

SNO	DESCRIPTION FOR BHEL REQUIREMENT		SPECIFIED / TO BE CONFIRMED BY	OFFERED	DEVIATIONS	REMARKS
1.0 PURPOSE:						
1.1 Purpose:			Vendor to Confirm			
	The post curing electric oven shall be used for preheating & also for post curing of High Voltage stators and rotors of electrical machines. Vacuum impregnated stators and rotors shall be cured in post curing oven. The sizes of stators and rotors vary. Hence depending on the availability of jobs and availability of space, the oven shall be loaded. The max. weight of jobs can go upto 50 tonnes					
1.2 Process:	The post curing process for VPI impregnated stators & rotors is as follows:					
	(i) Impregnated stator capsules / rotors having total weight 2 tons to 25 tons (numbers depending on space availability) will be placed on the motorized trolley of the curing oven and moved into the oven.		Vendor to Confirm			
	(ii) Oven temperature shall be raised to 70 +/- 5 deg C. This should be achieved in 1 hour with total mass of fixtures and jobs (6000 Kg to 50000 Kg).					
	(iii) Oven temperature shall be further raised to 140 +/- 5 deg C. This should be achieved in 3-4 hours with total mass same as above		Vendor to Confirm			
	(iv) Curing of bars at above temperature for 10 to 16 hours		Vendor to Confirm			
	(v) After completion of heating cycle the job is cooled down to approximately 60-70 degree centigrade in side oven in two to three hours approx. Then the jobs are taken out from the oven.		Vendor to Confirm			
	(vi) There will not be a single piece but number of pieces loaded into the oven at a time					
2.0 SPECIFICATION:						
2.1 Construction:						

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2.1.1	The post curing electric oven shall be front loading type with a moving trolley system. The job in the chamber shall be heated with recirculating hot air. The trolley shall be with motorized operation and shall be capable of sustaining the total load of the job. Operational parameter of the oven shall be PLC controlled with in built temperature and time recording of the job. The oven shall be designed and manufactured following the latest technology conforming to national / international operational and safety norms. (Complete construction detail to be furnished)	Vendor to Confirm			
2.1.2	The electric Oven and its accessories should be suitable for continuous operation to its full capacity for 24 hour a day and 7 days a week throughout. Vendor to ensure and confirm the same.	Vendor to Confirm			
2.1.3	Job details: Stator capsules OD X length x mass (Max/ Min) 3000 x 2500 x 25 ton 1200 x 800 x 3 tons length of core for resting - max/min 2000 / 500 mm Rotors OD x Core length x weight x OAL (max / Min) 1550 x2500 x 25 tonnes x 6000 mm 700 x 500 x 2 tonnes x 1800 mm Bearing dia max /min- 80 to 300 mm, Journal width- 120 mm Distance betn Journal dia- Max/Min- 4500 / 1000 Separate rotators are required for the above stators and rotors and they must take motion from a drive mounted on the trolley through universal coupling/ flange/ shaft				
2.2	Oven Chamber:				
2.2.1	Chamber Internal Dimension: 6 m length x 4.5 m width x 4 m height(LxWxH)	Vendor to Confirm			
2.2.2	Design Temperature.	Vendor to Specify			
2.2.3	Operating Temperature.	R/T to 200 deg C			
2.2.4	Double wall construction made of mild steel sheets with suitable supporting structure and reinforcement for rigidity.	Vendor to Confirm			
2.2.5	Insulation Material.	Vendor to Specify			
2.2.6	Thickness of Insulation.	Vendor to Specify			
2.2.7	Max Skin Temperature 10 to 15 degree centigrade above ambient.	Vendor to specify			

