

	BHARAT HEAVY ELECTRICALS LIMITED INDUSTRIAL VALVES PLANT 433, INDUSTRIAL COMPLEX GOINDWAL SAHIB DISTT. TARN TARAN- PUNJAB – 143422	No.BHEL:IVP: SC:Isolating Valve:AD 2019-20/02 Dated 03.02.2020
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NOTICE INVITING APPLICATIONS FOR REGISTRATION OF SUB CONTRACTORS

BHARAT HEAVY ELECTRICALS LIMITED [BHEL] is manufacturing Industrial Valves and other Boiler accessories at its Industrial Valves Plant, Goindwal Sahib unit. Machining Vendors are required for machining of various castings & components. Annual procurement value for the year 2020 – Rs 20 lac.

Expression of interest and applications for registration are invited from sub-contractors (BHEL encourages procurement from Micro and Small Enterprises (MSEs), MSEs are requested to apply for registration) for doing the machining job of various components of Isolating Valves. Various work centers involved in the machining job work shall be VTL, Horizontal boring machine, Drill machine, etc. Chrome plating may also be required on certain components post machining.

Isolating Valves	Casting machining of body, bonnet, disc, cover and other machining components. List of components, where machining vendors are required, is attached herewith as Annexure-I. Sample drawings of some components are also attached. (S.no of list – 7 and 29)
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BHEL is looking for prospective Sub Contractors for above detailed job work for BHEL.

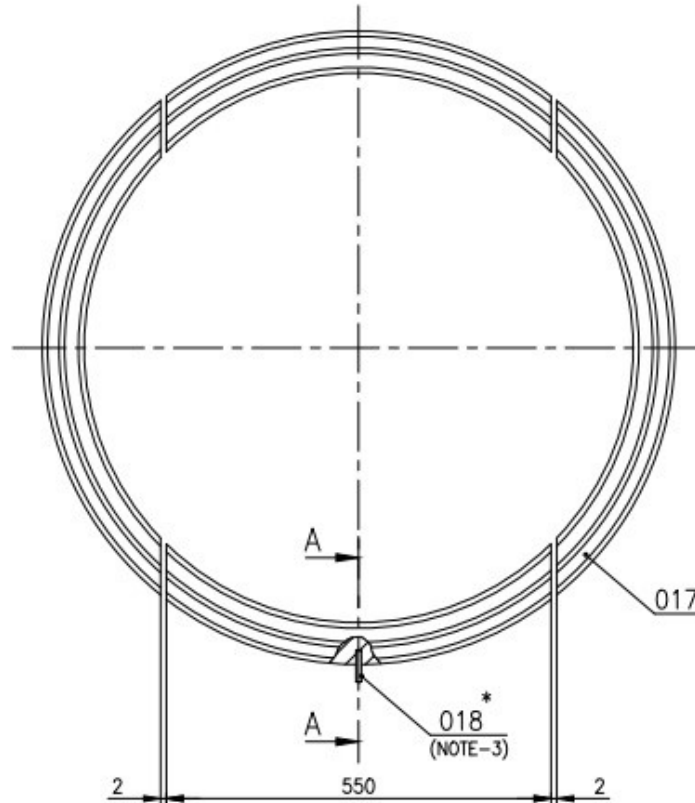
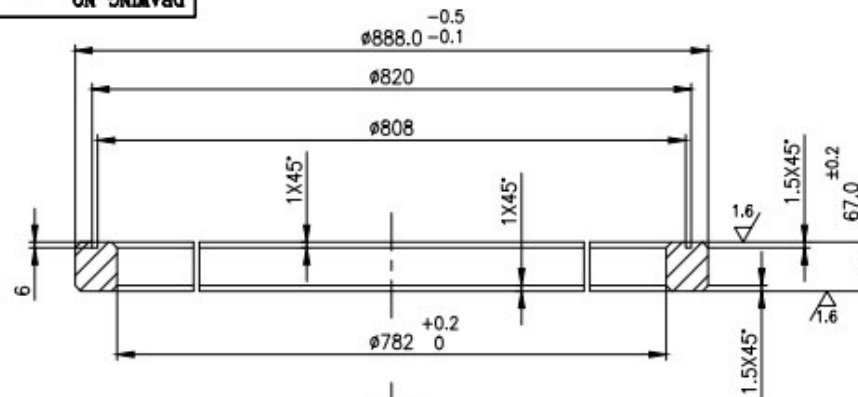
BHEL shall evaluate the vendors as per its established vendor selection, evaluation and registration procedure. Supplier registration can be done online : <https://supplier.bhel.in/>

