

BHARAT HEAVY ELECTRICAL LIMITED, BHOPAL



PQR CUM ANNEXURE-1 TO P.1.821/192008

SPECIFICATION CUM COMPLIANCE CERTIFICATE OF INDEXABLE DEEP GROOVING & PARTING TOOL

NOTE:-

1. Vendor must submit complete information against clause no. 1.0 to 7.3. The offer meeting this clause would only be processed
2. The "Offered" Column and where applicable, the "Deviations" & "Remarks" Column of this format shall be filled in by the Vendor and submitted along with the offer. Inadequate / incomplete, ambiguous, or unsustainable information against any of the clauses of the specifications/requirements shall be treated as non-compliance.
3. The offer and all documents enclosed with offer should be in English language only.
4. The information provided by vendor in specification cum compliance certificate will supersede any other information provided by vendor.

NAME & ADDRESS OF THE SUPPLIER :

E-MAIL ADDRESS :

SCOPE: SUPPLY OF INDEXABLE GROOVING & PARTING TOOL WIDTH: 6.0 MM, 8.0 MM & 10.0 MM

SNO	DESCRIPTION FOR BHEL REQUIREMENT	SPECIFIED / CONFIRMED BY	OFFERED	REMARK
1	PURPOSE: This sheet deals with specification of indexable deep grooving & parting tool, width: 6.0 mm, 8.0 mm & 10.0 mm capable of parting operation in 150 mm deep in hardened alloy steel bar dia. 300.00 mm.	Vendor to note		
1A	Supply and proving of: INDEXABLE DEEP GROOVING AND PARTING TOOL, WIDTH 6.0 MM, 8.0 MM & 10.0 MM IN SET (EACH SET CONSISTS OF 50 PVD COATED, CARBIDE INSERT +1 DOUBLE ENDED CUTOFF/ PARTING BLADE HAVING CAPABILITY OF GROOVING AND PARTING RADIALY+1 CUT OFF BLOCK)	Vendor to Confirm		
2	Specification of carbide insert and grooving & parting tool width 6.0mm			
2.1	Blade length (Min.) : 260.00 mm	Vendor to confirm		
2.2	Blade width (Min.) : 52.00 mm	Vendor to confirm		
2.3	Blade thickness (Min.) : 06.0 mm	Vendor to confirm		
2.4	Square cut off block length (Min.) : 135.0 mm	Vendor to confirm		
2.5	Square cut off block width (Min.) : 40.0 mm	Vendor to confirm		
2.6	Square cut off block height (Min.) : 35.0 mm	Vendor to confirm		

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2.7	Total block height including integral clamping (Min.)	: 80.0 mm	Vendor to confirm	
2.8	Cutting width (Min.)	: 6.0 mm	Vendor to confirm	
2.9	Insert Corner radius L & R range (Within)	: 0.15-0.3 mm	Vendor to confirm & specify	
2.9.1	Inscribe clearance angle (Within)	: 6-10 degree	Vendor to confirm & specify	
2.9.2	Depth of cut "ap" (Min.)	: 1.75 mm	Vendor to confirm	
2.9.3	Cutting speed in "P" grade material (Vc)	: 150-180 m/min	Vendor to confirm & specify	
2.9.4	Plunge feed (Within)	: 0.08-0.2 mm/rev	Vendor to confirm & specify	
3	Specification of carbide insert and grooving & parting tool width 8.0mm			
3.1	Blade length (Min.)	: 260.00 mm	Vendor to confirm	
3.2	Blade width (Min.)	: 52.00 mm	Vendor to confirm	
3.3	Blade thickness (Min.)	: 08.0 mm	Vendor to confirm	
3.4	Square cut off block length (Min.)	: 135.0 mm	Vendor to confirm	
3.5	Square cut off block width (Min.)	: 40.0 mm	Vendor to confirm	
3.6	Square cut off block height (Min.)	: 35.0 mm	Vendor to confirm	
3.7	Total block height including integral clamping	: 80.0 mm	Vendor to confirm	
3.8	Cutting width (Min.)	: 8.0 mm	Vendor to confirm	
3.9	Insert Corner radius L & R range (Within)	: 0.2-0.3 mm	Vendor to confirm & specify	
3.9.1	Inscribe clearance angle (Within)	: 6-10 degree	Vendor to confirm & specify	
3.9.2	Depth of cut "ap" (Min.)	: 1.75 mm	Vendor to confirm	
3.9.3	Cutting speed in "P" grade material (Vc)	: 150-180 m/min	Vendor to confirm & specify	
3.9.4	Plunge feed (Within)	: 0.08-0.2 mm/rev	Vendor to confirm & specify	
4	Specification of carbide insert and grooving & parting tool width 10.0mm			
4.1	Blade length (Min.)	: 260.00 mm	Vendor to confirm	
4.2	Blade width (Min.)	: 52.00 mm	Vendor to confirm	
4.3	Blade thickness (Min.)	: 06.0 mm	Vendor to confirm	
4.4	Square cut off block length (Min.)	: 135.0 mm	Vendor to confirm	
4.5	Square cut off block width (Min.)	: 40.0 mm	Vendor to confirm	
4.6	Square cut off block height (Min.)	: 35.0 mm	Vendor to confirm	
4.7	Total block height including integral clamping	: 80.0 mm	Vendor to confirm	
4.8	Cutting width (Min.)	: 6.0 mm	Vendor to confirm	
4.9	Insert Corner radius L & R range (Within)	: 0.2-0.3 mm	Vendor to confirm & specify	
4.9.1	Inscribe clearance angle (Within)	: 6-10 degree	Vendor to confirm & specify	
4.9.2	Depth of cut "ap" (Min.)	: 1.75 mm	Vendor to confirm	
4.9.3	Cutting speed in "P" grade material (Vc)	: 150-180 m/min	Vendor to confirm & specify	
4.9.4	Plunge feed (Within)	: 0.08-0.2 mm/rev	Vendor to confirm & specify	