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2.2.8	The door of the chamber shall be mounted on trolley itself.The motorised gear arrangement should be mounted outside of door on trolley.	Vendor to Confirm			
2.2.9	Door Locking Arrangement (Details should be furnished)	Vendor to Specify			
2.2.10	There should be proper sealing around the door and it's bottom to ensure that there is no leakage of hot air from the chamber. (Details should be furnished.)	Vendor to Confirm			
2.2.11	To facilitate uniform heating of the job inside oven , suitable air circulation arrangement shall be provided.	Vendor to Confirm			
2.2.12	To exhaust the resin fumes produced in the oven chamber and the forced circulating air , one separte exhaust ducting with exhaust blower and damper should be provided.The exhaust ducting for the forced hot circulating air is to be provided with heated precipitator to reduce the pollution. (Complete details should be furnished).The exhaust ducts should be taken out of shop area at a suitable height.	Vendor to Confirm			
2.2.13	Painting of chamber with heat resistant aluminum paint.	Vendor to Confirm			
2.3 Heating Arrangement:					
2.3.1	Heating to be carried out by Electrical heating system through suitable heat exchanger system.Heaters and heat exchanger can be mounted on top of the oven.	Vendor to Confirm			
2.3.2	Ceramic fiber blanket Insulation of suitable thickness is to be provided on all sides and roof of the oven including door for uniform heating. (Thickness and details of ceramic fiber blanket insulation to be furnished)	Vendor to Specify			
2.3.3	Tube heaters should be insulated with heat resistant material of suitable size.	Vendor to Confirm			
2.3.4	Heaters shall be suitable for application of 220 volts A.C. supply . These heaters are to be evenly distributed in 3- Phase 415 volt supply.	Vendor to confirm			
2.3.5	KW rating of oven and heat exchanger shall be designed to raise the oven tempearture to 200 + Deg. Centigrade.(Including mass of fixture and coils approx 6 to 50 Tons).	Vendor to Confirm			
2.3.6	The following details of oven to be furnished:	Vendor to Specify			

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	a) KW rating of oven. (tentative 500 kW)	Vendor to Specify			
	b) Number of heating zones.	Vendor to Specify			
	c) Calculation details of rating of heating elements, their make and mounting arrangement.	Vendor to specify			
	d)Capacity of each air blower.	Vendor to specify			
	e) Rating of Blower motor.	Vendor to specify			
	f) Air flow switch to be provided for each blower to sense air flow.	Vendor to confirm			
	g) Heat exchanger design.	Vendor to specify			
	2.4 Temperature Control / Recording:				
	2.4.1 Temperature Control Range.	R/T to 200 deg C			
	2.4.2 Accuracy of Temperature Control at set temp. (Job temperature.)	$\pm 5^{\circ}\text{C}$ at 145°C			
	2.4.3 Temperature uniformity along the length and width of the chamber(within $\pm 5^{\circ}\text{C}$).	Vendor to confirm			
	2.4.4 Type of Control.	Vendor to Specify			
	2.4.5 Digital Temperature Indicator / Controller should be programmable with record of temperature/time curve.	Vendor to Confirm			
	2.4.6 Temperature Recorder shall also be provided (Make, Model and complete details of the Recorder should be furnished). One analog strip chart recorder with 25 strip rolls as well as one digital strip chart recorder.	Vendor to Confirm			
	2.4.7 The temperature of the job is to be recorded at 6 Number of points by placement of suitable sensors. 2 Nos spare points should also be provided.	Vendor to confirm			
	2.4.8 Temperature Indicator with Large Size LED Display for easy viewing from floor level shall be provided on the top front of the oven chamber. (Size of display should be furnished.)	Vendor to confirm			

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2.4.9	Thermocouples/ RTD sensors and Sufficient length of compensating leads for connecting temperature controller, indicator and recorder to the thermocouples should be supplied.	Vendor to confirm			
	2.5 Motorized Trolley:				
2.5.1	The flat type open trolley with removable trays underneath to collect the droplets of resin from the job. shall be with motorized operation and shall be capable of sustaining the total load of the job (Complete construction details of the trolley should be furnished). The top of the trolley should be of sheet steel of suitable thickness to carry load of job and fixture as mentioned at 1.2 above.	Vendor to confirm			
2.5.2	Safe weight carrying capacity of Trolley.	Vendor to Specify			
2.5.3	Travel Speed.	Vendor to Specify			
2.5.4	Height of Trolley Top from Floor should not be more than 350 mm.	Vendor to confirm.			
2.5.5	Length & Width of Trolley shall be around 6 m x 4.5 m.	Vendor to confirm			
2.5.6	Rail wheel diameter.	Vendor to Specify			
2.5.7	The wheel bearings shall be lubricated with high temperature lubricant which should withstand continuous exposure to the oven temperature. (Details of Lubricant used should be furnished.)	Vendor to Confirm			
2.5.8	Rails for travel of trolley should be supplied. Track width shall be 1445mm.	Vendor to confirm			
2.5.9	Drive Motor Rating.	Vendor to Specify			
2.5.10	Suitable trolley drive arrangement shall be located outside the oven door on the trolley itself..	Vendor to Specify			
2.5.11	Operating of door of oven shall be motorised.				
	2.6 OPERATION & CONTROL SYSTEM:				
2.6.1	The Oven shall be equipped with control panel containing all the equipments necessary for operation, controlling and recording.	Vender to Confirm			
2.6.2	The temperature controller, recorder, alarm indication lamps, blower controls, burner controls shall be located in the control panel	Vender to Confirm			
2.6.3	The Oven should be controlled by a suitably programmed PLC. All required modules and interfacing cables shall be included.	Vendor to Confirm			

