidder shall confirm compliance with following by signing/ stamping this compliance certificate and furnish same with the offer.

- a) The scope of supply, technical details, construction features, design parameters etc. shall be as per technical specification & there are no exclusions/ deviations with regard to same.
- b) QP/ test procedures shall be submitted in the event of order based on the guidelines given in the specification & QP enclosed therein.

QP will be subject to BHEL/ CONSULTANT/ CUSTOMER approval in the event of order & customer hold points for inspection/ testing shall be marked in the QP at the contract stage. Inspection/ testing shall be witnessed as per same apart from review of various test certificates/ Inspection records etc.
- c) All drawings/data – sheets etc. to be submitted during contract shall be subject to BHEL/ CONSULTANT/ CUSTOMER approval.
- d) There are no other deviation with respect to specification other than those furnished in the 'Schedule of Deviations'.
- e) Bidder shall include the cost of Mandatory Spares, unless specified otherwise in Sec-IA of the specification or NIT.


Any mandatory spares stated as not applicable, shall have to be supplied without any cost implication to BHEL in the event they are found to be applicable during detail engineering stage.
- f) The offered materials should be either equivalent or superior to those specified. Also for components where material is not specified it shall be suitable for intended duty. All materials shall be subject to approval in the event of order.
- g) Prices for recommended spares (if any) for 3 years operation shall be furnished separately & not included in the base price.
- h) The commissioning spares (if any) are supplied on 'As Required Basis' & prices for same included in the base price (If bidders reply to this is "No commissioning spares are required" and if some spares are actually required during commissioning same shall be supplied by bidder without any cost to BHEL).
- i) All sub vendors shall be as per BHEL/CONSULTANT/CUSTOMER approved list.
- j) Tests for noise, vibration, parallel running etc. for pumps shall be conducted at site by Pump Vendor/BHEL as per cl. no. 3.04.00 of Section-IIA and if the site performance is found not meeting the requirements in any respect as specified, than the equipment shall be rectified or replaced by the vendor, at his own cost.
- k) Any special tools & tackles, if required, shall be in bidder's scope.
- l) All models offered have been supplied by bidder in the past and are meeting the experience qualifying criteria of BHEL/CONSULTANT/CUSTOMER (viz. offered model is successfully operating in two separate stations for at least one year or as specified in technical PQR). Any deviation to this criteria shall be suitably highlighted in deviation schedule.
- m) All selected motor ratings have minimum margins as per Datasheet A, Section ID.

We the undersigned hereby undertake to meet the compliance requirements as listed above on the conditions as elsewhere specified.

PARTICULARS OF BIDDER/ AUTHORISED REPRESENTATIVE

NAME	DESIGNATION	SIGNATURE	DATE	COMPANY SEAL
------	-------------	-----------	------	--------------


735230/2022/PS-PEM-MSE

	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001	
		SECTION: IIIC	
		SUB-SECTION:	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1	OF 1

STANDARD TECHNICAL REQUIREMENTS**SECTION IIIC**

DEVIATION SCHEDULE
(TO BE SUBMITTED ALONG WITH THE BID BY ALL BIDDERS AS PER
NIT FORMAT)

735230/2022/PS-PEM-MSE

	TECHNICAL SPECIFICATION MISCELLANEOUS PUMPS	SPEC. NO.: PE-TS-439-100-N001	
		SECTION: IIID	
		SUB-SECTION:	
		REV. NO. 00	DATE 04.03.2022
		SHEET 1	OF 1

STANDARD TECHNICAL REQUIREMENTS**SECTION IIID****DATA SHEET – B FOR PUMPS****ELECTRICAL LOAD DATA (FORMAT ATTACHED)****CABLE SCHEDULE (FORMAT ATTACHED)****MOTOR DATASHEET**

