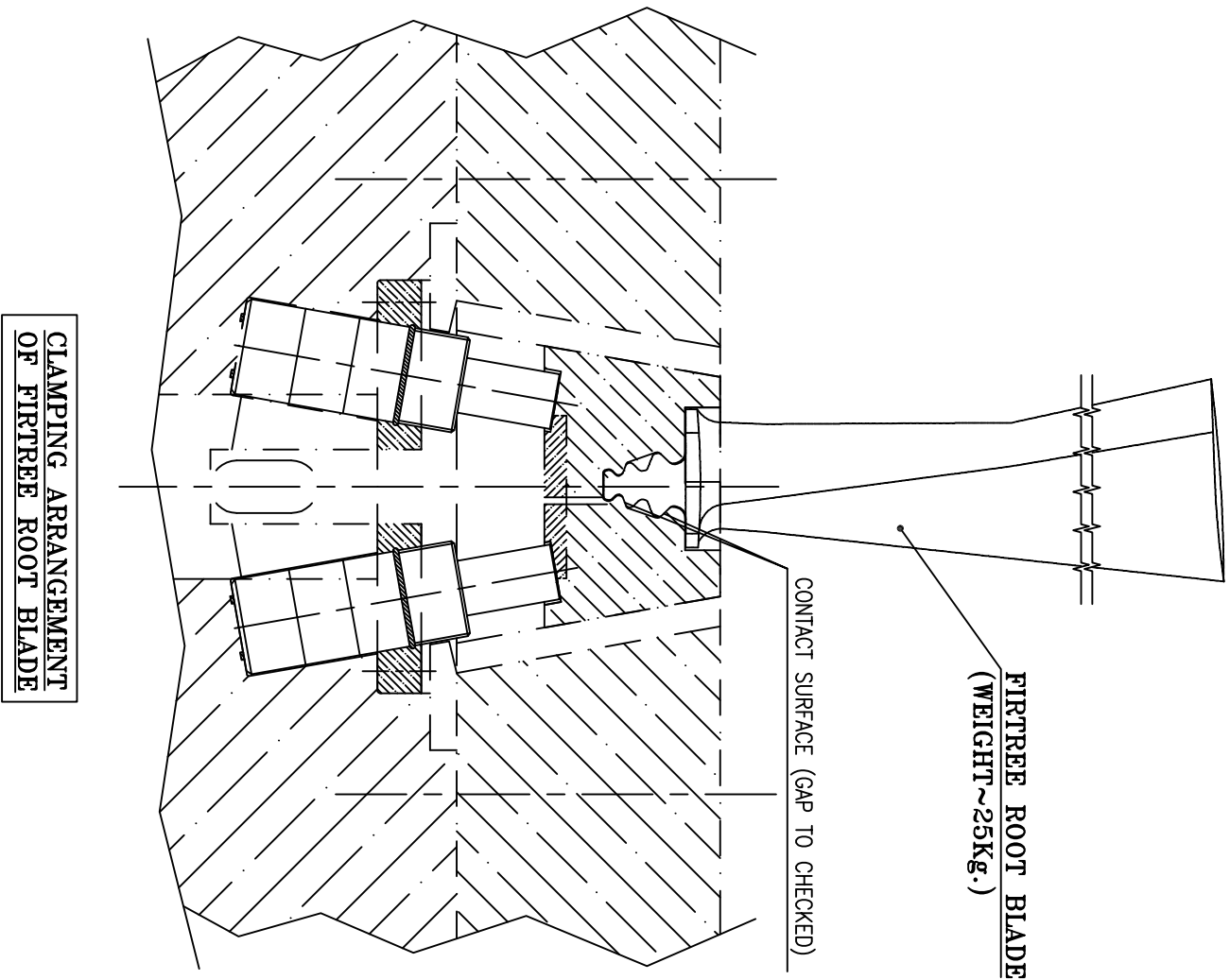