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2.6.3.1	PLC shall be ALLEN BRADLEY/GE-FANUC/MODICON/MITSUBISHI/SIEMENS MAKE ONLY. (Make, Model and Details to be furnished.)	Vendor to Specify			
2.6.3.2	PLC Programming shall be in Statement List (STL) and ladder diagram (LAD). It should have copy, cut, print functions etc.	Vendor to Confirm			
2.6.3.3	It should have Off line and on-line programming and editing with capability of power flow monitoring and debugging, forcing of I/Os etc.	Vendor to Confirm			
2.6.4	Necessary manual local controls should also be provided for operation of the oven. (Details should be furnished.)	Vendor to Confirm			
2.6.5	Inkjet printer for printout of essential process parameters.	Vendor to Confirm			
2.6.7	UPS FOR PLC SYSTEM: UPS of 30 minutes for PLC system with inbuilt cooling and charge status display. (Battery charging /discharging time should be specified by vendor.)	Vendor to Confirm			
2.7	ELECTRICAL SYSTEM :				
2.7.1	415V + 10% / -10%, 50HZ + / - 1.5 Hz, 3 Phase AC (3 wire system with out neutral) Power Supply Source will be provided by BHEL at a single point near the oven as per layout recommended by Vendor. All types of cables, connections, main MCBs/ other circuit breakers etc. required for connecting BHEL's power supply point to different parts of the Plant / control cabinets, shall be the responsibility of vendor. Requirement of grounding/earthing with required material details is to be informed by vendor well in advance so that same could be incorporated during construction of foundation.	Vendor to Confirm			
2.7.2	Tropicalisation: All electrical / electronic equipment shall be tropicalized	Vendor to Confirm			
2.7.3	All electrical & electronic control cabinets & panels should be dust and vermin proof.	Vendor to Confirm			
2.7.4	All electrical components in the cabinets should be mounted on DIN Rail.	Vendor to Confirm			
2.7.5	All electrical and electronic panels including operator's panel should be provided with fluorescent lamps for sufficient illumination and power receptacles of 220Volts, 5/15 Amp AC. All adapters/receptacles should have compatibility with Indian equivalents.	Vendor to Confirm			
2.7.6	Motors shall conform to IEC Standards	Vendor to Confirm			