**(TO BE SUBMITTED BY SUCCESSFUL BIDDER AFTER AWARD OF
CONTRACT)**

735230/2022/PS-PEM-MSE

PROJECT:
MISCELLANEOUS PUMPS
DATASHEET - B


SL.	DESCRIPTION	UOM	PUMP DATA
1.0	GENERAL		
1.1	Designation of the Pump		
1.2	Manufacturer		
1.3	Model No.		
1.4	No. of pumps	Nos.	
1.5	System Design Pressure	Kg/cm ²	
1.6	Specific Gravity of fluid to be handled	-	
2.0	PERFORMANCE PARAMETERS		
2.1	Performance standard		
2.2	Rated capacity. (No negative tolerance)	M ³ /hr	
2.3	Total Dynamic Head (TDH) at rated capacity (No negative tolerance)	MWC	
2.4	Shut off head	MWC	
2.5	Range of Operation of the Pump		
	a) Min.Flow	M ³ /hr	
	b) Max.Flow	M ³ /hr	
2.6	The pumps offered have continuously rising head capacity curves from the duty point towards shut off point.		
2.7	The pumps offered have stable rising H-Q curves within the "Range of Operation"		
2.8	Pump rated speed	RPM	
2.9	Vibration measurements (2.9.2 is applicable in addition to 2.9.1 for Pumps with speed less than 600 RPM)		
2.9.1	Max.value of vibration on any pump /motor bearing w.r.t. velocity (Vrms) as per ANSI/ HIS 9.6.4 for speed > 600 RPM		
	a) Guaranteed at manufacturer's works	mm/s	
	b) Guaranteed at site	mm/s	
2.9.2	Max.value of vibration on any pump /motor bearing w.r.t. peak to peak amplitude as per ANSI/ HIS 9.6.4 for speed <= 600 RPM		
	a) Guaranteed at manufacturer's works	microns	
	b) Guaranteed at site	microns	
2.10	Max. noise Level (Guaranteed at site)	dB	
2.11	Guaranteed Pump efficiency at rated head & rated capacity without -ve tolerance	%	
2.12	Power consumption		
	a) Guaranteed pump input power at duty point	KW	
	b) Guaranteed max. Pump input power within range of operation.	KW	
	c) Max. pump input power at shut off	KW	
	d) Guranteed power at motor input	KW	
2.13	NPSH required at rated capacity	MWC	
3.0	DESIGN & CONSTRUCTION FEATURES		
3.1	Type of pump casing		
3.2	Pump duty		
3.3	Type of Impeller		
3.4	Location		
3.5	Pump suitable for parallel operation		
3.6	Torque speed curve of the pump & drive motor furnished for pumps with drive motor rating of 100 KW and above.		
3.7	Pump number of stages		

735230/2022/PS-PEM-MSE


PROJECT:
MISCELLANEOUS PUMPS
DATASHEET - B

SL.	DESCRIPTION	UOM	PUMP DATA
3.8	Specific speed $N = \frac{\text{RPM} \times (\text{Flow in USGPM})^{1/2}}{(\text{Head in Ft.})^{3/4}}$		
3.9	Minimum suction head required in MLC for pump operation at maximum discharge point within the 'Range of Operation' specified (NPSHR at max. flow).		
3.10	Whether pump is suitable/designed so that pump internals can be attended without disturbing suction and discharge piping.		
3.11	Type of coupling between pump & motor		
3.12	Bearing (DE & NDE)		
	a) Type and manufacturer		
	b) Bearing no.		
	c) Type of lubrication		
	d) Design life (Hrs.)		
3.13	Shaft Sealing arrangement		
	a) Type and manufacturer		
	b) Sealing liquid		
	c) Requirement of external water if any		
	i) Quality		
	ii) Quantity/ Pump	M ³ /hr	
3.14	In case separate oil/grease/water pump or any such equipment required for bearing lubrication/stuffing box gland sealing, furnish full technical details of these equipment and their drive.		
4.0	MATERIAL OF CONSTRUCTION (Indicate applicable code/ standard)		
4.1	Casing		
4.2	Impeller		
4.3	Shaft		
4.4	Shaft sleeves		
4.5	Wear ring		
4.6	fasteners		
4.7	Gland		
4.8	Lantern ring		
4.9	Mechanical seals (faces)/		
	Gland packing		
4.10	Base plate		
5.0	CONNECTIONS AND OTHER DIMENSIONAL DETAILS		
5.1	Impeller diameter	mm	
6.0	DRIVE DATA		
6.1	Drive unit output at 50°C ambient condition	KW/ P	
7.0	INSPECTION & TESTING		
7.1	Material test		
7.2	Hydrostatic test pressure	Kg/cm ²	
7.3	Hydrostatic test duration	Min.	
7.4	Performance test on pump at shop		
7.5	Dyanamic balance test		
8.0	WEIGHT AND LOADING DATA		
8.1	Weight of the pump & drive assembly	Kg	
8.2	Weight of the heaviest piece to be handled	Kg	

735230/2022/PS-PEM-MSE

		PROJECT:	
		MISCELLANEOUS PUMPS DATASHEET - B	
SL.	DESCRIPTION	UOM	PUMP DATA
8.3	Size of base plate (length x width)	mm	
9.0	ADDITIONAL INFORMATION FOR VERTICAL PUMPS		
9.1	Type of pump		
9.2	No. of stages for Vertical Turbine Pump	Nos.	
9.3	Bowl Head	MLC	
9.4	Bowl Efficiency	%	
9.5	Setting Length	m	
9.6	Column pipe OD X Thickness	mm X mm	
9.7	No of column pieces	Nos.	
9.8	No of intermediate shafts	Nos.	
9.9	No of bearings	Nos.	
9.10	Type & make of Bearing		
9.11	Sealing/lubrication arrangement of bearings		
9.12	Capacity of overhead forced lubrication tank	m ³	
9.13	Nos of forced lubrication pumps	Nos.	
9.14	Capacity of forced lubrication pumps	m ³ /Hr	
9.15	TDH of forced lubrication pumps	MLC	