BHEL invites such vendors to visit its above located plant on any working day from Monday to Saturday between 0900 Hrs to 1730 Hrs and contact undersigned for any clarification regarding:

Items details and requirement		Vendor registration form/procedure
Vineet Kumar Dy. Manager (Sub Contracting)	Mukesh Kumar Dy.Manager (Sub Contracting)	Sahil Malhotra Dy.Manager (Sub-Contracting)
Phone: 01859-224625	01859-224644	01859-224669
Mobile: 99150 47504	81465 52387	98142 09180
E-mail: vineet.k@bhel.in	kumarmukesh@bhel.in	sahil@bhel.in

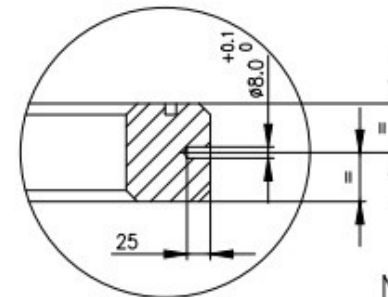
BHARAT HEAVY ELECTRICALS LIMITED INDUSTRIAL VALVES
PLANT, 433, INDUSTRIAL COMPLEX, GOINDWAL SAHIB,
DISTT. TARN TARAN, PUNJAB – 143 422

S.No	Gr. No	Job/Component Description	Description of Valve/ Product (Used in)
1	G2412	Adjusting Screw	450-C500-CRHIV-BW-WCB
2	G2413	Adjusting Screw	700-C500-CRHIV-BW-WCC
3	G2412b	Adjusting Screw	550-C900-HRHIV-BW-WC9
4	G2412c	Adjusting Screw	750-C500-CRHIV-BW-WCC
5	G2414	Hex Domed Screw-3202	750-C600-CRHIV-BW-WCC
6	G2422	SUPPORT RING-3201/3200/3396	450/500-C900-HRHIV-BW-WC9
7	G2425	SPLIT RING ASSY-3245/3316	750-C600-CRHIV-BW-WCC
8	G2425a	SPLIT RING ASSY	700-C600-CRHIV-BW-WCC
9	G2426	COVER-3245	750-C600-CRHIV-BW-WCC
10	G2426a	COVER-3245/3316	700-C600-CRHIV-BW-WCC
11	G2426b	COVER-3316	750-C900-HRHIV-BW-C12A
12	G2432	COVER SHEET	750-C600-CRHIV-BW-WCC
13	G2433	DISK-3245	750-C600-CRHIV-BW-WCC
14	G2433a	DISK-3204	700-C600-CRHIV-BW-WCC
15	G2434	LOCATING SCREW-3200	450-C500-CRHIV-BW-WCB
16	G2469	DISK-3200	450-C500-CRHIV-BW-WCB
17	G2470	BONNET-3200	450-C500-CRHIV-BW-WCB
18	G2483	Support Ring-3208/3390	550-C900-HRHIV-BW-WC9/C12A
19	G2484	Disk-3208	550-C900-HRHIV-BW-WC9/C12A
20	G2485	Seat Ring Rough	550-C900-HRHIV-BW-WC9/C12A
21	G2510	Bonnet Machining	550-C900-HRHIV-BW-WC9/C12A
22	G2517	Locking Plate-3200	450-C500-CRHIV-BW-WCB
23	G2518	Locking Plate-3208/3390	550-C900-HRHIV-BW-WC9/C12A
24	G2520	Seat Ring final	550-C900-HRHIV-BW-WC9/C12A
25	G2530	Split Ring Assy-3200/3396	450/500-C500-CRHIV-BW-WCB/WCC/WC9
26	G2531	Split Ring Assy-3208/3390	550-C900-HRHIV-BW-WC9/C12A
27	G2470a	Bonnet	450-C900SPL-HRHIV-BW-WC9
28	G2414a	DOMED SCREW	450-C500-CRHIV-BW-WCB
29	G2578	Body Machining	550-C900-HRHIV-BW-WC9
30	G2578a	Body Machining	550-C900-HRHIV-BW-C12A
31	G2573	SEAT RING Final	450-C500-CRHIV-BW-WCB/WC9
32	G2574	Body	500-C500-CRHIV-BW-WCC
33	G2576	Seat Ring Rough	500-C500-CRHIV-BW-WCC
34	G2575	Seat Ring Final	500-C500-CRHIV-BW-WCC
35	G2408a	Body Machining	700-C600-CRHIV-BW-WCC
36	G2408c	Body Machining	700-C900-HRHIV-BW-C12A
37	G2408	Body Machining	750-C600/900-HRHIV-BW-WCC
38	G2408b	Body Machining	750-C600/900-HRHIV-BW-C12A
39	G2482	Cover-3208	550-C900-HRHIV-BW-WC9
40	G2415a	LOCKING PLATE-3204	700-C600-CRHIV-BW-WCC
41	G2415	Locking Plate-3245	750-C600-CRHIV-BW-WCC