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2.7.7	All cables moving with traversing equipment should be installed in Caterpillar/ Drag chain. Additionally, all the Cable trays, hoses, cable drag chains etc required for laying of cables should be included in the offer.	Vendor to Confirm			
2.7.8	Vendor should ensure the proper earthing for all equipment of the oven and its auxiliaries.	Vendor to Confirm			
2.7.9	In-cycle hour counter with reset facility is to be included in the offer.	Vendor to Confirm			
2.8	SAFETY ARRANGEMENTS:				
	Following safety features in addition to other standard safety features should be provided for the oven and its auxiliaries: (Complete description of Safety features should be furnished)				
	1. Oven should have adequate and reliable safety interlocks / devices to avoid damage to the Oven, workpiece and the operator due to the malfunctioning or mistakes. Oven functions should be continuously monitored and alarm / warning indications through lights (on Control Panels) should be available.	Vendor to Confirm			
	2. A detailed list of all alarms / indications provided should be submitted	Vendor to Confirm			
	3. All the pipes, cables etc. on the Plant should be well supported and protected.	Vendor to Confirm			
	4. All the rotating parts used on Oven should be statically & dynamically balanced to avoid undue vibrations. All rotating parts should be provided with suitable guards.	Vendor to Confirm			
	5. Emergency Switches at suitable locations as per International norms are to be provided.	Vendor to Confirm			
	6. Safety against failure of air supply from blowers.	Vendor to Confirm			
	7. The Lighting & electrics inside the Oven shall be of flame proof type.	Vendor to Confirm			
	8. All Electrical fittings shall confirm to IE Rules and IS/BS standard.	Vendor to Confirm			
	9. All Electrical equipment shall be suitably protected by IIRC fuses /MCBs /Overload relays, single phasing preventors.	Vendor to Confirm			
	10. All Electrical equipment shall have double earthing.	Vendor to Confirm			
	11. The wiring / cabling shall be neatly dressed / clamped.	Vendor to Confirm			

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	12. All rotating parts shall be suitably guarded.	Vendor to Confirm			
	13. Emergency rescue / escape features shall be provided for accidental entrapment of person in the Oven.	Vendor to Confirm			
	14. The wires and cables shall be of Fire retardant insulation.	Vendor to Confirm			
	15. Suitable Fire Protection scheme is to be provided by supplier comtable to the system provided in BHEL.	Vendor to Confirm			
	16. The waste generated in the system should conform to MPPCB norms and disposal method as per MPPCB / Environmental rules is to be	Vendor to Confirm			
2.9	ENVIRONMENTAL PERFORMANCE OF THE OVEN & COMPLIANCE OF REGULATIONS:				
	The electric Oven shall conform to following factors related to				
	(a) Maximum noise level shall be 85 dB(A) at normal load condition, 1 M away from the Plant with correction factor for back ground noise, if necessary. This will be measured as per international standards like DIN 45635-16. Supplier to demonstrate compliance to noise level, if so required.	Vendor to Confirm			
	(b) If any safety / environmental protection enclosure is required it should be built in the electric Oven by the vendor. (Details should be furnished.)	Vendor to Confirm			
	(c) Paint of the electric Oven should be heat resistant and should not peel off.	Vendor to Confirm			
	d) Structural Stability of Oven	Vendor to Specify & Confirm			
	e) Air Pollution - There shall not be any emissions from the Vessel. In case of emission suitable Air Pollution control device is to be provided.	Vendor to Specify & Confirm			
	f) In case of alternatives offer (Electrical Heating System), all requirements of M.P. Factory Rules (Attached Rule 73 J as per annexure) should be complied by supplier for Thermic Fluid (Rules detail enclosed).	Vendor to Specify & Confirm			
3.0	LEVELING & ANCHORING SYSTEM				
	Complete anchoring system including foundation bolts, anchoring materials, fixators, leveling shoes etc shall be supplied for the Oven and all allied equipment.	Vendor to confirm			

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4.0	TOOLS FOR ERECTION, OPERATION & MAINTENANCE :				
4.1	Special tools and equipment required for erection of the Post Curing Oven shall be brought by the vendor. Necessary tools like Spanners, Keys, grease guns etc.for operation and maintenance of the Post Curing Oven should be supplied. List of such tools should be submitted with offer.	Vendor to Confirm			
5.0	SPARES:	Vendor to Confirm			
5.1	Item wise breakup of mechanical, electrical and electronic spares used on the oven in sufficient quantity as per recommendation of Vendor for 2 years of trouble free operation on three shifts continuous running basis should be offered by vendor. The list to include following, in addition to other recommended spares. (Unit Price of each item of spare should be offered.)	Vendor to Confirm			
	a) Mechanical Spares: All types of Valves/pressure switches / transducers, /filters& all types of seals..	Vendor to Confirm			
	b) Electrical /Electronic / PLC Spares: All types of Relays, Contactors, Proximity Switches, Push Buttons, Indicating Lamps, Special Fuses, Circuit Breakers, Main Power Switch, Display Unit, I/O Cards for PLC, etc.	Vendor to Confirm			
5.2	Vendor to confirm that complete list of spares for Oven and accessories, along with specification / type / model, and name & address of the spare supplier shall be furnished along with documentation to be supplied with the machine.	Vendor to Confirm			