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LT MOTORS**A. GENERAL**

1. Manufacturer & Country of origin.
(Shall be as per approved QA make)

2. Equipment driven by motor

3. Motor type

4. Quantity

B. DESIGN AND PERFORMANCE DATA

1. Frame size

2. Type of duty

3. Type of enclosure /Method of cooling/Degree of protection

4. Applicable standard to which motor generally conforms

5. Efficiency class as per IS 12615

6. (a) Whether motor is flame proof Yes/No

(b) If yes, the gas group to which it conforms as per IS:2148

7. Type of mounting

8. Direction of rotation as viewed from DE END__

9. Standard continuous rating at 40 deg.C. ambient temp. as per Indian Standard (KW)

10. Derated rating for specified normal condition i.e. 50 deg. C ambient temperature (KW)


11. Maximum continuous load demand of driven equipment in KW

12. Rated Voltage (volts)

13. Permissible variation of :

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- a. Voltage (Volts)
 - b. Frequency (Hz)
 - c. Combined voltage and frequency
14. Rated speed at rated voltage and frequency(RPM)
15. At rated Voltage and frequency:
 - a. Full load current
 - b. No load current
16. Power Factor at
 - a. 100% load
 - b. NO load
 - c. Starting.
17. Efficiency at rated voltage and frequency,
 - a. 100% load
 - b. 75% load
 - c. 50% load
18. Starting current (amps) at
 - a. 100 % voltage
 - b. 85% voltage
 - c. 80% voltage
19. Minimum permissible starting Voltage (Volts)
20. Starting time with minimum permissible voltage
 - a. Without driven equipment coupled
 - b. With driven equipment coupled

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21. Safe stall time with 100% and 110% of rated voltage
 - a. From hot condition
 - b. From cold condition
22. Torques :
 - a. Starting torque at min. permissible voltage(kg-mtr.)
 - b. Pull up torque at rated voltage.
 - c. Pull out torque
 - d. Min accelerating torque (kg.m) available
 - e. Rated torque (kg.m)
23. Stator winding resistance per phase (ohms at 20 Deg.C.)
24. GD^2 value of motors
25. No of permissible successive starts when motor is in hot condition
26. Locked Rotor KVA Input
27. Locked Rotor KVA/KW
28. Vibration limit :Velocity (mm/s)
29. Noise level limit (dBA)

C. CONSTRUCTIONAL FEATURES

1. Stator winding insulation
 - a. Class & Type
 - b. Winding Insulation Process
 - c. Tropicalised (Yes/No)

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- d. Temperature rise over specified maximum ambient temperature of 50 deg C
 - e. Method of temperature measurement
 - f. Stator winding connection
2. Main Terminal Box
 - a. Type
 - b. Location (viewed from NDE side)
 - c. Entry of cables(bottom/side)
 - d. Recommended cable size (To be matched with cable size envisaged by owner)
 - e. Fault level (MVA), Fault level duration (sec)
 - f. Cable glands & lugs details (shall be suitable for power cable)
3. Type of DE/NDE Bearing
4. Motor Paint shade
5. Weight of
 - a. Motor stator (KG)
 - b. Motor Rotor (KG)
 - c. Total weight (KG)
- D. List of accessories.**
 1. Space Heaters (Applicable for 30 KW & above motor) (Nos./Power in watts/supply voltage)
 2. Terminal Box for Space Heater (Yes/No)
 3. Speed switch (Yes/No)
No of contacts and contact ratings of speed switch

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4. Insulation of bearing (Yes/No)

5. Noise reducer(Yes/No)

6. Grounding pads

i) No and size on motor body

ii) Nos on terminal Box

7. Vibration pads

i) Nos and size

ii) Location

8. Any other fitments

E. List of curves.

1. Torque speed characteristic of the motor

2. Thermal withstand characteristic

3. Starting. current Vs. Time

4. Starting. current Vs speed

5. P.F. and Effi. Vs Load

F. Additional Data to be filled for each rating of DC Motor

1. Rated armature voltage (Volt)

2. Rated field excitation (Amp)

3. Permissible % variation in voltage

4. Minimum Permissible Starting voltage (volt)


5. At rated voltage

i) Full load Armature current.(Amp)

ii) Full load Field current (Amp)

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- iii) No load Armature current (Amp)
6. Full load Field current (Amp)
7. No load Armature current (Amp)
8. Minimum permissible field current(Amp) to avoid overspeeding at
 - i) Maximum permissible voltage
 - ii) Rated voltage
 - iii) Minimum Permissible Voltage
9. Resistance (indicative Values) in ohm
 - i) Armature winding (Arm + IP + Series) at 25 deg.C
 - ii) Field Winding at 25 deg. C
10. Inductance (indicative values)
 - i) Armature winding
 - ii) Field winding
11. Value of trimmer resistance (ohm) to be connected in series with the shunt field to obtain rated speed at
 - i) 220 V DC
 - ii) 250 V DC
 - iii) 187 V DC
12. Value of the external resistance (ohm) required to be connected in series with armature during starting only
13. Technical data sheet for external resistance box
14. GA drawing of motor
15. Starting time calculation

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16. Starter resistance design calculation
17. Electrical connection diagram of motor

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