

ITEM:-TOOL HOLDER PACKAGE

Supply & Successful establishment of Tool Holder package for Turning operation to be used on Jobs having properties as specified at point no. 12, meeting acceptance criteria as specified at point no. 6. as per following details :

POINT NO.	REQUIREMENT TO BE COMPLIED					VENDOR'S CONFIRMATION
1	The vendor to offer tooling package for Turning operation to be used on Jobs having properties as specified at point no. 12, meeting acceptance criteria as specified at point no. 6					VENDOR TO CONFORM
2	Quantity : Tooling package shall consist of following items					VENDOR TO CONFORM
	ITEM NO.	Part No.	PACKAGE(ITEM PARTS DETAIL)	PACKAGE(1 SET QTY DETAIL).	PACKAGE QTY(SET)	
	1	a.	Tool Holder body(50x50x300) ready to use fitted with Spares	1 Nos.	2 SETS	
		b.	Spare sets	10 sets		
	c.	Inserts	200 Nos.			
3	Supplied Tool Holder should be hardened & tempered.					VENDOR TO CONFORM
4	1 spare set consists of all the spares used in Tool Holder at single point of time. Vendor to provide Total 10 spare sets in addition to ready to use Tool Holder Body fitted with spares.					VENDOR TO CONFORM
5	L1 status shall be evaluated for full item package i.e. item no. 1 comprising of part no. a,b,c as specified at point no.2. 1 set of enquired 2 sets of Item no. 1 comprising of part no. a, b,c as specified at point no.2, will be procured from L-1 vendor. For remaining one set of item no. 1, L-2 vendor to be counter offered L-1 price of item no. 1 and depending on L-2 vendor's acceptance, subjected item no. 1 will be procured from L-2 vendor at L-1 vendor price. In case L-2 vendor doesn't conform to offer at L-1 vendor's price, similar counter offer to be made subsequently to L-3, L-4 upto last technically qualified vendor and depending on their acceptance of L-1 vendor's price, PO will be placed on them. In case no vendor concurs L-1 vendor price, balance 1 set of item no. 1 to be procured from L-1 vendor i.e. making procurement of both sets from L-1 vendor.					VENDOR TO CONFORM
6	Final acceptance shall be given by CFFP BHEL after successful establishment of supplied items by the vendor at BHEL, CFFP Haridwar by carrying out turning operation on Conventional Vertical Boring Machine at parameters as prescribed by vendor. Supplied item package should meet following acceptance criteria under vendor prescribed operating conditions:- Minimum material removal rate 25mm ³ /min and minimum material removal should be 1500mm ² with all cutting edges. The above machining shall be carried out on Conventional Vertical Borer Machine on BHEL specified delivery schedule as per availability of components & machine. Vendor may depute their representative at the time of establishment.					VENDOR TO CONFORM
7	If item 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 Cutter body/spares/inserts/machining parameters. In case of failure even in second chance, the supplied lot for concerned item(including cutter body, spares,inserts) shall be declared as rejected.					VENDOR TO CONFORM
8	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.6					VENDOR TO CONFORM
9	The offer should be complete having list & quantity of each item offered with price, technical details, 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. 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 & PROVIDE REQUIRED DOCUMENTS
10	In case of damage to Tool Holder or it's spares during establishment of required machining, the same shall be replaced by the vendor without any financial implications to BHEL.					VENDOR TO CONFORM
11	Tool Holder package should be suitably designed to withstand machining conditions on Jobss having properties as specified at point no. 12 as Job to be machined generally has black surface, hard spots, sand inclusion, cracks etc and supplied item will be subjected to interrupted cutting & sudden impact loading during operation. Vendor to provide Guarantee Certificate with minimum guaranty period of 12 months.					VENDOR TO CONFORM
12	Chemical Composition:- C-0.11-1.14; Si- 0.2-0.4; Mn-0.8-1.2;P- ≤0.02 ;S- ≤0.01;Cr-9.2-10.2;Mo- 0.9-1.05;V- 0.18-0.25 Ni-0.6-0.8;Al- ≤0.02; Nb- 0.05-0.08; N- 0.04-0.06;W- 0.95-1.05 Mechanical Properties:- 0.2% PS- ≥250N/mm ² ; UTS- 680-850 N/mm ² ; %EI ≥15%; % Ra ≥ 40%; Impact ≥ 35J Cast Weight - Upto 39T ;Wiegth after amchining-Upto 35.8T ;Max OD-2410mm Max ID- 1630mm					VENDOR TO CONFORM