

PROJECT :- ARUN-III**DESCRIPTION:- MCG OF RUNNER BLADES TO DRG 12040720503 REV 00, PROFILE DRG 02040070901****SCOPE OF WORK**

- 1 Raw material for Runner Blade casting will be issued from BHEL after submitting Bank Guarantee by the vendor.
- 2 120 nos stainless steel runner blade casting to be finished mcd all over as per profile drg 02040070901. This generally required 5 axis CNC machines. However, vendors are free to machine above blades on 3 axis CNC machine, but final dimensions should be as per finished m/cg drg.
- 3 The material of runner blade casting is 13:4 cr:Ni (ASTM A 743CA6 NM) and machining allowances on tool point to all over shall be 6 to 8 mm which is to be machined off.
- 4 Grinding shall be carried out on all surfaces after final machining to achieve surface finish of 3.2 micron.
- 5 Edge preparation and related parameter will be followed as per technical requirement of drg 12040720503 Rev 00.
- 6 Before start of runner blade m/cg, vendor to ensure the latest revision of drg from BHEL-Bhopal(HTE).
- 7 Drg/Sketch of Checking Template for profile to be made by vendor in consultant with BHEL-Bhopal(HTE). Vendor shall manufacture 2 set of templates and one set template to be supplied with 1st supply of machined Runner blade.
- 6 Delivery required 20 no. Blades in 45 days.

PRE QUALIFICATION CRITERIA:- FOLLOWINGS ARE REQUIRED FOR TECHNICAL QUALIFICATION

- 1 Availability of 5 axis CNC Machines/3 axis CNC machines. Machine make with spec & photo are required
- 2 Availability of surface finish measuring equipment. Machine make with spec & photo are required.
- 3 Vendor should have experience for machining of Francis Hydro Turbine runner blade profile on 5 or 3 axis machine and they have to submit the Purchase order with experience and completion certificate. The PO and completion certificate should be within three year. Cut off date will be tender opening date(Techno-commercial). However in case of partial completion of PO, Lot completion certificate is required.
- 4 Interested bidder has to submit any last three consecutive CA audited financial annual report(Balance sheet and Profit & loss account) since 2016-17 to 2018-19. Required Financial soundness will be decided by our evaluation committee.

COMMON POINTS

- 1 QA plan is applicable. Vendor has to submit the QAP to BHEL(QWT) for acceptance.
- 2 Required tools and fixtures to be arranged by supplier.
- 3 Any checking gauge/measuring gauge required, will be arranged by supplier.
- 4 Inspection will be done at vendor's work by QC- BHEL-Bhopal as per QAP and MDCC required before dispatch.
- 5 After m/cg, runner blade should be identified by permanent marker pen with drg no and PO no.
- 6 Qty may be distributed between two vendors with 2:1 ratio. L1 Vendor will get minimum 80 Blades for m/cg out of 120 nos. If L1 vendor not able to meet the our requirement than qty may be diverted to L2 vendor and vice versa as per requirement.
- 7 Transportation to & fro will be in vendor scope.
- 8 Rate to be quoted on the basis of drg 12040720503 and profile drg 02040070901 will be provided after PO placement

DGM(WTM-THX)

Sr.MGR(WTM-SHOP)

Sr.MGR(WTM-PLG Inc)

Dy.Mgr(WTM-PLG)