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6.0	DOCUMENTATION : Five sets of following documents (Hard copies) in English language should be supplied along with the Post Curing electric Oven.				
6.1	Operating Manuals of post curing electric Oven.	Vendor to Confirm			
6.2	Programming Manuals of PLC system.	Vendor to Confirm			
6.3	Detailed Maintenance manual of Curing Oven with all drawings of Oven assemblies/sub-assemblies/parts including Electrical / Pneumatic circuit diagrams. All Assembly/ Sub Assembly Drawings shall be supplied with the part list also	Vendor to Confirm			
6.4	Maintenance, Interface & commissioning manuals for PLC system.	Vendor to Confirm			
6.5	Catalogues, O&M Manuals of all bought out items like gas burners etc including drawings, wherever applicable.	Vendor to Confirm			
6.6	PLC program print-outs with comments in English.	Vendor to Confirm			
6.7	PLC program on CD.	Vendor to Confirm			
6.8	Complete Master List of parts used in the Oven shall be submitted by the vendor.	Vendor to Confirm			
6.9	One additional set of all the above documentation on CD ROM, wherever possible.	Vendor to Confirm			
7.0	TRAINING:				
7.1	BHEL Persons should be trained at supplier's Works for mutually agreed period	Vendor to Confirm			
7.2	Supplier to train BHEL personnel in operations of oven after installation.	Vendor to Confirm			

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8.0	FOUNDATION:				
8.1	Vendor shall submit the preliminary layout drawing for getting BHEL's approval within one month from the date of Letter of Intent (LOI)/ P.O. Soil condition data will be furnished by BHEL alongwith the approval. Complete Foundation Design including details, like Static/ Dynamic load details etc. and final Layout Drawings shall be submitted by the supplier within given period after getting BHEL's approval. The Layout should consist of all requirements pertaining to complete oven and all accessories. and control pannel. BHEL shall construct complete foundation for the oven .The vendor shall also indicate detailed specifications of grouting compound and grouting procedureetc. for foundation bolts of the oven.	Vendor to Confirm			
9.0	ERECTION & COMMISSIONING				
9.1	Supplier to take full responsibility for carrying out the erection, start up, testing of oven, it's control system & all types of other supplied equipment, Service requirement like power, air & water shall be provided by BHEL at only one point to be indicated by supplier in their foundation/layout drawings. Other requirements like crane shall also be provided by BHEL. Details of these requirements should be informed by vendor in advance.	Vendor to Confirm			
9.2	Successful proving of BHEL components by the supplier shall be considered as part of commissioning. All tests, as mentioned at clause 11 (Machine /Oven Acceptance) shall form part of the commissioning activity.	Vendor to Confirm			
9.3	Commissioning spares, required for commissioning of the oven within stipulated time, shall be brought by the supplier on returnable basis.	Vendor to Confirm			
9.4	Portion, if any, of them oven &- accessories where paint has rubbed off or peeled during transit or erection should be repainted and merged with the original surrounding paint by the vendor. For this purpose, the vendor should supply sufficient quantity of touch-up paint of various colours of paint used.	Vendor to Confirm			
9.5	Schedule of Erection and Commissioning shall be submitted with the offer.	Vendor to Confirm			
9.6	Charges, duration, terms & conditions for E&C should be furnished in detail	Vendor to Confirm			

