



BHARAT HEAVY ELECTRICAL LIMITED
BHOPAL, MADHYA PRADESH

PQC cum Annexure-I to P.I.821192002

Email:

SPECIFICATION CUM COMPLIANCE CERTIFICATE OF ~~BRAS~~ BRAZED C.T. GUNDRILL

NOTE:-

1. Vendor must submit complete information from clause No.1 to 9.1, The offer meeting this clause would only be processed
2. The offer and all documents enclosed with offer should be in English language only.
3. The information provided by vendor in specification cum compliance certificate will supersede any other information provided by vendor .
4. No deviations irrespective of technical/ NIT conditions, will be acceptable because of our requirement is stringent,Hence vendors not fulfilling our requirement shall not be participate.

NAME & ADDRESS OF THE SUPPLIER :

E-MAIL ADDRESS :

SCOPE: SUPPLY OF BRAZED CARBIDE THROUGH COOLANT GUN DRILL & THEIR ACCESSORIES

SNO	DESCRIPTION FOR BHEL REQUIREMENT	SPECIFIED / CONFIRMED	OFFERED	REMARKS
1	SUPPLY AND PROVING OF BRAZED CARBIDE TIPPED THROUGH COOLANT GUN DRILL DIAMETER 12.76 MM x 800 MM OVER ALL LENGTH FOR HOLE DIA 12.76 MM +0.05-0.00 .SHOULD WORK CUTTING SPEED BETWEEN 60 TO 120 MM/MIN,FEED 0.08 TO 0.15 MM/MIN AND TOOL LIFE 50 TO 80 METERS .THE IDENTIFICATION MARK (DRILL SIZE)SHOULD BE PERMANENTLY MARKED AT SUITABLE PLACE.	Vendor to Confirm		
2	MACHINE TECHNICAL DATA :			
2.1	Tube plate(Material grade : SA182 F 316L) to be drilled through in horizontal LEHR make deep hole drilling machine, has a thicknes of 280.00 mm,using neat type cutting oil with a pressure of 45 bar @ 1500 rpm.	Vendor to note		

अभिनुव त्रिपाठी
उप प्रबंधक (स्वा.) / Dy. Manager (Prod.)
एच.सी.एम. विभाग / HCM Division
बी.एच.ई.एल., भोपाल / BHEL, BHOPAL

3 TECHNICAL DETAIL :					
3.1	Drilling hole diameter	: 12.76+0.05-0.00 mm	Vendor to Nnote		
3.2	Drill diameter	: 12.76 mm	Vendor to confirm		
3.3	Over all Length of the drill	: 800.0 mm	Vendor to confirm		
3.4	Driver	: as per drg. HPH/1005	Vendor to confirm		
3.5	Effective hole depth	: 280.00 mm	Vendor to confirm		
3.6	Hole tolerance	Between H7-H8	Vendor to specify and confirm		
3.7	Hole surface quality(Min)	: 3.2 Ra	Vendor to specify and confirm		
3.8	Hole concentricity	: 0.3 mm (Max.)	Vendor to confirm		
3.9	Hole straightness	: 0.5 mm (Max.)	Vendor to confirm		
4	Single piece carbide head length(mm)	: 40.0 mm (Min.)	Vendor to confirm		
4.1	Carbide head regrinding length(mm)	: 30.0 mm (Min.)	Vendor to confirm		
4.2	Carbide head profile	: E	Vendor to confirm		
4.3	Carbide head coating	: TiALN nano	Vendor to confirm		
4.4	Carbide head "V" angle(Degree)	: 120	Vendor to confirm		
4.5	Carbide head "V" point grinding	: Chip breaker	Vendor to confirm		
4.6	Guide bush	: as per drg. B/STM/1542	Vendor to confirm		
5 OPERATION DETAIL:					
5.1	Cutting Speed Vc(m/min)	: 60-120 (Min.)	Vendor to specify and confirm		
5.2	Feed f(mm/Rev.)	: 0.08-0.15	Vendor to specify and confirm		
5.3	Cutting fluid	: Neat type oil	Vendor to note		
5.4	Spindle Speed	: 1500 RPM	Vendor to note		
6 SCOPE OF SUPPLY:-					
6.1	BRAZED CARBIDE TIPPED GUN DRILL FOR HOLE DIA.12.76 (DRIVER AS PER DRG. HPH/1005)		Vendor to confirm		
6.2	GUIDE BUSH AS PER DRG.NO.B/STM/1542		Vendor to confirm		
6.3	Test & Guarantee Certificates		Vendor to confirm		

अभिषेक त्रिपाठी / ABHISHEK TRIPATHI
 उप प्रबंधक (उत्पा.) / Dy. Manager (Prod.)
 एच.सी.एम. विभाग / HCM Division
 श्री एच.ई.एल., भोपाल / BHEL, BHOPAL

7	SUPPLY & PROVING OF THE EQUIPMENT				
7.1	Supplier will be solely responsible for the supply, commissioning and proving the gun drill at BHEL works. Actual job shall be proved at Bhopal in all respect for accuracy and performance during commissioning.	Vendor to confirm			
8	GENERAL : The vendor should submit the following information:				
8.1	Only OEM or their authorized distributor / dealer has to be quoted and in this regard. Vendors other than OEM are need to be furnished an authorization certificate ensuring BHEL for their guarantee support and warrantee services (For a period of 12 months from the date of receiving of material at our works) as and when required by BHEL, Bhopal on prompt basis	Vendor to submit & confirm			
8.2	Vendor to submit reference of customer(s) where 12.76 mm diameter or higher capacity gun drill have been supplied by the vendor or their principal (through any authorised vendor by principal) of last three years effective from tender opening due date, mentioning the customer detail, Model/Part No of the supplied gun drill, Year of Supply etc. along with offer, else offer is technically disqualified without notice to the vendor.	Vendor to submit PO copy/commissioning report.			
8.3	Last three year auditted balance sheet of the company or their principal (In case of authorized vendor) will be provided along with offer, else offer is technically disqualified without notice to the vendor.	Vendor to submit			
8.4	Detail printed catalogue containing technical details, Model/Part No of the GUN DRILL should be submitted along with the offer failing which offer is treated as technically incomplete and liable to be rejected without information to the bidder.	Vendor to submit			
8.5	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			
9	TERM & CONDITIONS (FINANCIAL PQC)				
9.1	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, LD penalty shall be loaded suitably as per BHEL standard norms.	Vendor to specify & Confirm			


ABHINAV TRIPATHI
 Manager (Prod.)
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