REV	DATE	ALTERED	BY	REV	DATE	ALTERED	BY
04	19.04.18	CHD & APPD	R.P.SINGH SSK & KRS	03	15.02.16	CHD & APPD	M.SRINIVASAN SSK & KRS
SL.NO. 03 INCLUDED				NOTES SL.NO. 2 MODIFIED.			

SECTION-AA



SECTION-AA

NOTES

- BREAK ALL SHARP CORNERS.
- HARD Cr. PLATING TO BE CARRIED OUT ON FINISHED SPLIT RINGS TO A THICKNESS OF 0.015 MM TO 0.03 MM.
- * FIX ONE CYLINDRICAL PIN $\phi 8 \times 55$ FOR ASSEMBLING WITH BODY AT THE TIME OF ASSEMBLY.

03	CYL PIN $\phi 8 \times 55$	-	-	-	-	0.01	-	BPS 41702	018
	-	92 203 433	ASTM A182 F91 NT, CERTIFY	QT	40	72.0	-	417 02 08055 00	
02	CYL PIN $\phi 8 \times 55$	-	-	-	-	0.01	-	3-V-3311-24536	017
	-	92 203 249	AISI 4140 CERTIFY.	QT	40	72.0	-	93 203 960 0000	
01	CYL PIN $\phi 8 \times 55$	-	-	-	-	0.01	-	BPS 41702	018
	SUGGESTED SIZE PL68 -892 X 892	--	SA387 GR.22 CERTIFY.	NORMALISED & TEMPERED	20	71.99	333.6	417 02 08055 00	
SL No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
								COMP. CODE	

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD.
UNIT: HIGH PRESSURE BOILER PLANT.
TIRUCHIRAPALLI-620014.

DEPT
VL
CODE 320



SCALE
NTS

WEIGHT (KG).
72.0

REFERENCE INFORMATIONS

CAD : F324536

TITLE

SPLIT RING

CARD
CODE
U 01

DRAWING NO.