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10.0	AMBIENT CONDITIONS & THERMAL STABILITY :				
10.1	The Oven and its accessories should work trouble free and efficiently under following operating conditions and should give specified accuracies. Power Supply: Voltage: 415 V - 10%, +10% Frequency: 50 Hz + / - 1.5Hz No. of phases = 3 (3-Wire, No Neutral.) Ambient Conditions: Temperature = 5 to 50 degree celsius Relative Humidity = 95% max. (Vendor to confirm that the electric oven is suitable for above and details o	Vendor to Confirm			
11.0	MACHINE/OVEN ACCEPTANCE: (Tests/Activities to be Performed by Vendor)				
11.1	Tests/Activities that should be carried out at supplier's works on the Oven before dispatch :	Vendor to Confirm			
11.1.1	The electric Oven should be tested for continuous running of 48 hrs at 140 deg C. If any break down occurs during this test, the test should be repeated for 48 hrs from that time.	Vendor to Confirm			
11.1.2	Demonstration of all features of the Oven Control system and all Accessories.	Vendor to Confirm			
11.2	Test to be carried out at BHEL works while commissioning the Oven.				
11.2.1	The Oven control system including PLC should be tested for continuous running for 1 week. If any break down occurs during this test, the test should be repeated for 1 week from that time.	Vendor to Confirm			
11.2.2	Demonstration of all features of the Oven, Control system & all accessories to the satisfaction of BHEL for their efficient and effective use.	Vendor to Confirm			
11.2.3	Atleast 2 batches/cycles of Jobs should be proved out.	Vendor to Confirm			
11.2.4	Two weeks supervision of independent operation of Oven by BHEL after job proveout.	Vendor to Confirm			

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11.2.5	Training of BHEL personnel in Operation & Maintenance of the Oven & accessories etc by the supplier's experts / engineers after commissioning	Vendor to Confirm			
	12.0 PACKING:				
12.1	Rigid packing for all items of the Oven and its controls to avoid any damage/loss in transit. When machine is despatched in containers, all small loose items shall be suitably packed in boxes	Vendor to Confirm			
	13.0 GUARANTEE :				
13.1	24 months from the date of acceptance of the machine.	Vendor to Confirm			
	14.0 GENERAL : The vendor should submit the following information:				
14.1	Oven Model	Vendor to Confirm			
14.2	Total connected load (KVA):	Vendor to Confirm			
14.3	Floor area required (Length, Width, Height) for the Oven, Control System accessories	Vendor to Confirm			
14.4	Painting of Oven/ Electrical Panels: Heat Resistant Aluminum Paint for Oven and RAL 6011 Apple Green Colour for Control Panel	Vendor to Confirm			
14.5	Total weight of the Oven	Vendor to Confirm			
14.6	Weight of heaviest part of Oven	Vendor to Confirm			
14.7	Weight of the heaviest assembly/ subassembly of the Oven	Vendor to Confirm			
14.8	Dimensions of largest part/ subassembly/ assembly of the Oven	Vendor to Confirm			
14.9	Vendor to submit, along with offer, the reference list of customers where similar Ovens have been supplied mentioning the customer, Oven - Model, major specifications of the supplied Oven, Year of Supply etc	Vendor to Confirm			
14.10	Detailed catalogues , sketch/ photographs of the Oven and accessories should be submitted with the offer.	Vendor to Confirm			
14.11	All piping should be preferably metallic except places where flexible pipings are essential.All the pipes required for the same shall be included in the standard scope of the Oven.	Vendor to Confirm			

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14.12	Descriptive leaflets, operating and maintenance manuals, schematic and wiring diagrams.				
14.13	General arrangement drawings.				
	15.0 QUALIFYING CONDITIONS :				
15.1	Only those vendors, who have supplied and commissioned at least one Curing Oven of size 5 m x 4.0 m x 3 m (LxWxH) or higher and Operating Temperature up to 200°C for similar applications in the past and such equipment is presently working satisfactorily for more than one year (more than six months if supplied to BHEL) after commissioning, should quote.	Vendor to Confirm			
15.2	The following information is to be submitted by the vendor about the companies where similar Ovens have been supplied. This is required from all the vendors for qualification of their offer.	Vendor to Confirm			
	1. Name of the customer / company where similar Oven is installed. (Copy of Purchase Order should be furnished)	Vendor to Confirm			
	2. Complete postal address of the customer.	Vendor to Confirm			
	3. Year of commissioning. (Copy of Commissioning Report should be furnished)	Vendor to Confirm			
	4. Application for which the oven is supplied	Vendor to Confirm			
	5. Name and designation of the contact person of the customer.	Vendor to Confirm			
	6. Phone, FAX no. and email address of the contact person of the Customer	Vendor to Confirm			
	7. Performance certificate from the customers, regarding satisfactory performance of the plant supplied to them.	Vendor to Confirm			
Approved by					