

Technical Specifications of modular assembly table

This specification covers technical requirement, scope of Transformer tank welding positioner with clamps

1. Scope of supply:

Design, manufacturing, supply, installation and commissioning of Transformer tank welding positioner with clamps. All type of clamps, Ref: Annexure:02 must be suitable for weld positioner hole, pitch etc in all manner.

2. Drawings

The dimensions and detailed sketch are provided in technical requirement (Annexure :1 , page no 02)

3. Technical requirement

- a) Size: 3600x2000mm with side clamping provision
- b) Flatness of surface less than 0.3mm per meter
- c) Table Top plate thickness minimum: 15.0mm
- d) Standard Hole diameter for clamps, preferable: top surface hole pitch 50x50mm, suitable hole of 16mm for clamps
- e) CNC machined holes for clamping accessories fixing for achieving accurate jobs (repeatability)
- f) Surface material: Steel IS2062
- g) Frame material: Steel IS2063
- h) Case depth of Nitriding minimum: 0.01 – 0.02mm
- i) Surface Hardness minimum: VICKERS HARDNESS HV 450 or Rockwell C Scale Hardness HRC 45.9
- j) Co-efficient of friction ($\mu = F/L$) = 0.37
- k) Loading capacity minimum: 1 MT
- l) Top surface must be anti-corrosive, Anti spatter, wear resistive and tough.
- m) Bottom stand must be painted to avoid rusting.
- n) Height adjustment leveling pad at welding positioner /table required.
- o) **Must have provision for module addition or removal.**
- p) **welding positioner /table required 3D option for side clamping, suitable 3D brackets required.**

4. Certificate required:

- a) NABL lab test certificate for Mechanical & chemical properties of the material supplied.
- b) Bidder has to submit performance / Execution certificate from at least two customers
- c) Calibration certificate required

5. Manuals required:

- 1 set of Operation & maintenance manual.
- 1 set of soft copy.

6. Erection and commissioning

Demonstration, erection and commissioning with leveling arrangement in all X, Y & Z direction of total system (welding positioner with clamps) and fixing procedure of the system /equipment to be done by supplier at BHEL CFP Rudrapur.

7. Warranty:

Minimum one-year warranty from date of commissioning.

8. Inspection:

BHEL/Third party quality check before dispatch.

9. Make of equipment:

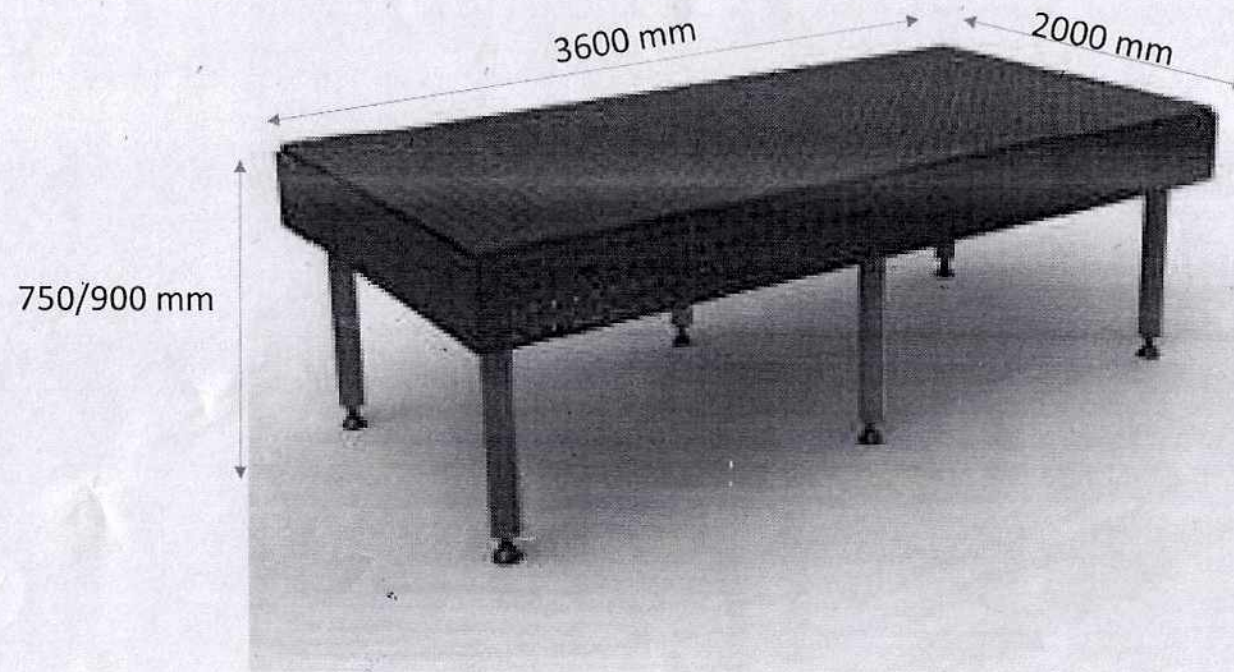
Supplier has to declare make of all the equipment's during technical evaluation.

Note: Non acceptance /submission of above is liable for rejection on T/C bid

Outer dimensions of Modular table for welding accurate jobs

Annexure:1

$L \times W \times H = 3600 \times 2000 \times 750/900\text{mm}$



Annexure-1
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