



भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
Bharat Heavy Electricals Limited, Bhopal

FEEDERS MAINTENANCE DIVISION

TGM MAINT. DEPARTMENT

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Scope of Work

Tender Enquiry No. FDX/TGM/20-21/PM/03 (R.T.)

Dtd. :25.09.2020

Due Date: 05.10.2020 Time: 2:00 PM

Sub:- Scope of Work for Preventive Maintenance & Calibration Contract under AMC for Wenzel CNC Gear Tester machine, Model No WGT1000 and BHEL Item No. 14/B/2112 in TGM Div.

Machine will be calibrated as per OEM standard. Calibration cum preventive visit will cover following works.

1st VISIT: SCOPE OF WORK UNDER CALIBRATION CUM PREVENTIVE VISIT.

- Calibration will be done as per standard norms of Wenzel. This will cover checking and setting of all geometrical accuracies of the machine as per specification given by Wenzel. All calibration activities will be done using Masters/tools from Wenzel only. Tools/Masters from customer will not be entertained.
- Air bearings will be cleaned if necessary.
- Movements in all axes will be checked.
- Machine guard will be removed and beds will be cleaned.
- Connecting tubes will be checked and if needed will be advised for replacement.
- Adjustment of Pressure Switch & Solenoid Valve will be carried out to correct pressure level.
- Encoder adjustment will be carried out with reference to respective scale.
- Pressure switch functioning will be checked.
- Counter balance will be checked.
- Measuring scales will be cleaned.
- Air supply will be checked.
- Filter set and Air Dryer will be checked.
- Belt tension will be checked and re-adjusted if necessary.
- Adjustment of Pressure Switch & Solenoid Valve will be carried out to correct pressure level if necessary.

- Room condition including temperature, humidity & cleanness will be checked.
- Input Power Supply to machine with adequate ground connection will be checked.
- Customer will join the inspection routine so that the air supply and power supply to the machine is maintained properly by the customer.

2nd VISIT: SCOPE OF PREVENTIVE VISIT.

- Air bearings will be cleaned if necessary.
- Movements in all three axes will be checked.
- Machine guard will be removed and beds will be cleaned.
- Connecting tubes will be checked and replaced if necessary.
- Adjustment of Pressure Switch & Solenoid Valve will be carried out to correct pressure level if necessary.
- Encoder adjustment will be carried out with reference to respective scale.
- Pressure switch functioning will be checked.
- Counter balance will be checked.
- Measuring scales will be cleaned.
- Air supply will be checked.
- Filter set and Air Dryer will be checked.
- Belt tension will be checked and re-adjusted if necessary.
- Room condition including temperature, humidity & cleanness will be checked.
- Input Power Supply to machine with adequate ground connection will be checked.

3rd VISIT: SCOPE OF WORK UNDER CALIBRATION CUM PREVENTIVE VISIT.

- Calibration will be done as per standard norms of Wenzel. This will cover checking and setting of all geometrical accuracies of the machine as per specification given by Wenzel. All calibration activities will be done using Masters/tools from Wenzel only. Tools/Masters from customer will not be entertained.
- Air bearings will be cleaned if necessary.
- Movements in all axes will be checked.
- Machine guard will be removed and beds will be cleaned.
- Connecting tubes will be checked and if needed will be advised for replacement.
- Adjustment of Pressure Switch & Solenoid Valve will be carried out to correct pressure level.

- Encoder adjustment will be carried out with reference to respective scale.
- Pressure switch functioning will be checked.
- Counter balance will be checked.
- Measuring scales will be cleaned.
- Air supply will be checked.
- Filter set and Air Dryer will be checked.
- Belt tension will be checked and re-adjusted if necessary.
- Adjustment of Pressure Switch & Solenoid Valve will be carried out to correct pressure level if necessary.
- Room condition including temperature, humidity & cleanness will be checked.
- Input Power Supply to machine with adequate ground connection will be checked.
- Customer will join the inspection routine so that the air supply and power supply to the machine is maintained properly by the customer.

4th VISIT: SCOPE OF PREVENTIVE VISIT.

- Air bearings will be cleaned if necessary.
- Movements in all three axes will be checked.
- Machine guard will be removed and beds will be cleaned.
- Connecting tubes will be checked and replaced if necessary.
- Adjustment of Pressure Switch & Solenoid Valve will be carried out to correct pressure level if necessary.
- Encoder adjustment will be carried out with reference to respective scale.
- Pressure switch functioning will be checked.
- Counter balance will be checked.
- Measuring scales will be cleaned.
- Air supply will be checked.
- Filter set and Air Dryer will be checked.
- Belt tension will be checked and re-adjusted if necessary.
- Room condition including temperature, humidity & cleanness will be checked.
- Input Power Supply to machine with adequate ground connection will be checked.