5 Carbide insert should have PVD coated wear & heat resistant and proper chip evacuation & breaking geometry without coolant cutting oil.		Vendor to confirm		
5.1	Spare insert clamping screw suitable to parting blade & block.	Suitable for cutter body	Vendor to confirm	
5.2	Spare tool/ alien key suitable for screw insert	Suitable for insert head	Vendor to confirm	
5.3	Prefarable makes are: ISCAR, TUNGALOY, MITSUBISHI, MINATIG, TAAGUTECH, WIDIA, SANDVIK, WALTER KENNAMETAL OR EQUIVALENT	Vendor to specify		
5.4	All Standard accessories/ items (if Any) shall be in the scope of vendor enable us ready to use the face milling cutter.	Vendor to confirm		
6 QUALIFYING CONDITIONS :				
6.1	Only OEM or their authorized distributor / dealer has to be quoted in this regard. Vendors other than OEM are need to be furnished an authorization certificate ensuring BHEL for their guarantee support and warranty services/ For a period of 12 months from the date of receiving of material at our works) as and when required by BHEL on prompt basis		Vendor to confirm (OEM/Dealer) & submitted	
6.2	Only those vendors shall quote, who or their principal have supplied and commissioned at least one number of grooving & parting tool set of width 8.0 mm or higher size in past three years effective from tender opening date and such parting & grooving tool is presently working satisfactorily for at least one years after commissioning, mentioning the customer detail, else offer is technically disqualified without notice to the vendor.		Vendor to submitted customer(s) details	
6.3	Model/ Part No of the supplied parting & grooving tool shall be working satisfactorily at least from last one year of Supply . PO copy shall be required along with offer, else offer is technically disqualified without notice to the Vendor.		Vendor to submitted PO copy	
6.4	Average annual turnover of the company should be at least Rs. 3,00,000 or more and it should be supported by balance sheet and profit & loss account vetted by chartered accountant or income Tax Return of the party for last three financial years & self certified last 3 years profit & loss account transaction in case of small scale industry/ Vendor those not comes under the boudation of audit as per government/ income tax rules (if the party is registered in BHEL, BHOPAL with permanent vendor code should be opted to last three year PO executed to BHEL, BHOPAL with cumulative value equal to order value.		Vendor to submitted (Registered vendor have to specify vendor code & VPR)	
6.5	PRODUCT CATALOGUE CONTAINING TECHNICAL LITERATURE MUST BE SUBMITTED FOR ALL THE ITEMS TO JUDGE TECHNICAL PARAMETERS ELSE QUOTATION IS TREATED AS INCOMPLETE AND LIABLE TO BE REJECTED WITHOUT NOTICE TO THE BIDDER.		Vendor to submitted	
6.6	Vendor shall have fully functional Service Centre in India. Details about the same to be provided.		Vendor to specify & submitted provide detail	

7	General:			
7.1	Supplier will be solely responsible for the supply and proving the indeniable parting & proving tool at BHEL works. Actual job shall be proved at Bhopal in all respect for accuracy and performance during commissioning	Vendor to note		
7.2	BHEL reserves the right to verify information provided by vendor. In case the information provided by vendor is found to be false incorrect, the offer shall be rejected.	Vendor to note		
7.3	Approximate time of delivery 10-12 weeks (Ex-works). However 2 week shall be given delivery term as FOR BHEL. Bhopal works. Delivery beyond 14 weeks shall be technically rejected without intimation to the vendor.	Vendor to confirm & specify		


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