

ITEM:-SPADE DRILL PACKAGE

Supply & Successful establishment of Spade Drill , Item No. 1:-for drilling of Hole dia 65mm, drill depth= min 880mm ; item no. 2:- for drilling of Hole dia 100 mm, drill depth= min 880 mm on Jobs(Having Hardness upto 350 BHN) by using Spade drill having coated single HSS drill insert as per following details :

POINT NO.	REQUIREMENT TO BE COMPLIED				VENDOR'S CONFIRMATION
1	Vendor to offer tooling package for drilling of Hole dia 65mm,100mm respectively for item no. 1,2 with working length= min 880mm using Spade Drill having single drill insert of suitable coating with external coolant on Jobs(Having Hardness upto 350 BHN) achieving Cylindricity within 1mm/meter, Surface Finish within 12.5 micron. The mounting of drill on the machine shall be through Drill Sleeve Adaptor & Reduction Sleeve(To be provided By CFFP BHEL).				VENDOR TO CONFORM
2	Quantity : Tooling package shall consist of following items				VENDOR TO CONFORM
	ITEM NO.	Part No.	ITEM PARTS DETAIL	Qty.	
	1	a.	Holder for Drill insert dia 65mm, Working Length = min 880 mm suitable with external coolant arrangement	1 Nos	
		b.	Dia 65mm HSS Drill insert	15 Nos.	
	2	a.	Holder for Drill insert dia 100mm, Working Length = min 880 mm suitable with external coolant arrangement	1 Nos	
3	The drill holders should be hardened & tempered with proper flute depth(Flute area should be at least 40% of cross sectional area of Holder) for smooth chip flow. Coolant flow should be proper, adequate and should not be obstructed by insert seating.				VENDOR TO CONFORM
4	The HSS drill insert should be of suitable grade and insert geometry & coating shall be suitable for smooth chip flow, chip breaking & productive machining.				VENDOR TO CONFORM
5	The offered drilling system should be complete with external coolant arrangement as only external coolant system is available on the machine.				VENDOR TO CONFORM
6	Tool life of one drill insert : 3.5 meter (min) – should be obtained while drilling on Jobs(Having Hardness upto 350 BHN).				VENDOR TO CONFORM
7	L1 status shall be evaluated separately for both items i.e. for full package of item no. 1,2 comprising of part no. a,b for item no. 1 & part no. a for item no. 2 as specified at point no. 2 against item. Full package of item no. 1,2 comprising of part no. a,b for item no. 1 & part no. a for item no. 2 as specified at point no. 2 , will be procured from L-1 vendor only due to compatibility reason.				VENDOR TO CONFORM
8	Final acceptance shall be given by BHEL after successful establishment of supplied item by the vendor at BHEL, CFFP Haridwar by carrying out drilling operation making holes (with holders meeting requirement as mentioned at point no.3) meeting required drill dia,depth, Cylindricity, Surface Finish as mentioned at point no. 1 & achieving tool life as mentioned at point no. 6. The above machining shall be carried out on Conventional Horizontal Borer having spindle dia. 200mm, Spindle Power 70 Kw,Max working RPM 80, spindle taper metric 120(Drill Sleeve Adaptor & Reduction sleeve to make Machine Spindle Taper MT-5/6 will be provided by BHEL CFFP) on mutually agreed schedule as per availability of component & machine.(Vendor may depute their representative at the time of establishment.				VENDOR TO CONFORM
9	If the process & tools could not be established in one go, the vendor will be given one more chance to improve upon and establish the machining through change of Holder/insert/spares,process etc. In case of failure even in second chance, the supplied lot for concerned item(including Holder, insert ,spares etc) shall be declared as rejected.				VENDOR TO CONFORM & PROVIDE REQUIRED DOCUMENTS
10	The payment shall be made subject to final acceptance by BHEL after successful establishment of supplied items by the vendor as per Final acceptance criteria mentioned above at point no. 1,Point No.3 and point no.6				VENDOR TO CONFORM
11	The offer should be complete having list & quantity of each item offered with separate price bid, technical details, drgs. & catalogue pages etc. for clear understanding of the offer. In case, vendor requires any clarification, they may discuss with BHEL prior to submission of their offer to avoid any gaps at later stage.				VENDOR TO CONFORM
12	In case of addition of any new item, if so required by the vendor, for successful establishment of supplied items, the same shall be supplied by the vendor without any financial implications to BHEL.				VENDOR TO CONFORM
13	In case of damage to any item during establishment of required machining due to wrong machining strategy, wrong tool selection or cutting parameters, supply of improper insert or it's Holder, improper fitting of inserts in Holders etc., the same shall be replaced by the vendor without any financial implications to BHEL.				VENDOR TO CONFORM
14	Guarantee Certificate required with minimum guaranty period of 12 months from the date of acceptance of material.				VENDOR TO CONFORM