



Pre-Qualification Requirement for LMZ Turbine Bearings

Description of Item: Fully machined LMZ Turbine Bearings as per drawing, with material as per combined Bill of Material and manufacturing as per BHEL Quality Plan HW/MCD/007 Rev.00

Scope of Work:

- 1) Procurement of Casting of bearing shell and other items as per combined bill of material provided by BHEL.
- 2) Critical raw material viz: casting of bearing shell etc.(will be indicated by BHEL in enquiry) to be procured from BHEL approved sources only.
- 3) Machining of Bearing shell and other components as per BHEL drawing.
- 4) Babbitting (White metal lining) to be done on centrifugal babbitting machine as per the broad process provided by BHEL. However process control to be ensured and exercised by the vendor. White metal should be as per BHEL specification. However BHEL has the right to witness the chemical properties of the white metal.
- 5) Testing of white metal bonding with Ultrasonic and Dye Penetration test as per BHEL testing standard.
- 6) Machining of bearing inner diameter as per BHEL drawing.
- 7) Assembly of other items with bearing as per BHEL drawing.
- 8) All the technical requirements of the drawing are to be followed and fulfilled strictly by the vendor.
- 9) Pre-dispatch inspection will be carried out at party's works by BHEL/BHEL representative as per BHEL Quality Plan. All measuring and testing equipments duly calibrated required for inspection will be arranged by the vendor. During manufacturing of bearings, BHEL may witness any process as per its discretion.
- 10) Preservation and packing as per BHEL instruction.

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- 11) Test certificates will be required for raw materials, UT and DP test. Other test reports are required as per Quality Plan/enquiry.
- 12) A guarantee certificate for minimum 24 months of trouble free performance from the date of shipment or min. 12 months from date of commissioning whichever is earlier to be given by the vendor.

Pre-Qualification Requirements for the vendors:

Only those vendors will be considered technical suitable for manufacturing the LMZ Turbine bearings, who fulfill the below mentioned three pre-qualification requirements:

- 1) Vendor should have well established manufacturing plant and well established procedure for manufacturing the LMZ turbine bearings. All the required manufacturing and testing facilities should be available with the vendor in house. Party has to provide the list of such facilities available with them along with their quotation. BHEL may verify the facilities and other credentials declared by the party at any moment of time. The quotation of the party may be declared null and void by BHEL on false information if any, found by BHEL.

Vendor should have minimum following major facilities for qualifying in the tender:

- Centrifugal Babbitting Machine suitable to size and weight of the required bearings for white metal lining
- Vertical Machining Centre or any other suitable machine for machining the required bearing
- Vertical Boring machine or any other suitable machine for ID machining of required bearing
- Drilling facility

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- UT testing machine with Level-II qualified operator
- DP testing facility with Level-II qualified operator

2) Vendor should have minimum 3 years experience for manufacturing the LMZ turbine bearings of 100/210 MW capacity as on the date of tender opening of techno-commercial Bid. Vendor has to provide the documentary evidence for the same along with their quotation.

3) Vendor should have successfully supplied LMZ turbine bearings of 100/210 MW capacity to reputed organizations and Power plants like NTPC, State Electricity Boards etc. in the past. Vendor has to provide the list of their customers and satisfactory performance certificate of their supplied bearings given by their customers, along with the quotation. Vendor to furnish contact detail of the authority issued the performance certificate to facilitate verification by BHEL. Further if any feedback from the customer is available, the same should be furnished with the offer.

OR

Vendor is already registered with any other unit of BHEL for supplying this type of turbine bearings. In this case, vendor is to submit the detail like unit name of BHEL where vendor is registered, vendor code with that unit etc. The decision regarding technical qualification of such vendors will be taken based on the vendor rating and feedback from the unit where vendor is registered.

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(कालोप कृष्ण)
वर्ग अफिम - भाग खं सिं

11/11/14
(रुनं कं सिंह)
प्रबंधक गुणता

10/11/14
(कुनल तिवारी)
प्रबंधक - डेप्युटी