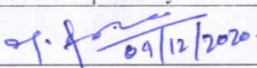
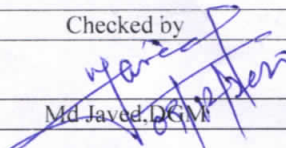
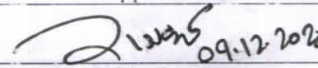


FINISH MACHINING OF RAM CASTING**i) PRE QUALIFICATION CRITERIA**

S.No.	BHEL Requirement	Vendor's Confirmation
1	Only those vendor should quote who have past experience of machining of similar jobs requiring milling, boring, drilling, & tapping operations	Vendor to Confirm and submit detail (including Drawing, copy of P.O. & Inspection/Acceptance report)
2	Vendor should have a CNC Horizontal borer/HMC/VMC/Gantry milling machine which can accommodate job of size 2540 x 1710 x 1655 mm and weight 22 MT	Vendor to Confirm and submit detail
3	Vendor should have material handling capacity of 22 MT or more	Vendor to Confirm and submit detail

ii) TECHNICAL REQUIREMENT

S.No.	BHEL Requirement	Vendor's Confirmation
* 1	Casting is to be machined to the dimensions, tolerances, accuracies and surface finish as per drawing 1-105-91-80100/M2 (Sheet 1 of 3)	Vendor to confirm
2	2 nos. Inclined holes to be drilled in the casting as per drawing 1-105-91-80100/M2 (Sheet 2 of 3). Reference picture IMG 01 attached.	Vendor to confirm
3	14 tapped holes of M48 on the bottom face and 4 keyways to be made by machining as per drawing 1-105-91-80100/M2 (Sheet 3 of 3)	Vendor to confirm
4	Liners along with bolts shall be provided to vendor. After finish machining of Ram casting, these Liners are required to be fixed onto the Ram casting as per Sheet 2 of 3 of drawing 1-105-91-80100/M2 and a skin cut is to be taken by vendor on top of liners to remove undulations and achieve flatness.	Vendor to confirm
5	Hydro test to be carried out at 6 atm. for holding time of 3 hrs. reference pictures IMG 02 attached. Hydro Test shall be witnessed by BHEL/BHEL's customer/TPI	Vendor to confirm
6	All machined surfaces to be suitably protected	Vendor to confirm
7	All threaded/unthreaded holes and keyways to be greased	Vendor to confirm
8	The finished casting to be packed in wooden box with proper protection of machined surfaces to avoid damage during loading, unloading and transportation. Suitable lifting arrangement to be made.	Vendor to confirm
9	Inspection of the machined job shall be carried out by BHEL/BHEL's customer at vendor's works before dispatch. Vendor to arrange for inspection with necessary instruments, gauges, etc.	Vendor to confirm
10	Identification details on the casting to be maintained	Vendor to confirm
11	Delivery Requirement :Nine(9) weeks from the date of lifting	Vendor to confirm
12	The material of casting is G28Mn6 of EN10293	Vendor to Note
* 13	Allowance of 5 to 7 mm will be available on tool point for carrying out finish machining	Vendor to Note
14	Weight of casting before finish machining will be 22 MT (approx.)	Vendor to Note
15	Weight of casting after finish machining will be 21.19 MT (approx.)	Vendor to Note
16	Vendor to submit Details of the Organization and Facilities available at their works	Vendor to submit
17	Vendor to submit Filled Supplier Registration Form along with Requisite Documents to SDC Cell in MM Deptt. of CFFP, BHEL, Haridwar, if already registered at any unit of BHEL, then Vendor code may be furnished. Vendor may plan a visit to CFFP, Haridwar	Vendor to submit & accept
18	BHEL team may visit vendor's works for facility/capacity verification.	Vendor to Accept

Prepared by	Checked by	Approved by
 Md. Asad, Dy. Manager	 Md. Javed, DGM	 R.K. Singh, SrDGM