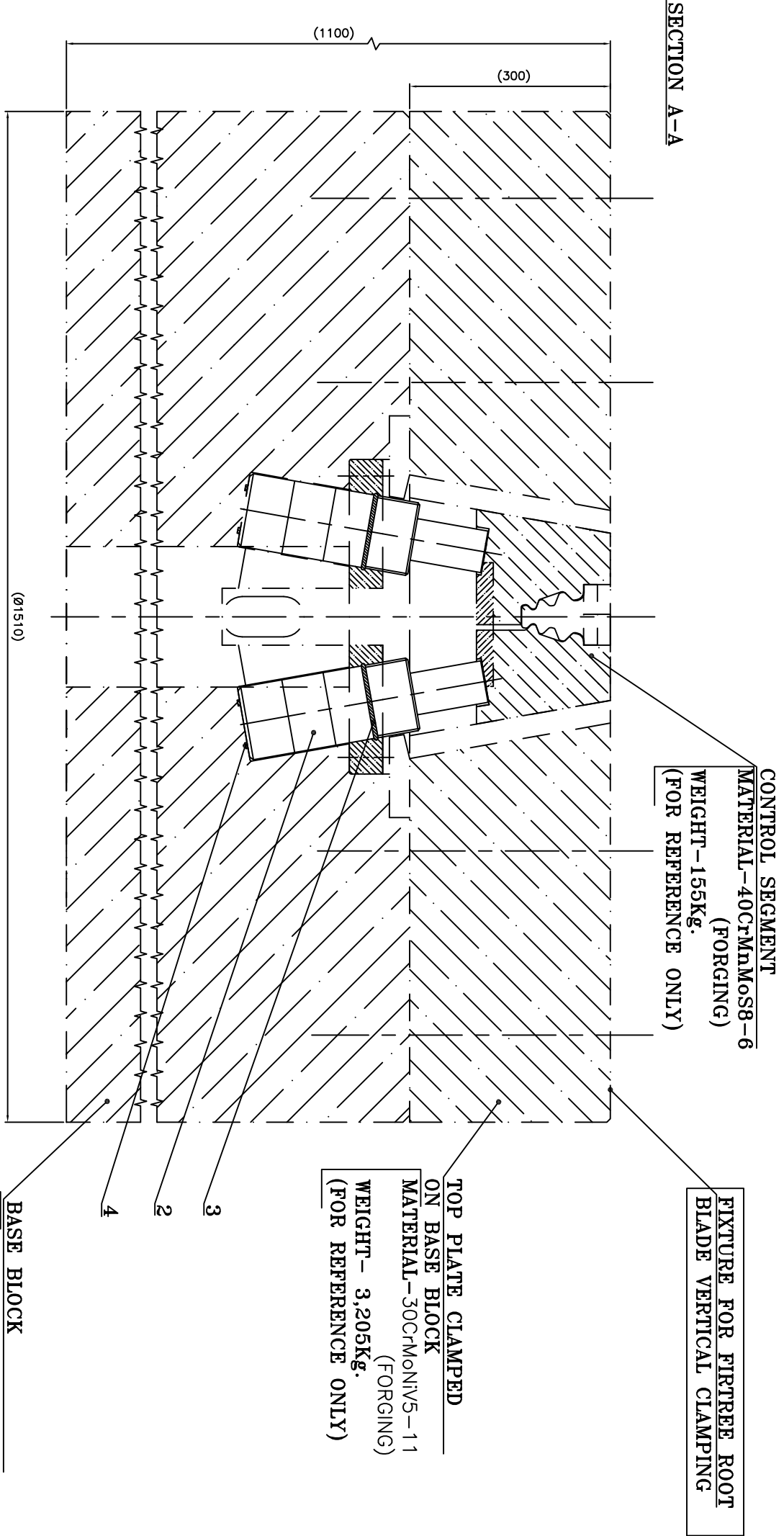




