



**Bharat Heavy Electricals Limited**  
**(A Govt. of India undertaking)**  
Boiler Auxiliaries Plant, Ranipet – 632 406, Tamilnadu.

### Part Processing

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Ref.: BHEL/BAP/PP/VTL

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***BHEL-Ranipet invites Expression of Interest(EOI) from vendors having facilities with specifications as below***

#### 1.Vertical Turning Lathe I

- a)Table with dia 1.2 meters minimum
- b)Maximum weight of job loaded on table:2 tons
- c)Grinding attachment preferable
- d)Accuracy of machining:0.01mm
- e)Machine should be able to produce surface finishing 1.6 micron Ra at dia 150mm

#### 2.Horizontal Boring Machine

- a)Table size around 1.2meters (Round/Square)
- b)Maximum weight of job loaded on table:2 tons
- c) Table with indexing (C axis) with accuracy 0.02 degrees
- d)CNC controller(Siemens/Fanuc/Fagor) preferable
- e)Spindle dia 100mm to 130 mm
- f)Auto Tool Changer(ATC)preferable
- g)Accuracy of machining:0.01mm
- h)Surface finish1.6 micron

#### 3. Vertical Turning Lathe II

- 1. Table dia 4000mm minimum
  - 2.Swing between column 5000mm minimum
  - 3.Maximum height of the job to be faced 1675mm
  - 4.Z vertical movement 1400mm minimum
  - 5.Loading on the machine 15 tons.(Handling facility is must)
  - 6.Machining accuracy is 0.02mm
- Machine should have a DRO (Digital Read Out) for axes  
Not necessarily a CNC machine  
Machine shall be able to produce a surface finish of 1.6 micron Ra at Dia 1100mm.  
A buffing attachment or grinding attachment is preferable.

#### 4.Vertical Turning Lathe III

- 1.Table dia 5000 mm minimum
  - 2.Swing between column 6400mm minimum ((Maximum dia that has to rotate)
  - 3 Maximum height of the job to be faced 2900mm
  - 4.Z vertical movement/approach with a rigid boring bar 2068 mm minimum
  - 5.Loading on the machine 18 Tons (Handling facility is must)
  - 6.Machining accuracy is 0.02mm
- Machine should have a DRO (Digital Read Out) for axes.  
Not necessarily a CNC machine  
Machine shall be able to produce a surface finish of 1.6 micron Ra at Dia 800mm.  
A buffing attachment or grinding attachment is preferable.

*Applications expressing interest should reach the undersigned on or before 21 days from the date of advertisement.*

SM/Part Processing