3-V-0000-24536

REV

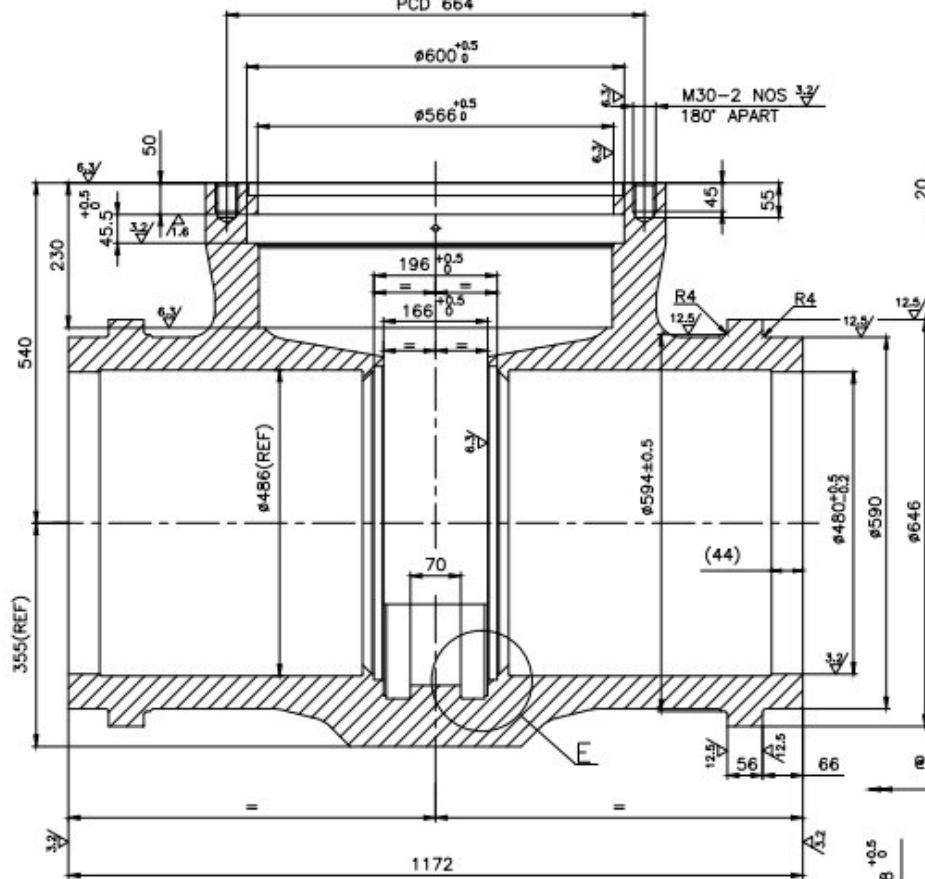
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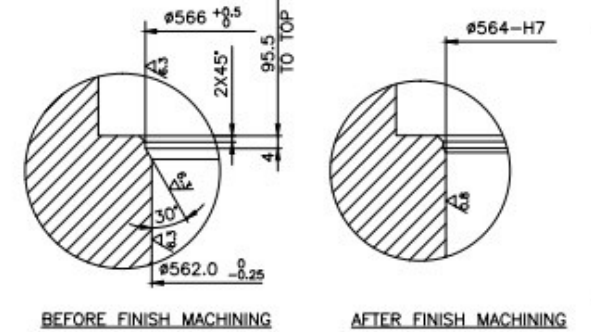
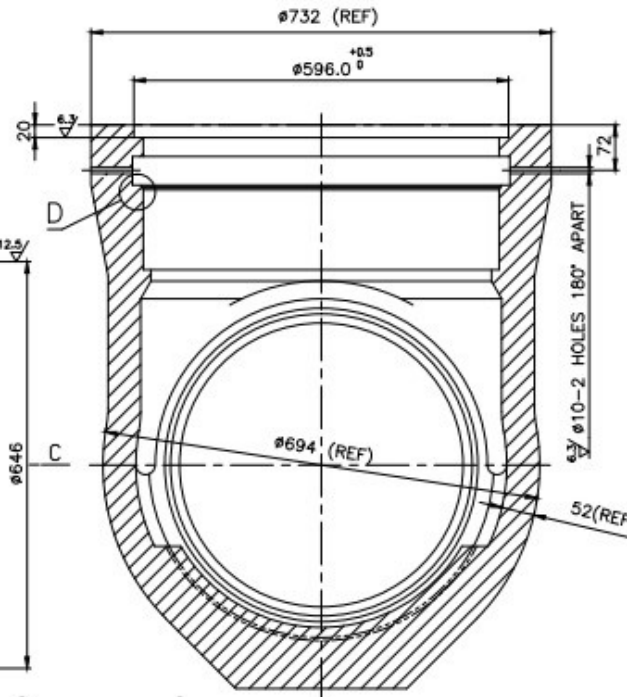
6.3 / 1.6