BASE BLOCK
MATERIAL-30CrMoNiV5-11
(FORGING)
WEIGHT- 10,530kg.
(FOR REFERENCE ONLY)

TOP PLATE CLAMPED
ON BASE BLOCK
MATERIAL-30CrMoNiV5-11
(FORGING)
WEIGHT- 3,205kg.
(FOR REFERENCE ONLY)

CONTROL SEGMENT
MATERIAL-40CrMoS8-6
(FORGING)
WEIGHT-155kg.
(FOR REFERENCE ONLY)

PICTURE FOR FIREFREE ROOT
BLADE VERTICAL CLAMPING

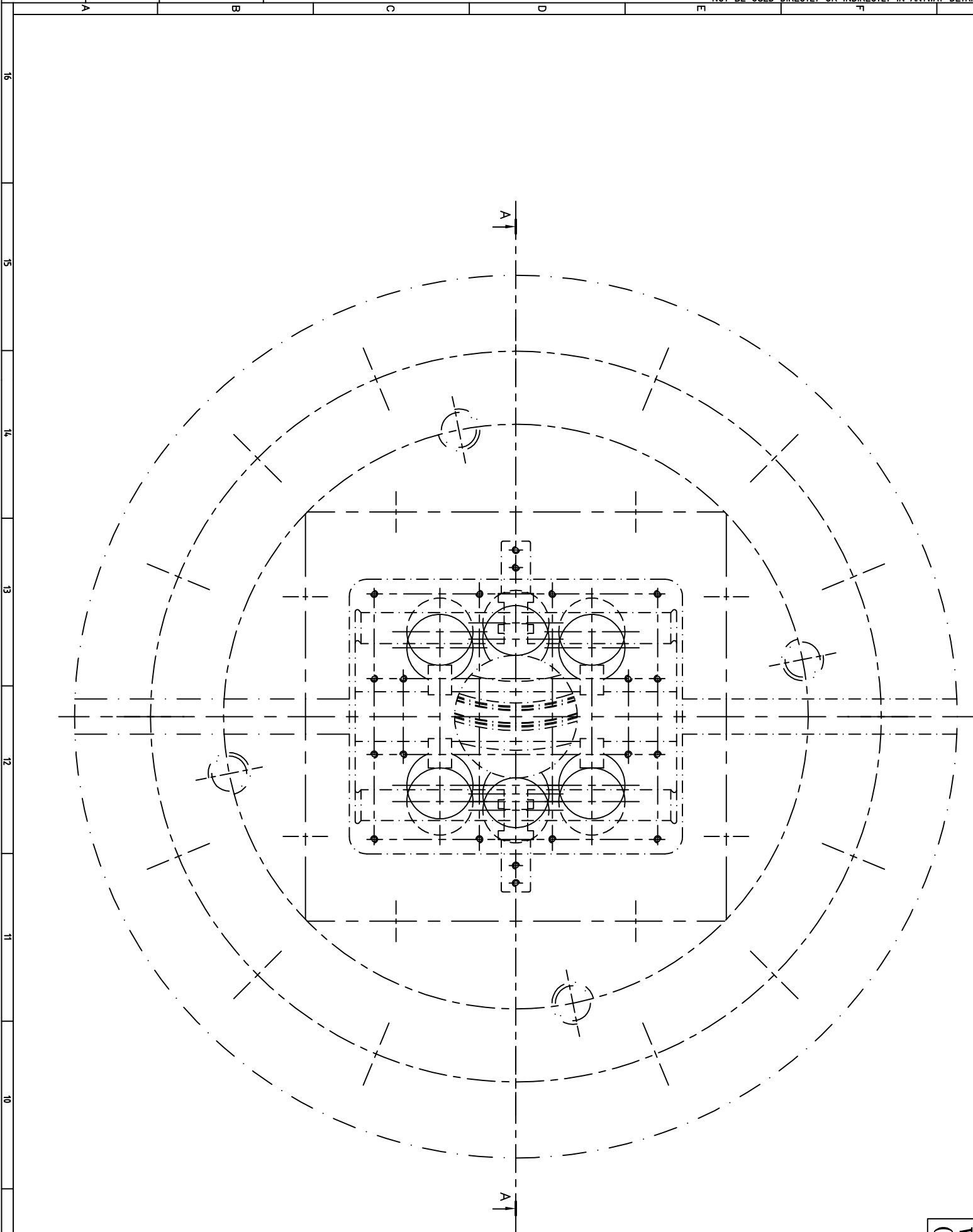
TECHNICAL REQUIREMENTS:-

- VENDOR HAS TO DEVELOP THE COMPLETE HYDRAULIC SYSTEM (ALL CYLINDERS, VALVES, PRESSURE GAUGE, ASPIRATOR, PUMP, MOTOR, POWERPACK WITH ALL PRELINES ETC) OF THE FIXTURE AS PER HYDRAULIC CIRCUIT DIAGRAM Dwg NO (F7871-1711/010). COMPLETE HYDRAULIC SYSTEM ARRANGED IN A BACK OR EQUIPMENT & KEPT AT SHOP FLOOR LEVEL.
- COMPLETE EQUIPMENT SHOULD HAVE ALL NECESSARY SAFETY FEATURES. DETAILS OF SAME SHOULD BE SUBMITTED WITH OFFER.
- VENDOR MUST SUBMIT LIST OF STANDARD/BOUGHT OUT PARTS THEIR SOURCE, CATALOGUE ETC ALONG WITH THE SYSTEM.
- VENDOR HAS TO INSTALL AND COMMISSION THE WHOLE HYDRAULIC SYSTEM IN THE FIXTURE AT BHEL HARDWARE. ALL FINISH MACHINED MECHANICAL FIXTURE PARTS SHALL BE PROVIDED BY BHEL. MECHANICAL ASSEMBLY SHALL BE DONE BY BHEL.
- PRE DISPATCH INSPECTION WILL BE DONE BY BHEL AT VENDOR WORKS (IF REQUIRED BY BHEL) AND FINAL ACCEPTANCE WILL BE GIVEN ONLY AFTER COMMISSIONING & PROVE OUT OF SYSTEM'S ASSEMBLY & FUNCTIONALITY BY VENDOR IN BHEL HARDWARE.
- VENDOR SHOULD PROVIDE A WARRANTY OF 2 YEARS ON WHOLE SYSTEM FOR ITS ESTABLISHED PERFORMANCE & FUNCTIONING.
- DURING COMMISSIONING TRAINING SHALL BE PROVIDED BY VENDOR TO BHEL PERSONNEL FOR HYDRAULIC OPERATION & MAINTENANCE.
- 3 SETS OF OPERATIONAL & MAINTENANCE MANUALS, HYDRAULIC CIRCUIT DIAGRAM AND ASSEMBLY, LIST/SOURCE/SPECIFICATIONS OF ALL BOUGHT OUT ITEMS, ETC SHALL BE PROVIDED BY VENDOR.
- A/MC FOR ONE YEAR, SUBSEQUENT TO WARRANTY PERIOD SHALL BE OFFERED BY VENDOR, HOWEVER BHEL MAY OR MAY NOT OPT FOR IT.
