

Pre-Qualifying Requirement (PQR) for Indent No: 20190201

SL.No	REQUIREMENT	REMARKS
1.	Only those vendors should quote who have following machine installed & operational at their works for following operations for Guide blade carrier-1 (Drg No: 01112158100):-	
A.	<u>Joint Plane milling, joint plane hole drilling/boring/threading & peripheral detail machining:-</u>	Vendor to confirm & Inform values. Vendor to submit the detail of attachment.
i.	<u>Horizontal Boring Machine with following specifications:-</u> (a) 'X' traverse : 2677mm or more (b) 'Y' traverse : 1000mm or more	
	OR	
ii.	<u>Gantry Milling Machine with following specifications & with suitable attachment:-</u> (a) Table Size: L= 3000mm or more, W= 1000mm or more (b) Milling height: 1500mm or more	
B.	<u>Turning Operation :-</u>	Vendor to confirm & Inform values.
i.	<u>CNC Vertical Boring Machine with following specifications:-</u> (a) Turning Dia : 2670mm or more (b) Swing dia : 2900mm or more (c) Ram Traverse : 900mm or more (d) Turning height : 1000mm or more (e) Weight capacity : 10 Ton or more	
C.	<u>Peripheral hole drilling:-</u>	
i.	<u>Horizontal Borer with rotary table with following specifications :-</u> (a) Rotary table with indexing accuracy : +/- 20' (20 minutes) or better (b) Weight capacity : 10 Ton or more (c) It should be possible to support dia 2391mm of GBC at 4 diagonal points or more on the table. Table drawing with its dimensions is to be submitted to verify compliance.	Vendor to confirm & Inform values.
	OR	
ii.	<u>CNC Horizontal Milling Machine or CNC Gantry Milling machine with universal programmable milling head with following specifications :-</u> (a) Indexing accuracy of milling head: +/- 20' (20 minutes) or better (b) Drilling Capacity: Dia 50mm or more	
	OR	
iii.	<u>Universal Radial Drilling Machine & rotary table with following specifications :-</u> (a) Rotary table with indexing accuracy : +/- 20' (20 minutes) or better (b) It should be possible to support dia 2391mm of GBC at 4 diagonal points or more on the table. Table drawing with its dimensions is to be submitted to verify the compliance. (c) Weight capacity of rotary table : 10 Ton or more (d) Drilling Capacity of drilling M/c: Dia 50mm or more	
2.	Vendor to confirm that above machines (A, B & C) installed at their works are in good working condition with capability of achieving accuracies (parallelity, cylindricity, perpendicularity, roundness etc.) & tolerances as per drawing. In support of this, vendor to submit at least one component details machined by vendor in past having same or finer accuracies.	Vendor to confirm & submit details.
3.	BHEL reserves the right to verify the information provided by vendor. BHEL may also visit vendor works if so desired by BHEL. In case the information provided by vendor is found to be false/ incorrect, their offer shall be rejected.	Vendor to note & agree.

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