SECTION-BB

A C
PCD 664



SECTION-AA

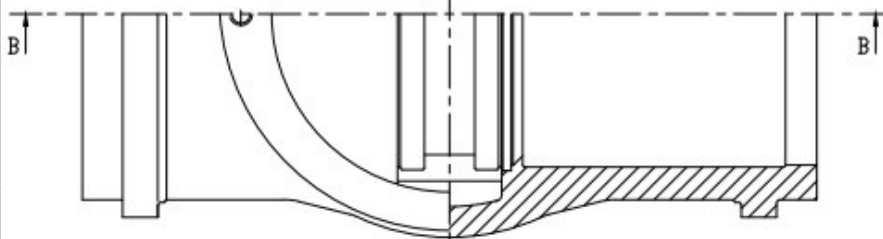


DETAIL-D

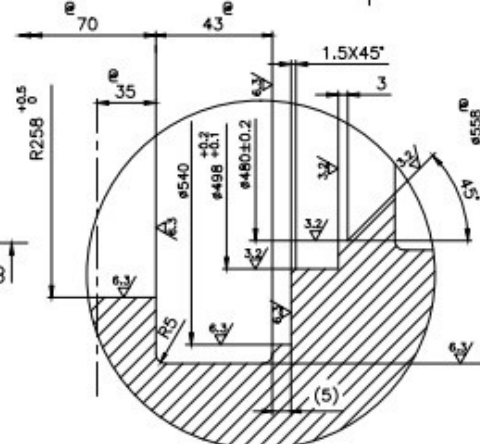
NOTE:-

1. UNSPECIFIED SHARP CORNERS TO BE CHAMFERED TO 1X45°.
2. ALLOWABLE DEVIATIONS FOR DIMENSION WITHOUT SPECIFIED TOLERANCE REFER: APPLICABLE QUALITY PROCEDURE.

SECTION-CC



DETAIL-E



REV	DATE	ALTERED	M.SRINIVASAN	REV	DATE	ALTERED	M.SRINIVASAN	REV	DATE	ALTERED	M.SRINIVASAN	REV	DATE	ALTERED	M.SRINIVASAN	REV	DATE	ALTERED	M.SRINIVASAN
05	21.12.13	CHD & APPD	SSK & KRS	07	06.06.13	CHD & APPD	SSK & KRS	06	06.07.11	CHD & APPD	M.RAJAKUMAR	05	18.06.09	CHD & APPD	M.RAJAKUMAR	04	20.03.09	CHD & APPD	P.BOOMINATHAN
DIMENSION 66 & 1172 WERE 64 & 1168 ±3.2				SL.No. 02 INCLUDED				DIMENSION (44) INCLUDED				DIMENSION 70, 43, 558 & (5) INCLUDED.				DIM. 558, 486, 52 WERE 544, 470 & 63 RESPLY. DIM. 540 INCLUDED.			
DCP : 801664								DCP:801194				DCP:800976				DCP:800936			

02	CASTING	92203133	SA217 C12A ATTEST	NORMALISED & TEMPERED	20	1270	1440	2-V-3390-05612	932030420000	001
01	CASTING	92033824	SA217 WC9 ATTEST	NORMALISED & TEMPERED	20	1270	1440	2-V-3208-05612/06	931663650000	001
SL No.	DESCRIPTION	MATL CODE	MATL SPEC	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING NO	COMPONENT CODE	ITEM No
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										
BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPPALLI-620014.										
DRN		NAME		SRIN		DA				
CHD		M.SRINIVASAN				22.05.93				
APPD		N.NAGARAJAN				22.05.93				
REFERENCE INFORMATION										
COMPONENT CODE: 93 165 365 C										
DRAWING NO. 2-V-0000-05612										
CARD CODE U 01										
BODY (550mm-C900)										

CAUTION: The information on this drawing is the property of BHARAT HEAVY ELECTRICALS LTD. and should not be used directly or indirectly in any way detrimental to the interest of the company.