- VENDOR SHALL ALSO OFFER ALL TYPE OF SPARES/CONSUMABLES WITH LIST OF ITEMS & REQUIRED QUANTITY.
- HYDRAULIC & CLAMPING FORCE ON THE BLADE ROOT SHOULD NOT DEFORM OR DAMAGE ROOT OR DEVELOP ANY TYPE OF CRACKS IN BLADE.
- PROVEOUT OF SYSTEM, DURING COMMISSIONING BY VENDOR SHALL INCLUDE FOLLOWING:-
 - DEMONSTRATION OF STABILITY OF RIGID CLAMPING OF BLADE IN THE FIXTURE.
 - DEMONSTRATION OF COMPLETE FUNCTIONALITY & MAINTENANCE OF SYSTEM IN COMPLIANCE WITH DRAWING REQUIREMENTS
 - AFTER CLAMPING OF BLADE ,GAP TO BE CHECKED AT CONTACT PLANKS AS MARKED IN DRAWING WITH FILLER GAUGES
- CONSERVATION IS TO BE DONE AS PER TL 30007.

FUNCTIONAL REQUIREMENTS:-

- THE BLADE TO BE CLAMPED VERTICALLY IN CONTROL SEGMENT (TWO PARTS) SUCH THAT IT IS PUSHED FROM BOTTOM BY HYDRAULIC CYLINDERS IN SUCH A MANNER THAT CONTROL SEGMENT MOVES IN UPWARD DIRECTION ALONG THE TAPER AND FINALLY HOLD THE BLADE PERFECTLY AGAINST ITS CONTACT PLANKS (ONLY UPPER CONTACT PLANK & 2nd NON CONTACT PLANK OF FIREFREE ROOT PROFILE)
- MOVEMENT OF CONTROL SEGMENT IS GUIDED BY T-TYPE KEYS ALONG THE TAPER SURFACE AGAINST THE EXTERNAL VIBRATIONS
- AFTER CLAMPING OF BLADE THE WHOLE SYSTEM SHOULD WORK AS SINGLE UNIT
- COMPLETE SYSTEM SHOULD ENSURE THAT BLADE REMAINS IN VERTICAL POSITION WHILE CLAMPED & MAINTAINS REPEATABILITY
- VENDOR MUST DISCUSS WITH BHEL IF THERE IS ANY AMBIGUITY REGARDING THE SYSTEM & ITS FUNCTIONALITY.

INVENTORY No. SIGN.&DATE REF. DRG. No.



INTERNAL LOCATION WITHIN

JURY REGARDING THE SYSTEM &

GRADE OF UNTOOL Dwg. :-		M/Cs-E/M/T AMO230208		WELDING-K/B/E/B-40621104		GAS CUTTING-T39W4021101		REV DATE ALTERED		REV DATE CHECKED		REV DATE		REV DATE	
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VAR.00		REMARKS		ITEM NO		DESCRIPTION		DRAWING NO.		MATERIAL CODE		UNIT WT(Kg)		QTY	
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